

## Adelphi A-933

### Water Based High Lap Shear Stack Lamination Adhesives

Adelphi A-933 is a high-strength water-based epoxy adhesive designed to bond rotors, stators, magnetic rails, and transformer cores where temperature resistance of up to **450°F** is required.

Fully cured bonds exhibits exceptionally high lap shear strength of **6000 PSI** at **23° C** and acts as electrical insulator for assembled stacks.

Viscosity	Base	Percent Solid	Dilute	Shelf Life
1000 cps	Water	53%	Water	1 year

### Performance Properties:

Temperature	Lap Shear psi
77° F	6200
162° F	3720
350° F	1860
400° F	400

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## Method of Applications:

Adelphi A-933 is non-flammable, low viscosity and can be applied via roller coat, spray, and brush.

## Drying and Curing Information:

Adelphi A-933 is a thermoset (heat curing) epoxy that first requires drying to a B stage followed by a final heat cure or C stage.

### Drying to B Stage:

After Adelphi A-933 has been applied, dry parts in for 5 minutes @ 100° C.

Do not exceed temperatures of 121° C (250° F).

### C Stage Heat Curing Temperature Cycle:

To cure the epoxy please follow the steps below.

Glue Line Temperature	Minimum Gel Time	Minimum Cure Time	Maximum Cure Time
356F or 180C	10 min	30 minutes	None

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

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