

## 1101 Epoxy Paste Adhesive



**Overview:** High strength structural adhesive used to bond and assemble sub-components to form rigid final structures. The high viscosity provides excellent gap filling characteristics that strengthen loose fitting joints and panel.

#1101 forms tough durable bonds to composites, SMC, many metals, and even common construction materials. It is easy to use with its 1:1 mix ratio, and 6-8 hour cure time at 77°F

Available in quart resin/hardener kits or cases of quart resin/hardener kits.

### Features & Benefits:

- #1101 provides excellent adhesion to a wide variety of materials such as aluminum, steel, brass, concrete, brick, glass, stone, ceramics, tile and wood.
- The mix ratio of 1:1 by weight or volume allows easy measuring.
- It is very easy to mix, and has good thixotropy for application to contoured or vertical surfaces without sag or run-off.
- #1101 cures relatively quickly, developing sufficient green strength to allow bonded items to be removed from the holding fixtures and handled within a few hours.
- The cured material has excellent strength as well as good resistance to weak acids, moisture and weather

### Typical Cure Schedule:

	#1101	Test Method
Mixed Viscosity	Smooth Paste	ASTM D2393
Mix Ratio	100:100 By Weight or Volume	
Pot Life at 77°F	20-30 Min	
Gel Time, 1 lb. mass	20-30 Min	ASTM D2741
Cure Time at 77°F	6-8 Hrs	
Cure Time at 140°F	45-60 Min	
Handling Strength	3-4 Hrs	

The material to be bonded may be preheated to accelerate curing time, or very light heat can be applied after the parts have been bonded

### Typical Product Properties:

	#1101 (A Side)	#1101 (B Side)	Test Method
Color	White	Grayish tan	Visual
Viscosity	Paste	Paste	ASTM D2393
Specific Gravity	1.54	1.49	ASTM D1475
Density lb./cu.in.	0.0556	0.0538	ASTM D792

**Typical Mechanical Properties:**

	<b>#1101</b>	<b>Test Method</b>
Specific Gravity	1.51	ASTM D1475
Hardness, Shore D	90D	ASTM D2240
Tensile Strength, Cast Bar	7,200 psi	ASTM D638
Compressive Strength	14,300 psi	ASTM D695
Volumetric Wt. Ratio, cu.in./lb.	18.3	ASTM D792
Water Absorption	<.2%	ASTM D570
Al to Al Tensile Lap Shear Strength, psi	3,480 psi	ASTM D1002
Tensile Elongation	6%	ASTM D412

**Mixing Directions:** Mixing is easy! Using clean plastic or paper containers, measure out equal parts of side A & B by weight or volume. Mix thoroughly for at least one minute or until a uniform color and consistency is achieved. Make sure to scrape the edges and the bottom of the container to avoid leaving unmixed material which can lead to soft spots in the cured adhesive joint.

**Surface Preparation and Application:** All surfaces to be bonded or patched must be free of dirt, oil, and grease. Sanding or roughening the bonding surfaces increases the surface area and enhances the bond strength.

Use a plastic or rubber squeegee to spread the mixed filler onto the low or porous surface. An alternative method is to fill a plastic pastry cone with adhesive and squeegee the material out the tip like icing a cake. For best wetting of the bonding surfaces, apply adhesive to both sides of the joint within 20 minutes of mixing the material. Clamp the joint until the handling strength is developed.

**Safety and Handling:** #1101 Epoxy Paste Adhesive contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating, drinking, or using toilet facilities. Individuals should observe conditions of good industrial hygiene and safe working practice. For more detailed instructions on handling, please see the MSDS sheet.

All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures. For more detailed instructions on storage, please see the MSDS sheet.