



ADHESIVE PASTE

DESCRIPTION AND USES

EPOXYBOND ADHESIVE PASTE is a two-part, thin film epoxy adhesive of paste consistency that spreads easily and develops an excellent bond to most surfaces. It's formulated for easy mixing using equal amounts of Resin and Hardener. EPOXYBOND ADHESIVE PASTE will adhere metals, glass, ceramics and plastics to themselves or any combination of materials. It is suitable for bonding a wide range of items such as tubing, instruments, fixtures and porcelain chips. High physical strengths permit repairs and maintenance that are long-lived. EPOXYBOND ADHESIVE PASTE is solvent free and has very little shrinkage. It is ideal for filling hairline cracks and resetting tile and fixtures. EPOXYBOND ADHESIVE PASTE can be worked as easily as wood after it sets. Paint can be applied after light sanding.

PACKAGING – EPOXYBOND ADHESIVE PASTE

18 x 16 oz. (454 g.) sleeved sets / carton; each sleeved set contains:

One - 8 oz. (227 g.) can Resin

One - 8 oz. (227 g.) can Hardener

2-Quart (6 lb. 4 oz. [2.8 kg.]) unit containing:

One - 3 lb. 2 oz. (1.4 kg.) can Resin

One - 3 lb. 2 oz. (1.4 kg.) can Hardener

2-Gallon (25 lb. [11.3 kg.]) unit containing:

One - 12 lb. 8 oz. (5.7 kg.) can Resin

One - 12 lb. 8 oz. (5.7 kg.) can Hardener

10-Gallon (125 lb. [56.7 kg.]) unit containing:

One - 62 lb. 8 oz. (28.4 kg.) pail Resin

One - 62 lb. 8 oz. (28.4 kg.) pail Hardener

MIXING AND APPLICATION

1. Clean and dry area to be repaired. Thoroughly remove all grease, loose particles, rust. Slightly roughen surface with wire brush or sandpaper.
2. Remove equal amounts of Resin and Hardener from tubes, cans or pails.
3. Mix Resin and Hardener with clean tool until uniformly white.
4. Spread thin film evenly over surface, removing excess.
5. Use tape where necessary to hold repair in position until paste hardens.

PHYSICAL PROPERTIES

PROPERTY	TYPICAL VALUE
Compressive Strength	10,000 psi. (68.9 MPa)
Bond Strength	1,100 psi. (7.58 MPa)
Modulus of Rupture	4,200 psi. (29.0 MPa)
Maximum Use Temperature, Continuous	125°F (52°C)
Tensile Strength	2,700 psi. (18.6 MPa)
Coefficient of Thermal Exp., 60°F–140°F, in./in./°F (cm./cm./°C)	4.85 x 10 ⁻⁵ (2.7 x 10 ⁻⁵)
Color	White

TYPICAL SETTING TIME

The setting of EPOXYBOND PASTE results from an exothermic reaction. Warmer temperatures will shorten the working life and accelerate the cure.

TEMPERATURE*	WORKING LIFE (100 g.)	INITIAL SETTING TIME (1/16" thick)
60°F (16°C)	40 min.	3 to 3-1/2 hr.
70°F (21°C)	30 min.	2-1/2 to 3 hr.
80°F (27°C)	20 min.	1-1/2 to 1-3/4 hr.
90°F (32°C)	15 min.	1-1/4 to 1-1/2 hr.
100°F (38°C)	10 min.	50 to 60 min.

*Temperatures below 60°F (16°C) will slow down curing mechanism. Not recommended.

CLEANING

A nylon scrub pad, soap and warm water will remove the material from mixing tools if cleaning is done immediately after use. Solvents, such as lacquer thinner, paint thinner or alcohol, will have to be used after material has begun to harden.

DISPOSAL

Dispose of residues and wastes in accordance with the directions in the Material Safety Data Sheets and government regulations.

STORAGE AND SHELF LIFE

Store all materials in a cool, dry environment. Keep all materials out of direct sunlight. Ideal storage temperature is 75°F (24°C). Protect from freezing. In unopened original containers, the materials referred to in this Data Sheet have a shelf life of approximately one year.

PRECAUTIONS

The materials referred to in this Data Sheet present handling and potential health hazards. Consult Material

Safety Data Sheets and the container labels for complete precautionary information.

TECHNICAL SERVICES

ATLAS maintains a staff of Technical Service Representatives who are available to assist you with the use of ATLAS products. In the event of difficulties with the application of ATLAS materials, the installation should be stopped immediately and ATLAS' Technical Service Department consulted for assistance.

WARRANTY

ATLAS warrants that its products will be free from defects in workmanship and materials under normal use for a period of one (1) year from the date of shipment by ATLAS (provided the products are installed before the expiration of the shelf life). THERE ARE NO EXPRESS OR IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR THE PURPOSE FOR THIS PRODUCT WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF. ATLAS' LIABILITY FOR ALLEGED BREACH OF THIS WARRANTY SHALL BE LIMITED TO REPAIR OR REPLACEMENT OF THE DEFECTIVE PRODUCT (BUT NOT INCLUDING REMOVAL OF THE DEFECTIVE PRODUCT OR INSTALLATION OF REPLACEMENT PRODUCTS). ATLAS SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES DURING THE WARRANTY PERIOD OR THEREAFTER. **ATLAS' WARRANTY IS VOIDED IF PAYMENT FOR PRODUCT IS NOT RECEIVED IN FULL.**