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♦ *TECHNICAL BULLETIN* ♦ *TECHNICAL BULLETIN* ♦ *TECHNICAL BULLETIN* ♦

## EPOXY RESIN RBC #2365

RBC #2365 is a thixotropic version of RBC#2360. RBC#2365 is a non-sag adhesive. It exhibits high peel strength, excellent shock and vibration resistance. Cured properties can be varied with the amount of hardener used, allowing a wide range of resiliency. It is ideal for bonding materials with different coefficients of thermal expansion. RBC#2365 bonds well to nickel, aluminum, nylon, polypropylene, glass and wood.

### HANDLING PROPERTIES:

Mixed Viscosity @ 25°C,cps	thixotropic
Pot Life	1-2 hours
Shelf Life, (closed Container @ 25°C)	12 Months

### PHYSICAL PROPERTIES (CURED):

Color	translucent
Specific Gravity @ 25°C	1.07
Hardness, Shore D	40
Linear Shrinkage, in./in.	0.005
Moisture Absorption 10 Days @ 25°C, %	0.55
Izod Impact Strength, ft. lbs./in. of notch	11.25
Bond Shear Strength, psi Al/Al @ 25°C	4,500
Tensile Strength @ 25°C, psi	3,500
Compressive Strength @ 25°C, psi	8,000

### THERMAL PROPERTIES (CURED):

Thermal Conductivity, cal/sec/cm <sup>2</sup> /°C/cm X 10 <sup>-4</sup>	5.20
Thermal Stability, 1000 Hrs. @ 175°C, % Wt. Loss	1.25
Coefficient of Thermal Expansion, in./in./°C X 10 <sup>-6</sup>	45.0
Operating Temperature Range, °C	-55 to 100

### ELECTRICAL PROPERTIES (CURED):

Volume Resistivity @ 25°C, ohm-cm	8 x 10 <sup>12</sup>
Dielectric Strength, volts/mil	430
Dielectric Constant @ 25°C, 100 KC	3.3
Dissipation Factor @ 25°C, 100 KC	0.018

The above properties are typical of a semi-flexible formulation cured for 1 hr @ 65°C and 1 hr. @ 120°C.

**MIXING INSTRUCTIONS:** Weigh the desired amount of #2365 Resin into a clean container and combine with AB-528 Hardener in one of the ratios shown below. Mix thoroughly for a minimum of three minutes by hand, or one minute by machine.

Semi-Flexible, Impact and Shock Resistant	100 parts RBC #2365 100 parts Hardener AB-528
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Flexible, Excellent Peel Strength	100 parts RBC #2365 132 parts Hardener AB-528
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**RECOMMENDED CURE STRENGTH:** Pot life ranges from 1 - 2 hours depending on batch size and hardener ratio. Cure for 72 hours at room temperature (25°C) or 2 hours at 65°C. For optimum properties, cure 1 hour at 65°C followed by 1 hour at 120°C.