

Axis M-30CL

Technical Data Sheet

Axis M-30CL is a low viscosity, medical grade industrial adhesive. This two-part epoxy cures at room temperature providing high strength bonds to a wide variety of substrates. Once cured it is resistant to an extensive range of chemicals and is stable over a wide temperature range. This product is in full compliance with the RoHS directives 2002/95/EC and 2003/11EC.

APPLICATIONS	FEATURES	SUBSTRATES
General Medical	Biocompatible per ISO 10993-5 - Pending	Various Plastics and Metals
Bonding	Viscosity	
Laminating	Clear	
Small potting		
Staking		

Typical Properties of Uncured Material*

Chemical Class	Epoxy : Amine
Color (Part A / Part B)	Clear : Amber
Viscosity, Part A @25°C, Spn7 @20RPM, cps	11,000 – 15,000
Viscosity, Part B @25°C, Spn5 @20RPM, cps	1,900 – 2,400
Specific Gravity Part A	1.16
Specific Gravity Part B	1.09
Mix Ratio, PBV (A:B)	2 : 1
Cleanup Solvent	Isopropyl alcohol

Cure Guidelines*

Work Life of 100 grams @ RT, minutes	35
Gel Time of 100 grams @ RT, minutes	60
Cure Time @ RT, hours	24

Typical Properties of Cured Material*

Durometer, Shore D	75
Elongation, %	<10%
Tensile Strength, MPa, [psi]	48 [7,000]
Lap Shear Strength, Al / Al, psi	625

***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.

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