

Adelphi A-971

Chemical Resistant Epoxy Adhesive Minimal Shrinkage

Adelphi A-971 is a high-strength, room-temperature-curing, 100%-Reactive, two-component, epoxy adhesive designed for bonding all metals and other rigid materials (such as glass, ceramics, plastics, plastic foams and structural laminates) to themselves and to each other.

Fully cured bonds exhibit minimal shrinkage, are electrical insulators and provide excellent resistance to weather, galvanic action and most chemical, acids and alkalis.

Viscosity	Color	Base	Wgt/Gal	Solids	Diluent	Shelf Life
Medium Syrup	Clear, pale amber	Modified epoxy	9.5 lbs	100 %	Do not dilute	1 year

Performance Properties:

Catalyst Number	Mixing Ratio (by weight)	Properties	Pot Life	Average Lap Shear Strength
A-971 C-3	5 parts 1 part	For best balance of properties	20-45 minutes	2500 PSI
A-971 C-38	5 parts 2 parts	For best impact and peel strength	20-45 minutes	2500 PSI

Surface Preparation:

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

Preparation of Adhesive:

First stir each part individually, weigh and mix slowly to avoid entrapping air.

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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.

Mixed adhesive may be applied with trowel, spatula, knife, paint roller, brush, etc. Apply enough mixed adhesive to leave about 4-6 mils in the final glue line. This may be accomplished by coating 4-6 mils on one surface only or by coating 2-3 mils on each surface.

If one surface is porous, more adhesive must be applied to fill the voids and yet produce a final glue line thickness of 4-6 mils.

Cure Time:

Room Temperature:

If cured at room temperature, assemblies can be handled in approximately 4-6 hours and develop 85 % of maximum strength in 14-24 hours.

Force Cure:

If a faster cure is required, the following can be used:

Elevated Temperature

Temperature	Cure Time
150F or 65C	60 minutes
200 F or 93C	20 minutes
250 F or 120C	15 minutes

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

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