

**PRODUCT DESCRIPTION:**

AA-DUCT X1 is a two parts electrically conductive epoxy adhesives specially designed for repair rear window defogger. Quickly and easily Bonds defogger tab to grid on rear window, and defroster repair Grid, provides a low cost, high quality repair for damaged grid. AA-DUCT X1 is fast cure, also characterized by a wide operating temperature range from -20 to +200°F.

AA-DUCT X1 is recommended for rear window Defogger ( tab Adhesives) and Grid lines.

**PRODUCT PROPERTIES:**

<b>Appearance</b>	Silver
<b>Cure Type</b>	Heat cure or Room temperature
<b>Benefits</b>	<ul style="list-style-type: none"> <li>• High strength</li> <li>• Perfect bond</li> <li>• Cold solder for heat sensitive components</li> </ul>
<b>Mix Ratio by weight</b>	100:5/ Resin : Hardener
<b>Substrates</b>	Excellent choice Glass, aluminum, copper, magnesium, steel, bronze, nickel, ceramic.
<b>Operating Temperature</b>	-20 to +200°F
<b>Typical Applications</b>	Electrical, conductive, circuitry, printed circuit board and electronics repair

**UNCURED PROPERTIES:**

<b>Viscosity @ 25 °C cps</b>	Paste
<b>Specific Gravity, mixed</b>	2.64
<b>Reactive solids contents, %</b>	100
<b>Pot Life</b>	6 minutes
<b>Shelf life</b>	6 months

**CURE SCHEDULE:**

<b>10 minutes</b>	@ 60°C
<b>4 hours</b>	Room temperature

**CURED PROPERTIES:**

<b>Hardness, Shore D</b>	83
<b>Shrinkage linear in/in</b>	0.003
<b>Tensile Strength, psi</b>	2200
<b>Volume Resistivity ohm. cm</b>	<0.0001
<b>Compressive Strength, psi</b>	13,400
<b>Lap Shear Strength, PSI</b>	9400

**THERMAL PROPERTIES:**

<b>Thermal Conductivity, btu / hr / ft2 / °F / in</b>	10
<b>Thermal Expansion Coefficient (cm / cm / °C · 10-5)</b>	1.3
<b>Heat Distortion, °C:</b>	95
<b>Operating Temperature Range, °F:</b>	-20 to +200

**GENERAL INFORMATION:**

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

**HOW TO USE:**

1. Carefully clean and dry all surfaces to be bonded.
2. Apply AA-DUCT X1 completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
3. Some separation of components is common during Shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.
4. Some ingredients in this formulation provided may crystallize when subjected to low temperature storage. A gentle warming cycle of 52°C for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be re-dissolved prior to use for best results.

**AVAILABILITY:**

This epoxy can be supplied in many different packages.

**Atom Adhesives**

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