

## Tra-Con Tra-Bond 642-1 Epoxy Adhesive

Category : Polymer , Adhesive , Thermoset , Epoxy

### Material Notes:

TRA-BOND 642-1 unfilled epoxy adhesive is designed to provide a long pot life and cure rapidly at elevated temperatures. Information provided by Tra-Con Inc.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Tra-Con-Tra-Bond-642-1-Epoxy-Adhesive.php](http://www.lookpolymers.com/polymer_Tra-Con-Tra-Bond-642-1-Epoxy-Adhesive.php)

| Physical Properties | Metric               | English              | Comments     |
|---------------------|----------------------|----------------------|--------------|
| Viscosity           | 5500 cP              | 5500 cP              | After mixing |
|                     | @Temperature 25.0 °C | @Temperature 77.0 °F |              |

| Mechanical Properties  | Metric   | English  | Comments                        |
|------------------------|----------|----------|---------------------------------|
| Hardness, Shore D      | 87       | 87       |                                 |
| Adhesive Bond Strength | 19.3 MPa | 2800 psi | Lap shear, alum to alum, @ 25°C |

| Thermal Properties        | Metric               | English              | Comments    |
|---------------------------|----------------------|----------------------|-------------|
| CTE, linear               | 84.0 µm/m-°C         | 46.7 µin/in-°F       |             |
|                           | @Temperature 20.0 °C | @Temperature 68.0 °F |             |
| Glass Transition Temp, Tg | 137 °C               | 279 °F               | Ultimate Tg |

| Electrical Properties | Metric              | English             | Comments |
|-----------------------|---------------------|---------------------|----------|
| Volume Resistivity    | 6.50e+14 ohm-cm     | 6.50e+14 ohm-cm     |          |
|                       | @Temperature 100 °C | @Temperature 212 °F |          |
| Dielectric Constant   | 3.36                | 3.36                |          |
|                       | @Frequency 1000 Hz  | @Frequency 1000 Hz  |          |
| Dissipation Factor    | 0.0070              | 0.0070              |          |
|                       | @Frequency 1000 Hz  | @Frequency 1000 Hz  |          |

| Processing Properties | Metric               | English             | Comments |
|-----------------------|----------------------|---------------------|----------|
| Cure Time             | 30.0 min             | 0.500 hour          |          |
|                       | @Temperature 120 °C  | @Temperature 248 °F |          |
|                       | 60.0 min             | 1.00 hour           |          |
|                       | @Temperature 95.0 °C | @Temperature 203 °F |          |

| Processing Properties | Metric                | English               | Comments |
|-----------------------|-----------------------|-----------------------|----------|
|                       | @Temperature 75.0 °C  | @Temperature 167 °F   |          |
| Shelf Life            | 12.0 Month            | 12.0 Month            |          |
|                       | @Temperature -40.0 °C | @Temperature -40.0 °F |          |

| Descriptive Properties | Value  | Comments |
|------------------------|--------|----------|
| Outgassing, NASA       | Passes |          |
| Thixotropic Index      | 1      |          |
| Working Life hours     | 8      |          |

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