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## TECHNICAL DATA SHEET 843

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# Structural Epoxy Adhesive

## PC500

### DESCRIPTION

**PC500** is a structural epoxy adhesive. Its high strength and durability make the product particularly useful for demanding bonding applications requiring very high performance properties. Unlike many other epoxies, **PC500** cures to be a tough high impact resistant material. The product has very good adhesion to many metals, ceramics and thermosetting plastics.

### PRODUCT FEATURES

- Fast Cure with heat exposure
- High Performance Structural Adhesive
- High thermal conductivity
- Excellent adhesive
- High durability
- High impact and peel strength

### TYPICAL PROPERTIES

<b>Color</b>	Gray Paste
<b>Viscosity</b>	Viscous Paste-200,000 cps
<b>Specific Gravity</b>	1.35

### TYPICAL CURED PROPERTIES

<b>Durometer</b>	80D
<b>T<sub>g</sub></b>	125°C
<b>Adhesive Shear Strength</b>	4000 psi (ASTM D-1002)
<b>Temperature Range of Use</b>	-40°C through 150°C (intermittent exposure thru 180°C)

### APPLICATION

PC500 is best applied through a 14 gauge or larger orifice tip onto the surface to be bonded or sealed. Sufficient product should be applied to provide full coverage to the bond area.

### CURING

**PC500** can be cured through a variety of thermal cycles. Typical ones are:

Glue Line Temperature	Time (Minutes)
125°C	45
150°C	20
170°C	10

Actual time to cure will depend on several factors. These include:

- Mass of the part to be heated
- Thermal conductivity of the part being heated
- Size and efficiency of the curing oven

**PC500** can also be cured rapidly by infra-red or induction heating systems.

### STORAGE AND HANDLING

<b>Shipping</b>	Recommended temperature is refrigerated or frozen
<b>Storage</b>	Store at 25°C for up to 3 months Store at 0°C for up to 12 months
<b>Safety</b>	Refer to MSDS for details

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