

## MEG – 150 Epoxy

### CHEMICAL PRODUCT

PRODUCT NAME: MEG-150

COLOR: White

CHEMICAL FAMILY: Mixture

MOLECULAR FORMULA: Mixture

MOLECULAR WGT: Mixture

GLASS TRANSITION TEMP: 127 °C

THICKNESS: 0.005" or 0.009"  $\pm$ 0.0005" (127  $\mu$ m or 230  $\mu$ m)

CURE TEMP: 165-175 °C for 1 hour

C.T.E.:  $15 \times 10^{-6}$  /°C

ELECTRICAL INSULATOR

### PRODUCT FEATURES

- ▶ Excellent adhesion to metal, glass, plastics (thermoset and high temperature thermoplastics), and ceramics.
- ▶ High shear, peel and cleavage strength over a wide temperature range.
- ▶ High degree of clarity when in contact with a solid surface.
- ▶ Good uncured integrity, light in weight and easy to handle.
- ▶ No primer required.
- ▶ At temperatures  $\leq 25$  °C, epoxy has little or no tackiness.
- ▶ Relatively low bonding pressure may be used.

### STORAGE

Store in a refrigerator at 32°F to 35°F (0°C to 2°C) or in a freezer between 15°F and 32°F (-9 to 0°C).

Allow the epoxy to regain room temperature just prior to use. Stored under these conditions, the shelf life of the epoxy is approximately 6 – 10 months.

### CURING SCHEDULE

Allow epoxy to warm up to room temperature before placing on the surface to be sealed. Curing time is a function of temperature, but in a general cycle of 60 minutes at 165°C to 175°C under 5 to 40 psi (0.03 to 0.28 MPa) can be used as a reference. However, bonding conditions can vary considerably with satisfactory results, using heat-up interval of 1 – 30 minutes (depending on size) and curing temperatures from 165°C to 175°C. Preheated convections ovens are recommended. Cure Atmosphere: air, nitrogen or vacuum.

Bonding conditions are optimized when the epoxy is fresh. The sealing surface should be dry and free of large particles, debris, oils and other foreign material.