

U.S. Corporate Headquarters 400 Valley Rd. Warrington, PA 18976 1(800) 523-2575 / (215) 343-6484 1(800)343-3291 fax

info@polysciences.com

Polysciences Europe GmbH Handelsstrasse 3 D-69214 Eppelheim, Germany +(49) 6221-765767 +(49) 6221-764620 fax info@polysciences.de Polysciences Asia-Pacific, Inc. 2F-1, 207 Tunhwa N. Rd. Taipei, Taiwan 10595 (886) 2 8712 0600 (886) 2 8712 2677 fax info@polysciences.tw

# **TECHNICAL DATA SHEET 846**

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# **PC550A&B**Versatile, Tough Epoxy Adhesive

## **DESCRIPTION**

**PC550A&B** is an epoxy adhesive designed for bonding and sealing when high strength and toughness is required.

Unlike most epoxies, **PC550A&B** cures to be a non-rigid, tough polymer. Because of its toughness and versatile adhesion it is especially useful for bonding dissimilar materials.

**PC550A&B** has good adhesive properties to many substrates. Including: metals, composites, ceramics and many plastics. It is especially good for bonding fiberglass.

**PC550A&B** cures at room temperature and has a convenient easy to use mix ratio of 1:1. It will cure in 1 day at room temperature but can also be cured by heating to 80°C for 1hour or 60°C for 2 hours.

#### **UNCURED PROPERTIES**

	Part A	Part B	Mix
Туре	Ероху	Amine	
Color	Black	White	Gray
Specific Gravity	1.32	1.40	1.53
Viscosity@ 25°C, cps	50,000	40,000	42,000

#### PROCESS PARAMETERS

This product is best dispensed through a static top mixer. A uniform gray mixture being dispensed is a good indication of complete mixing of the components.

**Mix Ratio** 

	Part A	Part B
By Weight	100	105
By Volume	1	1

**Mixed Product** 

Pot Life @ 25°C 30 minutes
Gel Time @25°C 90 minutes
Bond Set Time @ 25°C 2-4 hours

## **CURED PROPERTIES**

Property	Units	Value
Hardness@25°C	Shore D	70
Hardness@100°C	Shore D	50
Adhesion to Aluminum	Psi	2200
Peel Strength	pli	30
Temperature Range of Use	°C	-50 to 120

(Under low stress conditions, or through intermittent exposures, the material is suitable through  $+150^{\circ}\text{C}$ )

#### STORAGE AND HANDLING

Shipping Room temperature
Storage Room temperature
Safety Refer to MSDS for details

All values are considered typical based on tests believed to be accurate. Polysciences, Inc. may change the data as appropriate.

# North America (United States)

1 (800) 523-2575 / (215) 343-6484 1 (800) 343-3291 / (215) 343-0214 fax

### Europe (Germany)

(49) 6221-765767 / (49) 6221-764620 fax

#### Asia-Pacific (Taiwan)

(886) 2 8712 0600 / (886) 2 8712 2677 fax

Online anytime at: polysciences.com

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