



**ED-2018**  
**CORE SPLICE ADHESIVE**  
 HALOGEN-FREE  
 FLAME RETARDANT  
 EPOXY PASTE

**PRODUCT BULLETIN**



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**DESCRIPTION**

ED-2018 CORE FILL ADHESIVE is a halogen-free, low-density, flame retardant, two-part epoxy system. The smooth creamy consistency is ideal for fastener potting/core splicing and allows application to vertical surfaces without slumping. ED-2018 is color coded to ensure proper mixing and cures to a slate blue color. When used at room temperature, this material can be sanded in 4-6 hours.

ED-2018 was developed to meet BMS 5-28 Type 18 and FAR/JAR 25.853(a).

**HANDLING CHARACTERISTICS @ 25°C/77°F**

Mix Ratio (parts by weight).....	100R/20H
Mixed Density.....	0.60 grams/cc
.....	5 lbs/gal
Mixed Viscosity .....	Extrudable Paste
Work Life (200 gram mass).....	40 minutes
Room Temperature Cure Schedule .....	7 days
Accelerated Cure Schedule .....	Gel at Room Temperature
.....	+ 5 hours @ 52°C/125°F
Resin Color.....	Blue
Hardener Color.....	White
Mixed Color .....	Slate Blue
Shelf Life of Resin and Hardener (in original unopened containers) .....	2 years

**TYPICAL PHYSICAL PROPERTIES (7 day cure @ 25°C/77°F)**

Tensile Lap Shear (sandblasted aluminum to aluminum).....	1,333 psi
Flexural Strength.....	2,964 psi
Flexural Modulus.....	220,000 psi
Heat Deflection Temperature.....	54°C @ 66 psi
JAR/FAR 25.853 Flammability Testing: 60 second ignition vertical test .....	Pass
30 second ignition – 45 degree .....	Pass

**24 HOUR FLUID IMMERSION PROPERTIES (% of weight gain)**

**Per BMS 5-28AF, Type 17, test method section 8.10**

TT-S-735, Type III Test Fluid.....	0.21%
MIL-H-5606a Hydraulic Fluid .....	0.62%
BMS3-11 Type IV Class 1 Grade A (Low Density Hydraulic Fluid) .....	0.94%
Distilled Water .....	0.65%

Note: The listed flammability test methods were performed on ED-2018 samples conditioned for 7 days at room temperature and on samples conditioned at the accelerated cure rate.

ED2018 Tech/Revised 5/6/10  
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