

Adelphi A-833

Metal to Metal Structural Epoxy

Adelphi A-833 is a 100% -solids, two-component, solvent-free, epoxy paste form designed for metal-to-metal applications and for bonding other rigid materials such as glass, plastics, wood and structural laminates based on glass or fiber reinforced melamine, silicone, polyester, phenolic, epoxy and resins.

Adelphi A-833 and C-38 are specified by Hamilton Standard Div. of United Technologies Corp. for the bonding of treated Teflon to anodized aluminum propeller blade shanks.

Viscosity	Color	Base	Wt/Gal	Percent Solid	Dilute	Shelf Life
Paste	Dark Grey	Modified Epoxy	9.5 lbs.	100%	Do Not Dilute	1 year

Note: Pot life can be lengthened substantially if shallow mixing vessels are used or smaller batches are mixed. Cover mixed material to prevent water absorption.

Catalyst Number	Mixing Ratio (by weight)	Properties	Pot Life	Avg. Tensile Strength
A833 C-3	100Parts 6 Parts	For best balance of properties	2.5 hours	2500 psi
A833 C-38	100 32 Parts	For best impact and peel strength	20 minutes	2500 psi

Surface Preparation

All bonding surfaces must be thoroughly cleaned, degreased and dried. For plastic surfaces, remove mold release.

Preparation of Adhesive

Weigh each part and mix slowly to avoid entrapment of air.

Depending upon the end use service requirements of the completed bond, Adelphi A-833 may be used with hardeners which set at room temperatures, at moderate temperatures and at elevated temperatures.

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Heat Curing:

Heat Curing Hardener C-3 - Typical Cure cycle is 90 minutes @ 200F.

Room Temperature Curing Hardener C-38 - Typical cure cycle is 7 days, 75% of cure is attained in 24 hrs.

To accelerate the cure of Adelphi A-833 / C-38 any of the following cycles may be used:

Temperature	Cure Time
150F	20 minutes
200F	15 minutes
250F	10 minutes

Application:

Mixed Adelphi A-833 may be applied with trowel, spatula, knife, etc. Apply enough mixed adhesive to fill all cavities and depressions in both surfaces being bonded and to leave about 4 additional mils of adhesive on each side. After proper mating of the components (with slight squeeze out of adhesive), optimum bond line thickness should range from 3 to 6 mils. (Very heavy glue lines may be tolerated up to 10 mil - and the adhesive may be cured in heavy sections with very little shrinkage and with good resultant bond strength). Assemble the parts immediately after spreading the adhesive since there are no volatile solvents present to be evaporated.

Clean-up: Solvent. Do not add thinner to this adhesive. Methyl Ethyl Ketone may be used for cleaning equipment or wiping up spilled adhesive before curing.

Technical Questions? Call us. We are happy to help! +631-537-8390

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