

Axis M-20HP

Technical Data Sheet

Axis M-20HP is a medium viscosity adhesive with a two to one mix ratio by volume. Once cured, Axis M-20HP forms an off-white bond line with excellent peel resistance. It is resistant to a range of chemicals and solvents and is an excellent electrical insulator. Axis M-20HP can be used in the assembly of disposable medical materials.

APPLICATIONS	FEATURES	SUBSTRATES
General Medical	Biocompatible per ISO 10993-5 - pending	Various Plastics and Metals
Bonds to dissimilar materials	Rigid Bond	
	Room Temperature Cure	
	Thermal Shock Resistant	

Typical Properties of Uncured Material*

Chemical Class	Epoxy : Amine
Color (Part A / Part B)	Off-white : Amber
Viscosity, Part A @25°C, Spn7@20RPM, cps	110,000 – 150,000
Viscosity, Part B @25°C, Spn6 @20RPM, cps	11,000 – 16,000
Specific Gravity Part A	1.16
Specific Gravity Part B	1.13
Mix Ratio, PBV (A:B)	2 : 1
Cleanup Solvent	Isopropyl alcohol

Cure Guidelines*

Work Life of 100 grams @ RT, minutes	15
Gel Time of 100 grams @ RT, minutes	20
Cure Time @ RT, hours	24
Cure Time at 65°C, hours	2

Typical Properties of Cured Material*

Durometer, Shore D	77
Elongation, %	<10%
Tensile Strength, MPa, [psi]	39 [5,700]
Lap Shear Strength, Al / Al, psi	2,000
Lap Shear Strength, PCB / PCB, psi	160

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

Storage

Keep stored between 8°C and 28°C in tightly sealed containers away from direct sunlight. Keep from freezing. Please refer to product labeling for shelf life information. Consult SDS for safe handling recommendations.

RESIN DESIGNS MAKES NO EXPRESSED OR IMPLIED REPRESENTATIONS OR WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR OTHERWISE, WITH RESPECT TO THIS PRODUCT AND GUARANTEES NO PARTICULAR OUTCOME OR RESULT FROM ITS USE. RESIN DESIGNS' LIABILITY TO CUSTOMER WITH RESPECT TO THIS PRODUCT SHALL IN NO EVENT EXCEED THE AMOUNT PAID BY CUSTOMER FOR IT. APPLICATION OF THIS MATERIAL SHOULD COMPLY WITH LOCAL AND NATIONAL HEALTH AND SAFETY REGULATIONS.