



TECHNICAL INFORMATION

Provisional

EPOWELD® 20327 Epoxy Adhesive System

PRODUCT DESCRIPTION

EPOWELD 20327 is a two-part, room temperature cure epoxy adhesive. It has a quick gel time and displays very high cohesive strength. It also exhibits excellent impact and vibration resistance. This system is effective over an operating temperature range of -34 °C to 71 °C (-30 °F to 160 °F), and is recommended for bonding a wide variety of similar and dissimilar materials, including metal to metal, metal to wood, and metal and wood to many plastics.

HOW TO USE

Stir parts A & B separately in their original containers. Weigh out the correct proportions of parts A & B. Mix thoroughly.

MIXING AND CURING SCHEDULE

<u>Ratio</u>	<u>Part A</u>	<u>Part B</u>
Parts by weight	100	72
Parts by volume	100	100

The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties. The recommended schedule to achieve the typical properties is shown below:

7 days @ 25°C (77 °F) or 2 hours @ 60 °C (140 °F)

TYPICAL UNCURED PROPERTIES

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Black	Amber	Black
Viscosity @ 25 °C, cps	6,500	30,000	17,000
Weight per Gallon, lbs.	11.7	8.1	9.9
Specific Gravity @ 25 °C	1.40	0.97	1.19
Gel Time, 200gm mass @ 25 °C (77 °F), minutes	----	----	40
Filler Type	Non- Abrasive	Non- Abrasive	Non- Abrasive
Shelf Life (in separate sealed containers), months	12	12	----

TYPICAL CURED PROPERTIES

(Tested at 25 °C unless otherwise indicated)

<u>Test</u>	<u>Result</u>
Hardness, Shore D	83
Lap Shear, psi 7 days @ 25 °C	4,400
Tensile Strength, psi 7 days @ 25 °C	7150

STORAGE AND HANDLING

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60 °F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products.

A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes. For more information on proper recommendations and procedures, contact the Technical Department.

SAFETY

These materials are intended for industrial use only and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, nevertheless, care should be taken in handling. Adequate ventilation of work place and ovens is essential.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheets for additional information.

ADDITIONAL INFORMATION

Visit our web site at:

www.royaladhesives.com

Contact us at:

Royal Adhesives and Sealants, LLC
600 Cortlandt Street
Belleville, NJ 07109-3384
(888) 442-7362 Toll-free
(973) 751-3000 Phone
(973) 751-8407 Fax

NOTE

The information herein is currently believed to be accurate. We do not guarantee its accuracy. Purchasers shall not rely on statements herein when purchasing any products. Purchasers should make their own investigations to determine if such products are suitable for a particular use. The products discussed are sold without warranty, express or implied, including a warranty of merchantability and fitness for use. Purchasers will be subject to a separate agreement, which will not incorporate this document.