

PRODUCT DESCRIPTION:

AA-Bond 2115 is low viscosity epoxy formulation used in the fabrication of lasers. AA-Bond 2115 is an optical clear epoxy where alignment accuracy is essential. AA-Bond 2115 withstands 30 seconds of 60 watt direct laser energy. This adhesive has been used in cycling applications.

AA-Bond 2115 bond has good resistance to water and weathering, most petroleum solvents, mild acids and alkalis and other chemicals.

GENERAL PROPERTIES:

Technology	Epoxy
Color	Clear
Cure	Room temperature cure or Heat cure
Operating temperature	-50 to 105 °C Low viscosity Low shrinkage
Product Benefits	Good mechanical shock resistance Excellent temperature cycling performance
Mix Ratio, by weight-Resin : Hardener	100 : 30
Application	Manufacturing and Assembly Laser fabrication and Other optic applications
Typical Optic Application	Glass, Rigid plastics, Ceramic and Metals
Substrates	

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, cP:	
After Mixing	260 ± 10
Specific Gravity, mixed	1.19
Pot Life, hours	1.5

TYPICAL CURING PERFORMANCE

Cure Schedule	
25°C	24 hours
60°C	1 to 2 hours

PHYSICAL PROPERTIES:

Coefficient of Thermal Expansion, cm/cm/°C	5.50×10-05
Glass Transition Temperature (Tg), °C	55
Shore D	77
Izod Impact Strength, ft-lb/in. of notch	0.22

ELECTRICAL PROPERTIES:

Dielectric Strength, volts/mil	430
Dielectric Constant @ 25°C : 1kHz	4.8
Dissipation Factor @ 25°C : 1kHz	0.01

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength, psi:	
Substrate	
Aluminum to Aluminum	3700

GENERAL INFORMATION

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

DIRECTIONS FOR USE

- Carefully clean and dry all surfaces to be bonded
- Burst the pouch and thoroughly mix the AA-BOND 2115 epoxy adhesive system components in the handy plastic pouch until color is uniform throughout.
- Apply this 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.
- Some ingredients in this formulation provided in the plastic pouch, and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 50°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 redissolved prior to use for best results.

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