



EA-608 EPOXY ADHESIVE

MEDIUM CURE

PRODUCT BULLETIN



www.CASSpolymers.com
31200 Stephenson Hwy

800.344.7776
Madison Heights MI 48071

ADTECH@CASSpolymers.com
Ph 248.588.2270 Fax 248.588.5909

DESCRIPTION

EA-608 is a 1R:1H two-component epoxy adhesive with excellent wetting and bonding characteristics. EA-608 will cure at temperatures as low as 0°C/32°F. Its easy 1R:1H mix ratio, working life of 15-20 minutes and quick cure-to-handling-strength of one hour, make it an ideal choice for many production bonding applications. EA-608 is a longer work life version of EA-604 Fast Cure Adhesive. All types of general repair and bonding applications requiring a resilient liquid adhesive for easy and fast repair of similar and dissimilar materials.

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (parts by volume).....	1R:1H
Work Life (4 oz. mass).....	15-20 minutes
Resin Viscosity.....	10,000 - 15,000 cps
Hardener Viscosity.....	12,000 - 18,000 cps
Mixed Viscosity (flowable liquid).....	11,000 - 16,000 cps
Cure-to-Handling Strength.....	60 minutes
Cure-to-Handling Strength @ Temperatures Below 18°C/65°F.....	2-3 hours
Minimum Cure Time.....	24 hours
Maximum Cure Time.....	7 days
Shelf Life of Resin and Hardener (in original unopened containers).....	2 years

PHYSICAL PROPERTIES

Ultimate Tensile Strength (ASTM D-3039.93).....	2,410 psi
Tensile Elongation (ASTM D-3039.93).....	11.18%
Tensile Modulus (ASTM D-3039.93).....	237,400 psi
Ultimate Flexural Strength (ASTM D-790.92).....	4,852 psi
Flexural Modulus (ASTM D-790.92).....	166,800 psi
Ultimate Compressive Strength (ASTM D-695.91).....	8,090 psi
Coefficient of Thermal Expansion (ASTM-696.91).....	45.40x10 ⁶ in/in°F
Heat Deflection Temperature @ 66 psi (ASTM D-648.82).....	35°C/95°F
Heat Deflection Temperature @264 psi (ASTM D-648.82).....	31°C/89°F
Moisture Absorption (ASTM D-570.88).....	0.07%
PATTI Tensile Adhesion (Aluminum).....	1,886 psi
Hardness.....	80 Shore D

EA-608 Tech/Revised 5/20/10
Supersedes 06/29/06

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