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FABREEKA #700 EPOXY ADHESIVE APPLICATION SHEET

This two-part, multi-purpose Epoxy Adhesive is ideal for bonding Fabreeka Pad, SA-47, *PTFE, Steel, Aluminum and Stainless Steel to a variety of compatible materials, such as, wood, rubber, plastics, ceramics, metal and concrete. It will bond equally well to some of the more difficult substrates, such as, polyethylene, polypropylene, nylon and tedlar. It can be cured (set) at room temperature or heat may be used to speed the cure.
* PTFE must be protected from debris and direct sunlight with a "light obstructing" layer of black plastic. Exposing PTFE to direct sunlight can deteriorate adhesive bond.

Bond Surface Preparation

- Etch-clean and/or sandblast bond surface on concrete/metal thoroughly.
- Buff and clean rubber bond surface thoroughly.

Adhesive Mixing

- Mix Fabreeka #700 epoxy adhesive following manufacturer's instructions, mix 50-50, Base and Activator, (A&B).

Application

- Apply the mixed adhesive to bond surface to be bonded using a "V" notched serrated applicator with a 1/4" deep notch.
- Disposable plastic applicators are available from McMaster Carr, called a "thrifty trowel" spreader scraper.
- Place unit to be bonded securely in place by blocking and/or clamping to prevent movement during the 240 hour epoxy full cure time, (fixtures may have to be made for this step). The epoxy full cure time may be decreased by the application of heat. Please note the following: 2.75 hrs. @ 165°F, 1.75 hrs. @ 216°F or .75 hrs. @ 300°F.
- Remove all restraints and place unit under normal load.

Characteristics

- Operating temperature: -80 to +300°F
- Specific gravity: 1.20 to 1.35
- Exhibits high shear bond strength

Military Specifications

- Meets the requirements of MIL-A-8623, MIL-A-14202, MIL-A-134 and Naval Ordinance #2662718.

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