



APTEK LABORATORIES, INC.

ISO 9001 / AS9100 Certified

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TECHNICAL DATA & INFORMATION

PRELIMINARY
APTEK® 6528-A/B
High peel, epoxy adhesive

PRODUCT DESCRIPTION

APTEK 6528-A/B is a two component, long pot life, tough, flexible epoxy adhesive designed to adhere well to metal surfaces. When cured, **APTEK 6528-A/B** develops excellent peel strengths to difficult metal substrates like stainless steel and titanium.

KEY FEATURES AND BENEFITS

- Excellent wetting to metal substrates for maximum adhesion.
- Long pot life for large area applications

HANDLING INFORMATION

Mix ratio, parts by weight	100 (6528-A)/25 (6528-B)
Recommended weighing tolerances	± 1% on each part
Work life @ 25°C, 100 gms, hours	2

MIXING

Weigh 100 parts of Aptek 6528 Part A into a clean, dry, glass, metal, or plastic container and then add 25 parts of Aptek 6528 Part B. Hand mix with clean, dry glass rod or metal spatula until complete and thorough blending is achieved.

Note: For best results and void free casting, vacuum mixture at less than 15 mm Hg for 1-2 minutes after "break".

CURE SCHEDULE

2 hrs @ 125°C

or

4 hrs @ 110°C

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TYPICAL PROPERTIES

(values not to be used for specification purposes)

<u>CHARACTERISTICS</u>	<u>6528-A</u>	<u>6528-B</u>	<u>TEST METHOD</u>
Color	light yellow/off white	clear/sight yellow	Visual
Specific gravity	1.13	1.01	ASTM D-1475
Viscosity, @25°C,	36,000	45	ASTM D-1824
Flash Point, °C	>170	>170	ASTM D-92
Shelf life @ 25°C, mos factory sealed containers,	6	6	

CURED PHYSICAL PROPERTIES

(cured 4hrs @ 110°C)

APTEK 6528-A/B**TEST METHOD**Lap Shear, 5 mil bond line, @25°C,
abraded, solvent wiped, psi –

- Al/Al
- stainless steel/s.s.

1150
1050

ASTM D-1002

Peel strength, 0.3 mil bond line, @25°C,
solvent wiped, piw

- s.s/s.s

15

ASTM D-1876
(peel) @ 6"/min.**SAFETY AND FIRST AID**

APTEK 6528-A is safe to handle when used properly. Avoid contact with skin and eyes and use in a well-ventilated area and avoid breathing vapors. In case of eye contact, flush with fresh clean water for at least 15 minutes; for skin contact, wash thoroughly with soap and water. If swallowed, do not induce vomiting, drink at least one pint of water and call a physician. Refer to Material Safety Data Sheet for more details.

APTEK 6528-B is considered a slight irritant however, may cause eye and skin irritation on prolonged and repeated exposure. Inhalation of vapors may be harmful in large amounts. Avoid skin and eye contact and use in a well-ventilated area. In case of eye contact or skin contact, flush profusely with water. If swallowed, do not induce vomiting, dilute with at least one pint of water and contact physician. Refer to Material Safety Data Sheet for more details.

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