



EA-604
EPOXY ADHESIVE

FAST CURE



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DESCRIPTION

EA-604 is a two component liquid compound with excellent wetting and quick cure characteristics. The blue resin and yellow hardener, when mixed together, give a uniform translucent green color and provides a positive mix indicator. EA-604 will cure at temperatures as low as 0°F (-18°C). It exhibits an easy 1 to 1 mix ratio with a working life of 4-6 minutes at 77°F (25°C), and sets to handling strength in 10-15 minutes. Typical applications include all types of general repair and bonding requiring a liquid adhesive. EA-604 offers a quick, easy repair of similar and dissimilar materials.

TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C)

Mix Ratio (by weight or volume)	100R/100H
Specific Gravity	1.14 g/cc
Resin Viscosity.....	11,000-15,000 cps
Hardener Viscosity.....	10,000-16,000 cps
Mixed Viscosity	13,000 cps
Work Life (30 gram mass)	4-6 minutes
Cure to Handling Strength	10-15 minutes
Minimum Cure Schedule	6 hours
Maximum Cure	24 hours
Mixed Color	Translucent green
Shelf Life of Resin and Hardener (in original unopened containers)	2 years

TYPICAL PHYSICAL PROPERTIES @ 77°F (25°C)

Tensile Strength (ASTM D-638)	6,200psi (43MPa)
Tensile Elongation (ASTM D-638).....	6%
Tensile Modulus (ASTM D-630)	375,300psi (2,588MPa)
Compressive Strength (ASTM D-695).....	9,440psi (65MPa)
Compressive Modulus (ASTM D-695).....	174,000psi (1,200MPa)
Flexural Strength (ASTM D-790)	8,996psi (62MPa)
Flexural Modulus (ASTM D-790).....	267,400psi (1,844MPa)
Coefficient of Thermal Expansion (TMA) (ppm/°F (°C)).....	42 (76)
Heat Deflection Temperature @ 66 psi (ASTM D-648.82)	113°F (45°C)
Moisture Absorption (ASTM D-570.81)	0.65%
Impact Strength (ASTM D-256.93a).....	12.98 in-lbf/in
Hardness (ASTM D-2240.91)	80-85 Shore D

TENSILE ADHESION STRENGTH TEST

Substrate Material	Mahogany
Average Tensile Adhesion Strength	1,823psi (13MPa)
Maximum Tensile Adhesion Strength.....	2,446psi (17MPa)
Typical Failure Mode: 90% substrate failure, 10% adhesive failure	
Substrate Material	Steel
Average Tensile Adhesion Strength	1,052psi (7MPa)
Maximum Tensile Adhesion Strength.....	1,093psi (8MPa)
Typical Failure Mode: 100% adhesive failure	

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