



CPD General Purpose Adhesive Cartridge Information

Each kit contains one 15.2 oz. (450 mL) cartridge set of adhesive, a lock nut and a static mixing wand. The cartridge kits are designed to be used with a Cox PPM-300X manual dispensing gun, a Cox PPA-300B pneumatic dispensing gun or their equivalent.

Assembly:

1. Each kit contains a 300 mL resin cartridge and a 150 mL hardener cartridge. Place the rear of the cartridge set into the saddle of the dispensing gun and push the back against the spring-loaded center locator while dropping the front of the cartridge into the slot at the front of the gun. Adjust the plunger on the gun to contact the back of the plunger seals inside the cartridge barrels, making sure that the plungers are in the center of the seals of the cartridge.
2. Remove the protective cover and the two plugs from the spouts. Place the static mixing wand onto the spouts and affix it to the cartridges with the locknut included in the kit. Cut the tip of the static mixing wand for the appropriate size bead. The stated work life and gel time is based on a 1/2" bead. See "Property Information" below for additional hints on work life and gel time. Squeeze the trigger to start the flow of adhesive through the static mixing wand.

Coverage:

One cartridge contains 15.2 oz. Of material or 27.4 cubic inches. The following guide can be used to calculate usage.

<u>Mixing Wand Opening (Diameter)</u>	<u>Yield of Bead</u>
1/4"	46.6'
3/8"	20.7'
1/2"	11.7'

The yield will vary with operator experience. Smaller and larger beads and surface sizes can be calculated accordingly. Gap filling requirements may reduce surface yield. Spreading the material with a notched spreader will yield approximately seven square feet with a 1/8" x 1/8" spreader.

Surface Preparation:

All surfaces should be clean and free of contaminants. Additional recommendations are as follows.

- Aluminum: Chemical Etch and/or Conversion Coating
- Other Metals: Solvent Wash Followed By Sand Blasting and/or Metal Grinding To Abrade the Surface
- Stone: Sand Blasting and/or Metal Grinding
- FRP: Sand (36 grit or 80 grit) and Remove Dust or Use Peel Ply*
- Wood: Sand (80 grit) and Remove Dust

*Note: The use of peel ply may make additional preparation necessary in order to ensure adequate bonding where laminate "contaminants" from the composite structure have migrated to the surface.

(See Reverse)



Epoxy Adhesives

	Fast	Slow	
System	2175A/4373B	2175A/4375B	Test Method
HANDLING PROPERTIES			
Mix Ratio By Volume	2A : 1B	2A : 1B	
Mix Ratio By Weight	100A : 47B	100A : 46B	
Pot Life at 25°C (77°F), 100g	10 minutes	30 minutes	
Work Life at 25°C, 1/2" Bead	20 minutes	75 minutes	
Minimum Cure Temperature	>60°F	60°F	
PHYSICAL PROPERTIES			
Tensile Strength	6,300 psi	7,300 psi	ASTM D-638
Tensile Elongation	4.2 %	4.2 %	ASTM D-638
Tensile Modulus	384,000 psi	423,000 psi	ASTM D-638
Flexural Modulus	371,000 psi	411,000 psi	ASTM D-790
Heat Deflection Temperature	115°F	122°F	ASTM D-648
L A P Shear (G10 Laminate)	2,160 psi	2,280 psi	ASTM D-3165
Shrinkage	<0.001 in./in.	<0.001 in./in.	ASTM D-2566
Izod Impact, Notched	0.96 ft.-lb./in.	1.16 ft.-lb./in.	ASTM D-256
Hardness	82 Shore D	82 Shore D	ASTM D-2240
Availability:			
Drums, Pails and Dispensing Cartridges			

Please see the individual CPD technical data bulletins and material safety data sheets for further information on a specific adhesive system.

Property Information:

Epoxy adhesives have handling properties that are expressed with regard to a specific size bead at a specific temperature. This mass/temperature measurement is meant as a guide. The larger the mass (or bead), the faster the material will gel. The smaller the mass, the slower the material will gel. The work life and gel time values published on all Composite Polymer Design technical data bulletins were measured at 77 °F (25°C), unless otherwise indicated. At temperatures greater than 77°F, the gel time/work life of the adhesive will be curtailed and at temperatures less than 77°F, the gel time/work life of the adhesive will be prolonged. The ambient temperature of a shop and the size of bead being applied should be taken into account when determining the work life and/or gel time of the adhesive. Be certain that the adhesive has been allowed to cure thoroughly before stressing the bond.

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(See Reverse)