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TECHNICAL DATA SHEET

SOLARITE EA- 0522

DESCRIPTION: Solarite EA- 0522 is a room temperature curing adhesive compound, whose convenient mixing ratio makes it easy to use and well suited to automatic dispensing equipment. Solarite EA- 0522 give a semi-rigid very high impact resistant epoxy used in the manufacture of striking tools with excellent adhesion to metals, composites and plastics.

SPECIFICATIONS—UNCURED:

	Part A	Part B
Color, Visual	Blue	Yellow
Mix Ratio—By Weight	100	60
Mix Ratio—By Volume	100	70
Viscosity, cps, ASTM-D-2393	8,000	6,000
Specific Gravity	1.11	0.97
Gel Time, 25°C, Hours	0.8-1.0	
Mixed Viscosity, cps, ASTM-D-1084	6,000	
Shelf Life, 25°C, Months	12	

SPECIFICATIONS—CURED:

PHYSICAL:

Durometer, ASTM-D-2240	80-85D
Compressive Strength, psi, ASTM-D-695	12,675
Tensile Strength, psi, ASTM-D-638	7,300
Tensile Elongation, Percentage, ASTM-D-638	5.0
Service Temperature, °C	105

USE INSTRUCTIONS:

1. Pre-mix contents of each container before use to ensure the entire contents are uniform. Some settling may occur upon prolonged storage which is soft and easily incorporated.
2. Measure out equal components of the product by volume and mix thoroughly together to incorporate any settled material.
3. De- air if necessary at 760 mm of Hg for 5-10 minutes.
4. Pour into cavity to be encapsulated.

CURE SCHEDULE:

Initial cure is achieved in 16-24 hours at room temperature. Final cure takes at least 7-10 days at 72F. To accelerate the cure higher temperatures can be used, 2-4 hours at 150 F is usually sufficient , after allowing the product to gel at room temperature for 3 hours.

STORAGE REQUIREMENTS:

This product has a slight tendency to settle upon storage and shipment, material should be mixed well prior to use. Store in a cool dry place.

IMPORTANT:

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HEALTH CAUTION:

Avoid breathing possible fumes, mists and vapors, which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clear water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keEA away from open flame or ignition source.

PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION.

FOR CHEMICAL EMERGENCY
CALL CHEMTREC (DAY OR NIGHT) 800-424-9300.

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