

## Heat Release Epoxy Systems

COMPONENT PROPERTIES					MIXED SYSTEM PROPERTIES						
Epoxy System*	Appearance	Viscosity (cps @ 25°C)	Specific Gravity	Mixing Ratio (by volume)	Gel Time**** (min.)	Cure Time (hrs.)	Hardness** (Shore "D")	Bond Strength (psi) Reference Values			Applications
								4 hrs.	8 hrs.	24 hrs.	
AD4010-A AD4015-B	White Yellow	275,000 11,500	1.05 1.14	2 1	4	2	73-75	1,100	1,600	2,100	Standard heat release system
AD4010-A AD3831-BR	White Red	275,000 11,500-13,000	1.03 1.14-1.12	2 1	7	3	72-76	1,200	2,000	1,900	Increased early hardness heat release system used for bonding
AD4110-A AD4015-B	White Yellow	80,000 11,500	1.09 1.14	2 1	4	2	73-75	1,600	1,900	1,900	Low viscosity system for ingot fixturing, glass beam bonding to wire saw workplate
AD4130-A AD4130-B	Cream Orange	28,000 11,500	1.07 1.14	2 1	15	2	55-60	500	640	930	Extremely low viscosity, longer gel time
AD4010-A AD4017-B	White Yellow	275,000 13,000	1.05 1.14	2 1	7	2	52-54	350	380	600	Increased gel time system
AD4180-A AD4180-B	White Yellow	Paste Paste	1.08 1.13	2 1	5	2	64-66	1,000	1,650	1,700	Non-sag system used for vertical surface mounting
AD4500	Tan	38,000	1.23	-	-	-	80*** (Shore "A" Hardness)	-	-	-	UV curable system for protective coatings, transparent substrate bonding

The data provided in the table above is typical and accurate to the best of our knowledge and is for reference only.

\*Requires Consistent Temperature Range of 194-203°F (90-95°C) preheated hot water bath or oven temperature higher than 248°F (140°C) for adhesive release.

\*\*Hardness Cure Conditions, 24 hrs., 10-20g @ 77°F (25°C)

\*\*\*Film Hardness After UV Cure

\*\*\*\*Gel Time Conditions, 100g @ 77°F (25°C)



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