

**AXIS™ 84211**
**GENERAL PURPOSE EPOXY ADHESIVE**
**TECHNICAL DATA**
**APRIL 2017**
**Product Description**

A medium viscosity, unfilled epoxy resin system specifically developed for adhesive and coating applications in accordance with Title 21. U.S. Code of Federal Regulations, Food and Drug Administration (FDA) Chapter 1, Sub Part B, Sections 175, 105 and 175,300. This two part adhesive is easily mixed and develops tough strong bonds to a wide variety of materials. This product is an effective electrical insulator and provides low permeability to gases and vapors and good resistance to water, weather, galvanic actions, to petroleum solvents, lubricants and fuels, to mild acids and alkalis and to many other organic and inorganic compounds.

**APPLICATIONS**

- Medical
- Automotive
- Electronic

**FEATURES**

- RoHS & REACH Compliant
- FDA Compliant
- USP Class VI compliant

**SUBSTRATES**

- Metal
- Rubber
- Phenolic
- Glass

**PACKAGING**

- Dual Cartridges
- Bulk

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Property	Value, Part A	Value, Part B
Chemical Class	Epoxy	Amine
Appearance	Clear	Amber
Viscosity, 10 RPM, cps	10,000 to 14,000	12,000 to 16,000
Viscosity, 100 RPM, cps	10,000 to 14,000	12,000 to 16,000
Specific Gravity	1.16	0.98
Option 1: Mix Ratio by Volume	2	1
Option 2: Mix Ratio by Volume	1	1
Option 3: Mix Ratio by Volume	1	2

**TYPICAL PROPERTIES OF CURED MATERIAL**

Property	Value
Glass Transition Temperature (T <sub>g</sub> ), °C	60
Lap Shear Strength, Al/Al, PSI	>2,500
Hardness, Option 1, Shore	D80
Hardness, Option 2, Shore	D72
Hardness, Option 3, Shore	D64
Ultimate Tensile Strength, PSI	>7,000
Elongation at Break, %	10
Operating Temperature (°C)	-40 to 155
Volume Resistivity, Ω-cm	1 x 10 <sup>11</sup>

**\*All properties given are typical values and are not intended for use in preparing specifications.**

**CURE OVERVIEW**

Pot Life (15cc mass), Min	60
Cure Options: Hr @ 25°C	12 to 24
Cure Options: Hr @ 70°C	2
Cure Options: Hr @ 100°C	1
Clean-Up Solvent	Isopropyl Alcohol

**SHELF LIFE, STORAGE**

18 ± 10°C Bulk: 1 Year DOM; Packaged: 6 Months DOM

CONSULT SDS FOR SAFE HANDLING RECOMMENDATIONS.

**THIS MATERIAL IS SOLD FOR INDUSTRIAL USE ONLY**

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