

ERA-148
NO SAG, THIXOTROPIC EPOXY ADHESIVE

ERA-148 is a soft, paste-like epoxy adhesive that is essentially non-running on vertical surfaces, even at 60°C. It cures to a hard but flexible solid. Due to its neutral color, this adhesive is recommended for use in thin films to bond glass and other applications where the bond line should not be noticeable.

TYPICAL HANDLING PROPERTIES:

Resin	ERA-148A
Hardener	ERA-148B
Mix Ratio by weight, phr	50
Mixed Viscosity at 25°C, cp	Paste
Pot Life at 25°C (100 grams), mins	30
Recommended Cure Schedule	2 hrs at 65°C
Alternate Cure Schedule	48 hrs at 25°C

TYPICAL CURED PROPERTIES AFTER RECOMMENDED CURE:

Color	Translucent Amber
Specific Gravity	1.17
Hardness, Shore D	83
Water Absorption (24 hour immersion) at 25°C, %	0.83
Lap Shear Strength to Aluminum, psi	
at -45°C	2200
at 25°C	2500
at 65°C	1500
at 85°C	800
Flexural Strength at 25°C, psi	14,000
Flexural Modulus (yield) at 25°C, psi	4.7x10 ⁵
Service Temperature range	-55°C to 90°C
Glass Transition Temperature, °C	65
Coefficient of Linear Thermal Expansion, 10 ⁻⁶ /°C	
from -55°C to 25°C	140
Dielectric Strength, volts/mil	450
Dielectric Constant at 1 kHz and 25°C	3.9
Dissipation Factor at 1 kHz and 25°C	0.007
Volume Resistivity at 25°C, ohm-cm	9x10 ¹⁵

INSTRUCTIONS FOR USE:

At room temperature, mix 100 grams of ERA-148A with 50 grams of ERA-148B and vacuum degas. Apply to clean bonding surfaces and cure as recommended to achieve the desired properties. Typical cured properties were determined using the recommended cure schedule. Some difference in properties may occur with the alternate or other cure schedules.

FOR INDUSTRIAL USE ONLY:

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

WARNING!!

Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of the work place and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. In case of skin contact, wash thoroughly with soap and water. For eyes, flush immediately with plenty of water for at least 10 minutes and seek medical attention. Refer to the Material Safety Data Sheet for additional health and safety information.

SHELF LIFE:

The shelf life of these materials is greater than two years when stored in unopened containers at an average temperature of 25°C.