



Advanced Materials Technical Datasheet



Fastweld 10 A/B Epoxy Adhesive

Product Description

Fastweld 10 A/B Epoxy Adhesive is a rapid-setting, two-component paste offering a convenient one- to-one mixing ratio by volume or weight. Fastweld 10 A/B Epoxy Adhesive produces strong bonds in a very short period. It is especially suited for bonding small parts and repair work.

Features

- Rapid setting paste
- 1:1 mixing ratio

Typical Properties*

Property	Test Method	Fastweld 10 A Resin	Fastweld 10 B Hardener	Mixed System
Appearance	Visual	Black	White	Gray
Density at 25°C, g/cm ³	ASTM D792	1.48	1.44	1.46
Viscosity at 23°C, cP	ASTM D2393	260,000	160,000	250,000 [†]

*Properties are based on Huntsman test methods. Copies are available upon request.

[†]Measured at 25°C.

Processing

Mix Ratio

Product	Parts by weight	Parts by volume
Fastweld 10 A Resin	100	1
Fastweld 10 B Hardener	100	1

Mix only that quantity which can be applied immediately after mixing. Due to the very fast setting properties of Fastweld 10, hand mixing of the components should be avoided. Fastweld 10 is available in 50 mL twin cartridges. For best results, Fastweld 10 should be dispensed using manual or pneumatic dispensing equipment through a 0.25 in diameter, 20 element static mixing nozzle (Nordson EFD #7701488 or equivalent). For other mixing and application recommendations, please consult your local Huntsman Advanced Materials representative or one of our distributors.

Processing Data

Parameter	Value
Pot life, 2 fl oz at 25°C, min	3 - 4
Typical cure cycle	4 h at 25°C, curing at elevated temperatures is not recommended

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification. The figures below were all determined by testing standard specimens made up by lap-joint 4 in x 1 in x 0.06 in (10 cm x 2.5 cm x 1.5 mm) strips of degreased and 100-grit abraded aluminum. The joint area was 0.5 x 1 in (12.5 mm x 2.5 cm) in each case. Samples were cured for 24 h at 77°F (25°C), unless a different cure is specified.

Property	Value
Tensile lap shear at 25°C, psi (MPa) Cure: 1 h 41°F (5°C) 4 h 41°F (5°C) 24 h 41°F (5°C) 30 min 77°F (25°C) 1 h 77°F (25°C) 4 h 77°F (25°C) 24 h 77°F (25°C)	 1,420 (10) 1,560 (11) 1,710 (12) 1,710 (12) 2,130 (15) 2,840 (20) 2,840 (20)
Tensile lap shear,* psi (MPa) Test temperature: -40°F (-40°C) 77°F (25°C) 104°F (40°C) 140°F (60°C)	 1,560 (11) 2,840 (20) 2,420 (17) 1,140 (8)
Tensile lap shear, exposure to 120°F (49°C) / 95 % R.H., psi (MPa) 0 day 10 days 30 days	 2,840 (20) 1,710 (12) 1,000 (7)
Tensile lap shear, heat aging at 140°F (60°C), psi (MPa) 0 day 10 days 30 days 60 days	 2,840 (20) 2,840 (20) 2,990 (21) 2,560 (18)

*Load applied 10 minutes after specimens reach test temperature.

Storage

Fastweld 10 A/B Epoxy Adhesive should be stored in a dry place in the original sealed containers, at temperatures between 2°C and 40°C (36°F and 104°F). Under these storage conditions, and when supplied under Huntsman standard certification, the product has a shelf life of **3 years** (from date of manufacture). The product should not be exposed to direct sunlight.

If stored below 60°F, the adhesive should be brought to 60°F - 77°F and conditioned at this temperature for some time prior to use.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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