

## 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. Axis M-20HP complies with the Limit of Volatile Organic Compounds content in adhesives (GB 33372-2020) National Standard of the People's Republic of China.

APPLICATIONS	FEATURES	SUBSTRATES
<ul style="list-style-type: none"> <li>General Medical</li> </ul>	<ul style="list-style-type: none"> <li>Biocompatible per ISO 10993-5</li> </ul>	<ul style="list-style-type: none"> <li>Various Plastics and Metals</li> </ul>
<ul style="list-style-type: none"> <li>Bonds to Dissimilar Materials</li> </ul>	<ul style="list-style-type: none"> <li>Rigid Bond</li> </ul>	
	<ul style="list-style-type: none"> <li>Room Temperature Cure</li> </ul>	
	<ul style="list-style-type: none"> <li>Thermal Shock Resistant</li> </ul>	

#### 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 @ 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.**

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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