



Technical Data Bulletin No.
METREG RIP 327
 REV. 0 6/25/10

PRODUCT INFORMATION

High Technology Materials for Electronics and Industry

PRODUCT NUMBER: METREG RIP 327 DESIGNATION: HIGH STRENGTH, TWENTY-FIVE MINUTE EPOXY ADHESIVE

INTENDED APPLICATION: ADHESIVE

DESCRIPTIVE DATA:

	RESIN PORTION	ACTIVATOR	MIXTURE
FORM	LIQUID	LIQUID	LIQUID
COLOR	CLEAR	LIGHT YELLOW	LIGHT YELLOW
SP. GR.:	1.1 – 1.2	1.1 – 1.2	1.2
*VISCOSITY:	9,000 CPS	10,000 CPS	9,000 CPS

INSTRUCTIONS FOR USE:

MIX RATIO:	(BY VOLUME) (BY WEIGHT)	MIX TOGETHER	100 PARTS	ACTIVATOR AND ACTIVATOR AND	100 PARTS 100 PARTS	RESIN. RESIN.
POT LIFE:		(WORKING LIFE OF MIXTURE)		20 MINUTES		AT 25°C
CURE TIMES:	INITIAL CURE 25-30 MINUTES AT 25°C, FULL CURE 1 HOUR AT 25°C					
SPECIAL INSTRUCTIONS:	MIX ONLY AS MUCH ADHESIVE AS YOU CAN CONVENIENTLY USE IN LESS THAN TWENTY MINUTES. APPLY TO ONE SURFACE OF PARTS TO BE BONDED. MATE PARTS TOGETHER FOR 24-30 MINUTES (VERY THIN FILMS MAY BE HELD SLIGHTLY LONGER).					

CHARACTERISTICS OF CURED COMPONENTS:

	TEST METHOD	AVERAGE VALUES**	PHYSICAL UNIT
IMPACT RESISTANCE	IZOD		ft-lbs/in notch
EXPANSION COEFFICIENT	ASTM D 696		
THERMAL SHOCK RESIST.	MIL-I-16923C		
OPERATING TEMP. RANGE		-65 to +145	°C
		-76 to +293	°F
HARDNESS TESTS	ASTM D 2240	55	Shore D
MOISTURE TESTS			
FLEXURAL STRENGTH	ASTM D 790		psi
COMPRESSIVE STRENGTH	ASTM D 695		psi
TENSILE STRENGTH	ASTM D 638		psi
ELONGATION			%
TENSILE LAP SHEAR (A1-A1)	ASTM D 1002	650	psi
DIELECTRIC STRENGTH	ASTM D 149		volts/mil
VOLUME RESISTIVITY	ASTM D 257		ohm-cm
DISSIPATION FACTOR	ASTM D 150		
DIELECTRIC CONSTANT	ASTM D 150		

* Thixotropic materials list viscosity obtained by Helipath test method.

** Test values are average values obtained by standard laboratory tests. These are not intended as final specification limits and are not to be used for the preparation of specifications.

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