



TECHNICAL INFORMATION

EPOWELD® 7895A/7776B General Purpose Epoxy Adhesive System

PRODUCT DESCRIPTION

EPOWELD 7895A/7776B is a two component, long work life, room temperature cure epoxy adhesive designed for general purpose applications. It exhibits high cohesive strength combined with excellent impact and vibration resistance. The cured 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 such as metal, wood, ceramics and many plastics.

EPOWELD 7895A/7776B is available in the unique DOUBLE/BUBBLE® job sized package as reorder no. 04005.

CLEAN UP

EPOSOLVE® 299-R is a versatile clean up solvent (non red label) for both cured and uncured epoxies and urethanes. Gloves made of nitrile rubber or other impervious matter must be used with this product. A separate data sheet is available upon request. Refer to Material Safety Data Sheet for this product before using.

MIXING AND CURING SCHEDULE

Ratio	Part A	Part B
By weight	100	87
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:

24 hours at 25 °C (77 °F).

TYPICAL UNCURED PROPERTIES

	Part A	Part B	Mixed
Color	Amber	Dk. Amber	Dk. Amber
Viscosity @ 25 °C, cps	35,000	23,000	30,000
Weight per Gallon, lbs.	9.5	8.4	9
Specific Gravity @ 25 °C	1.14	1.01	1.08
Gel time, hours			
4 gm mass @ 25 °C	---	---	3
Gel time, minutes			
100 gm mass @ 25 °C	---	---	45
Flash Point, PMCC, °C	240	71	---
Filler Type	None	None	None
Shelf Life (in separate sealed containers), months	12	12	---

TYPICAL CURED PROPERTIES

(Tested at 25 °C unless otherwise indicated)

Test	Result
Hardness, Shore D	80
Impact Strength, ft.-lbs.	5.46

Lap Shear Strength

(Al/Al, 2024-T3 acid etched, various cure schedules)

Cure Schedule @ 25 °C	24 hours	1 week
Shear Strength, psi	2,765	3,280

Hardness over a temperature range;

(Cure schedule 24 hours @ 25 °C)

Test Temperature, °C	25	66	93	121	149
Hardness, Shore D	80	50	30	25	20

TYPICAL CHEMICAL RESISTANCE PROPERTIES

(Tested at 25 °C unless otherwise indicated)

Total Immersion:	Immersion Time, Days	% Weight Gain (Loss)
Water	1	(0.02)
	8	(0.42)
Ethyl Alcohol, 50% Solution	1	(1.42)
	8	(8.86)
Hydrochloric Acid (2N)	1	0.82
	8	5.06
Gasoline	1	0.43
	8	3.94
Sulfuric Acid, 30% Solution	1	0.84
	8	3.34
Toluol	1	10.2
	8	35.3
1,1,1 Trichloroethylene	1	8.47
	8	52.91
VM+P Naphtha	1	0.08
	8	0.63

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.

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:

www.royaladhesives.com

Contact us at:

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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. Purchases will be subject to a separate agreement, which will not incorporate this document.