



11801 Industry Drive
 Jacksonville, FL 32218
 www.StealthBond.com
 844-5-STEALTH

STEALTHBOND® TECHNICAL DATA

1. **PRODUCT DESCRIPTION:** StealthBond® is an all-purpose, modified epoxy that provides excellent tensile, peel and shear strength. Exhibits superior adhesive and flexibility to a wide variety of substrates includes: ceramics, concrete, wood, composites, FRP and most metals-without the use of primer. StealthBond has a user-friendly and forgiving 1:1 by volume mix ratio. Light stable and highly UV resistant. StealthBond® out performs most "brittle" 2-component systems by retaining high peel strength and flexibility through a wide temperature range.

2. **TECHNICAL DATA:**

STEALTHBOND ADHESIVE INFORMATION																																						
Open Time 25 min. Ultimate Peel Strength* 50pli Tensile Strength 825 psi. Lap Shear 750 psi. Elongation 100 % Shore Hardness A 82 High Temperature Resistance : Up to 350°F for short periods Low Temperature Flexibility : Properties retained to -75°F	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 15%;"></th> <th style="width: 15%;">Part A</th> <th style="width: 15%;">Part B</th> <th style="width: 15%;">Blend</th> </tr> </thead> <tbody> <tr> <td>Specific Gravity</td> <td>1.19</td> <td>1.44</td> <td>1.315</td> </tr> <tr> <td>Color</td> <td>White</td> <td>Black</td> <td>Gray</td> </tr> <tr> <td>Viscosity(cps) *Brookfield Helipath T-E @ 5 RPM's 72° F</td> <td>80,000</td> <td>160,000</td> <td>140,000</td> </tr> </tbody> </table> <p style="margin-top: 10px;">Storage: 6 Months. For maximum shelf life, store unopened product between 65°F - 80°F. Part B is cold storage sensitive. Do not store below 65°F for more than 1 week. The 400 ml dual cartridges may be warmed up to 65°F - 80°F prior to application to increase flow either in a heated cabinet, vehicle or warmed in a microwave oven for 1 min. per cartridge.</p>		Part A	Part B	Blend	Specific Gravity	1.19	1.44	1.315	Color	White	Black	Gray	Viscosity(cps) *Brookfield Helipath T-E @ 5 RPM's 72° F	80,000	160,000	140,000	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 40%;">DEGREE</th> <th style="width: 60%;">CURE TIME</th> </tr> </thead> <tbody> <tr> <td>35°F</td> <td>22.4 min</td> </tr> <tr> <td>45°F</td> <td>20.8 min</td> </tr> <tr> <td>55°F</td> <td>19.2 min</td> </tr> <tr> <td>65°F</td> <td>17.6 min</td> </tr> <tr> <td>75°F</td> <td>16 min</td> </tr> <tr> <td>85°F</td> <td>14.4 min</td> </tr> <tr> <td>95°F</td> <td>12.8 min</td> </tr> <tr> <td>105°F</td> <td>11.2 min</td> </tr> </tbody> </table>	DEGREE	CURE TIME	35°F	22.4 min	45°F	20.8 min	55°F	19.2 min	65°F	17.6 min	75°F	16 min	85°F	14.4 min	95°F	12.8 min	105°F	11.2 min		
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3. **PACKAGING:**
 400 ml dual cartridges

4. SURFACE PREPARATION

Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying product. Some substrate materials may not be compatible with this product. Testing substrate compatibility before application is recommended.

5. PAINTING:

Cured product may be painted with most industrial & consumer paints. Testing prior to painting is recommended.

6. STORAGE LIFE:

6 months. For maximum shelf life, store unopened product between 65°F- 80°F . Part B is cold storage sensitive. Do not store below 65°F for more than 1 week.

7. TECHNICAL SERVICE:

StealthBond® technical representatives are always available to provide assistance. Please contact our Technical Service Department with your questions or requests for specific applications.

8. LIMITED WARRANTY

Any goods that prove defective will be replaced or purchase price refunded. The limited warranty described herein is in lieu of any other warranty, expressed or implied, including any implied warranty of merchantability or fitness for a particular use. The user shall determine sustainability of the product for its intended use. Liability for any incidental or consequential damage or loss is excluded. The user assumed all risks of the product's use, handling and storage.