

Leepoxy Plastics, Inc.

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TECHNICAL BULLETIN LEEBOND E11130-1

Description

LEEBOND E11130-1 is a one-part, room temperature stable epoxy structural adhesive. It combines fast cures at room temperature above 250°F with long room temperature shelf life. LEEBOND E11130-1 provides a strong bond to clean metals, ceramics and some plastics.

| TYPICAL PROPERTIES | |
|--|--------------------|
| Appearance | Gray non-sag paste |
| Solids Content, % | 100 |
| Filler | Inorganic |
| Density, lbs./gal. | 10.0 |
| Shelf life @ 77°F, 5-gallon mass, months | 3 |

Directions for Use

Apply LEEBOND E11130-1 to the substrate surface. The method of application is not critical and can include knife, spatula, trowel or caulk tube. The quantity of adhesive should be selected to give a bondline thickness of 2-8 mils. Join the adhesive-coated surfaces using sufficient contact pressure to prevent the parts from moving during cure.

| TYPICAL CURE SCHEDULES | |
|------------------------|----------------|
| Bondline Temperature | Time (minutes) |
| 225°F | 60 |
| 250°F | 40 |
| 300°F | 20 |
| 350°F | 7 |
| 400°F | 2 |

Cure is generally sufficient when the adhesive is hard to the touch. Actual time and temperature should be adjusted to give the optimal cycle for the particular application.

| TYPICAL PERFORMANCE | |
|-------------------------------------|---------------------|
| Temperature | Tensile Shear (psi) |
| -67°F | 2600 |
| 77°F | 3800 |
| 150°F | 3600 |
| 200°F | 3200 |
| 300°F | 390 |
| Tensile Strength, cold-rolled steel | 3700 |
| T-Peel Strength @ 77°F, lb/inch | 9.0 |

Suggested maximum continuous operating temperature is 250°F. Resistance to chemicals other than strong mineral acids is excellent

Storage and Handling

LEEBOND E11130-1 can be stored for 3 months in 5-gallon pails at normal room temperatures below 77°F. Storage at higher temperatures and/or in larger masses will cause an increase in viscosity; storage at 40°F or lower will increase shelf life significantly. Keep containers closed when not in use to prevent contamination.

The Information contained herein is correct to the best of our knowledge. The recommendations or suggestions contained in this bulletin are made without guarantee or representation as to results. We suggest that you evaluate these recommendations and suggestions in your own laboratory prior to use. Our responsibility for claims arising from breach of warranty, negligence or otherwise is limited to the purchase price of the material. Freedom to use any patent owned by Leepoxy Plastics, Inc. or others is not to be inferred from any statement contained herein.

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