

Adelphi A-62

Metal to Metal/Magnet Epoxy

Adelphi A-62 is a 100% solid, two-component, solvent-free, epoxy adhesive paste designed for metal-to-metal applications and other rigid materials such as glass, plastics, wood and structural laminates. It works well with laminates based on glass or fiber reinforced melamine, silicone, polyester, phenolic, epoxy and resins.

This adhesive is perfect for magnet application given that it can be cured at room temperature or at elevated temperatures with excellent lap shear.

Viscosity	Color	Base	Wt/Gal	Percent Solid	Dilute	Shelf Life
Paste	Dark Grey	Modified Epoxy	9.5 lbs.	100%	Do Not Dilute	1 year

Adelphi A-62 meets military specification MMM-A-134 Type 1.

Surface Preparation

All bonding surfaces must be thoroughly cleaned, degreased and dried. For plastic surfaces remove mold release.

Preparation of Adhesive

Weigh each part and mix slowly to avoid entrapment of air.

Note: Pot life can be lengthened substantially if shallow mixing vessels are used or smaller batches are mixed. Cover mixed material to prevent water absorption.

	Mixing Ratio (by weight)	Properties	Pot Life@77F	Avg. Tensile Strength
Part A	7 Parts	For best balance of properties	30 min (175 grams)	2500 psi
Part B	2 Parts			

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Heat Curing

75% of cure is attained in 24 hours. To accelerate the cure, any of the following cycles may be used:

Temperature	Cure Time
150F	60 minutes
200F	25 minutes
250F	15 minutes

Where military specification qualification is necessary, Adelphi A-62 must be cured for 1 hour at 164 F.

Application

Mixed Adelphi A-62 may be applied with trowel, spatula, knife etc. Apply enough mixed adhesive to fill all cavities and depressions in both surfaces being bonded and to leave about 4 additional mils of adhesive on each side. After proper mating of the components (with slight squeeze out of adhesive), optimum bond line thickness should range from 0.003 to 0.006 inch. (Very heavy glue lines may be tolerated up to 0.010 inch - and the adhesive may be cured in heavy sections with very little shrinkage and with good resultant bond strength). Assemble the parts immediately after spreading the adhesive since there are no volatile solvents present to be evaporated.

Clean-up solvent: Do not add thinner to this adhesive. Methyl Ethyl Ketone may be used for cleaning equipment or wiping up spilled adhesive before curing.

Technical Questions? Call us. We are happy to help! +631-537-8390

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