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

EPOXY RESIN RBC #2400

RBC #2400 is a filled epoxy adhesive that cures at room temperature and offers excellent adhesion to both porous and non-porous surfaces. When combined with Hardener AB-520, its resistance to solvents, chemicals, and environmental conditions is impressive. Variations in rigidity and resiliency may be obtained by changing hardener ratios. It cures with low exotherm, making it an ideal encapsulant for heat-sensitive parts.

HANDLING PROPERTIES:

Mixed Viscosity @ 25°C, cps	45,000
Shelf Life, (Closed Container @ 25°C)	12 Months

PHYSICAL PROPERTIES (CURED):

Color	Black
Specific Gravity @ 25°C	1.30
Hardness, Shore D	65
Linear Shrinkage, in./in.	0.005
Moisture Absorption 10 Days @ 25°C, %	0.50
Izod Impact Strength, ft. lbs./in. of notch	1.10
Bond Shear Strength, psi AI/AI @ 25°C	4,100
Tensile Strength @ 25°C, psi	8,000
Compressive Strength @ 25°C, psi	12,000

THERMAL PROPERTIES (CURED):

Thermal Conductivity, cal/sec/cm ² /°C/cm X 10 ⁻⁴	8.0
Thermal Stability, 1000 Hrs. @ 175°C, % Wt. Loss	0.85
Coefficient of Thermal Expansion, in./in./°C X 10 ⁻⁶	45
Heat Distortion Temperature, °C	40
Operating Temperature Range, °C	-65 to 100

ELECTRICAL PROPERTIES (CURED):

Volume Resistivity @ 25°C, ohm-cm	9x10 ¹³
Dielectric Strength, volts/mil	450
Dielectric Constant @ 25°C, 100 KC	4.1
Dissipation Factor @ 25°C, 100 KC	0.020

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

MIXING INSTRUCTIONS: Stir #2400 Resin thoroughly in its shipping container and then weigh desired amounts of resin and hardener into a clean container. Mix thoroughly for at least three minutes by hand, or one minute by machine.

Rigid, heat resistant	100 parts RBC #2400 50 parts Hardener #AB-520
Semi-Flexible, impact and shock resistant	100 parts RBC #2400 100 parts Hardener #AB-520
Flexible, excellent peel strength	100 parts RBC #2400 150 parts Hardener #AB-520

RECOMMENDED CURE SCHEDULE: Pot life ranges from 1-3 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.



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