



**EA-612
EPOXY ADHESIVE
SERIES**
TWO HARDENER CHOICES
DISPENSABLE



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-612 is a two component, 1:1 volume, dispensable paste adhesive designed for bonding FRP; epoxy composites; metals; planks; woods; and all general purpose bonding applications requiring a high strength paste adhesive. This system is also formulated for contact with potable water applications and is FDA approvable. The white resin and black hardener when mixed together gives a uniform gray color and positive mix indicator when no streaks of white or black are observed. There is a choice of two hardeners which will depend on the working life required. EA-612 Hardener has a long working life and gives the user adequate time to position large parts and bond large surfaces. EA-612-1 Hardener offers the user a faster curing system. EA-612 is formulated to easily dispense from manually operated caulking gun/cartridge style dispensers or mechanical meter-mix equipment.

HANDLING CHARACTERISTICS @ 25°C/77°F

	<u>EA-612R/EA-612H</u>	<u>EA-612R/EA-612-1H</u>
Mix Ratio (by volume)	100R/100H	100R/100H
Mix Ratio (by weight)	100R/96H	100R/84H
Mixed Density	10.2 lbs/gal	9.45 lbs/gal
Specific Gravity	1.22 gms/cc	1.13 gms/cc
Viscosity	Disp. Thixotropic Paste	Non-Sag Disp. Paste
Work Life (200 gram mass)	2 hours	80 Min (100 gram mass)
Cure-To-Handling Strength	18-24 hours	8-12 hours
Complete Cure	7 days	3-5 days
Mixed Color	Gray	Gray
Shelf Life of Resin and Hardener (in original unopened containers)	2 years	2 years

PHYSICAL PROPERTIES

Tensile Strength	7,239 psi	4,079 psi
Tensile Lap Shear (aluminum to aluminum)	1,756 psi	*2,482 psi@65°C/149°F
Tensile Lap Shear (aluminum to aluminum)	**1,558 psi
Flexural Strength	12,170 psi	5,813 psi
Flexural Modulus	444,400 psi	450,000 psi
Heat Deflection Temperature @ 66 psi	49°C/120°F	49°C/120°F
Shore Hardness	85 Shore D	80 Shore D

*Cured 24 hours at 25°C + 1 hour at 120°C + cooled to 25°C + tested at 65°C

** Cured 24 hours at 25°C + 1 hour at 120°C + tested at 25°C

EA-612 Series Tech/Revised 5/20/10
Supersedes 1/25/08

Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. Seller accepts no responsibility for results obtained by the application of seller's products or the safety and suitability of seller's products, either alone or in combination with other products. Users are advised to make their own test to determine the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, seller delivers the products without warranty of any nature, stated or implied, and buyers and users assume all responsibility and liability for loss or damage arising from the handling and use of said products, whether used alone or in combination with other products. Purchaser waives any claim against seller for direct, indirect, consequential or exemplary damages against seller, including without limitation, damage which may incur as a result of purchaser's use or misuse of the product or the products failure to conform to any particular specifications.