



TECHNICAL INFORMATION

EPOWELD® 3645A/3655B Epoxy Adhesive System

PRODUCT DESCRIPTION

EPOWELD 3645A/3655B is a room temperature cured, two-component epoxy compound designed for all general purpose adhesive and casting applications. It is recommended for bonding striking tools such as hammers, axes and sledge hammers.

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>
By weight	100	100
By volume	100	116

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 at 25 °C (77 °F)

TYPICAL UNCURED PROPERTIES

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Amber	Dk Amber	Amber
Viscosity @ 25 °C, cps	600	40,000	6,000
Weight per Gallon, lbs	9.5	8.1	8.8
Specific Gravity @ 25 °C	1.14	0.97	1.06
Gel Time, minutes			
100 gm mass	---	---	90
Gel Time, minutes			
½ gal mass	---	---	60
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>
Hardnes, Shore K	82
Tensile Strength, psi	7,000
Lap Shear Strength, Al/Al, psi	4,000
Heat Distortion Temperature	55 °C

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 Sheet for additional information.

ADDITIONAL INFORMATION

Visit our web site at:

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NOTE

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