

Epibond[®] 1217 A/B Epoxy Adhesive

Product Description

Epibond[®] 1217 A/B epoxy adhesive is a two-part, translucent white paste that cures quickly at 77°F (25°C). It is recommended for bonding steel, aluminum, wood, ceramics and a variety of polymeric substrates.

Features

- Quick set adhesive
- Room temperature cure
- One to one mix ratio

Typical Properties*

| Property | Test Method | 1217 A Resin | 1217 B Hardener | Mixed System |
|-----------------------------------|-------------|--------------|-----------------|--------------|
| Appearance | Visual | Translucent | Amber | Translucent |
| Density @ 25°C, g/cm ³ | ASTM D792 | 1.20 | 1.18 | 1.19 |
| Viscosity @ 25°C, cP | ASTM D2393 | Paste | 90,000 | Paste |

*Properties are based on Huntsman test methods. Copies are available upon request.

Processing

Mix Ratio

| Product | Parts by weight | Parts by volume |
|--------------------------------------|-----------------|-----------------|
| Epibond [®] 1217 A Resin | 100 | 1 |
| Epibond [®] 1217 B Hardener | 100 | 1 |

Mix only that quantity which can be applied immediately after mixing. Due to the very fast setting properties of Epibond[®] 1217 A/B, hand mixing of the components should preferably be avoided. Epibond[®] 1217 A/B is available in 50 mL twin cartridges. For best results, Epibond[®] 1217 A/B should be dispensed using manual or pneumatic dispensing equipment through a 0.25 in diameter, 20 element static mixing nozzle (Nordson EFD #7701488), or equivalent. Material temperatures should be above 18°C (65°F) when mixing.

Processing Data

| Parameter | Value |
|------------------------|---------------------|
| Gel time, 50 g at 25°C | 4 – 8 minutes |
| Typical cure cycle | 1 - 2 hours at 25°C |

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

| Property | Test Method | Value |
|--|-------------|--|
| Tensile lap shear, Al-Al, psi (MPa) at -67°F (-55°C) at 77°F (25°C) at 181°F (83°C) | ASTM D1002 | 1,350 (9.3) 2,500 (17.2) 500 (3.4) |

Storage

Epibond® 1217 A/B should be stored in a dry place in the original sealed containers at temperatures between 2°C and 40°C (36°F and 104°F). After use, tightly reseal containers. Under these storage conditions, and when supplied under Huntsman standard certification, the product has a shelf life of **1 year** (from date of manufacture). The product should not be exposed to direct sunlight.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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