

CS-2 BOND TEST DATA

The following table summarizes the adhesive bonding process control test data for the Japanese CS-2 Satellite primary central cylinder structure. Specimens were standard EFC lap shear aluminum/beryllium coupons bonded with EA-9309 adhesive/BR-127 primer system. All specimens received a minimum seven day room temperature data.

Specimen No.	Shear Strength PSI	Specimen No.	Shear Strength PSI
1	4633	24	4467
2	4621	25	5117
3	4618	26	4706
4	4718	27	4553
5	4738	28	4598
6	4712	29	4709
7	4765	30	4850
8	4923	31	4844
9	4732	32	4838
10	4608	33	4722
11	4655	34	4781
12	4728	35	4702
13	4796	36	4796
14	4651	37	4944
15	4866	38	4863
16	4811	39	4925
17	4438	40	4760
18	4357	41	4856
19	4832	42	4912
20	4793	43	4639
21	4708	44	4282
22	4455	45	4591
23	4685	46	4581

Maximum 5117 Minimum-4282 Average-4716

Note: Handling Aluminum-Beryllium Alloys in solid form poses no special health risk. Like many industrial materials, beryllium-containing materials may pose a health risk if recommended safe handling practices are not followed. Inhalation of airborne beryllium may cause a serious lung disorder in susceptible individuals. The Occupational Safety and Health Administration (OSHA) has set mandatory limits on occupational respiratory exposures. Read and follow the guidance in the Material Safety Data Sheet (MSDS) before working with this material. For additional information on safe handling practices or technical data on Aluminum Beryllium Alloys, contact Materion Brush Inc.

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