



TECHNICAL DATA SHEET

TDS# 2308

DATE: JULY 2013

BACON INDUSTRIES

FLUID ADHESIVE FA-8

ADHESIVE: FA-8 is an unfilled gyro grade epoxy adhesive having good dimensional stability. It is useful in applications for bonding and sealing beryllium and other metals. The activator is colored making it easy to tell when the adhesive is properly mixed.

RECOMMENDED MIXING AND HANDLING PARAMETERS

Amount of Activator per BA-5, parts by weight per hundred of Adhesive FA-8 (1)	13.5
Viscosity of mixed adhesive at room temperature, poise	60
Surface Tension, dyne/cm	52
Working Life at room temperature, minutes	90
Pot Life (tack-free time) at room temperature, minutes	240
Recommended Cure, hr/°F	2/200

TYPICAL PROPERTIES OF CURED ADHESIVE:

	CURE		
	2 hr at 200°F	8 hr at 200°F	1 hr at 140°F + 16 hr at 160°F
Color (1)	Blue-Green	Blue-Green	Blue-Green
Specific Gravity	1.20	1.19	1.19
Hardness, Shore D	83	85	85
Lap Shear Strength to aluminum, psi			
at -65°F	2250	---	---
at 77°F	2650	2300	2500
at 200°F	1275	---	---
at 77°F after ageing one year at 300°F	2250	---	---
Flexural Strength, psi	18,000	15,000	18,000
Young's Modulus in Flexure, psi	760,000	690,000	720,000
Glass Transition Temperature, °F			
by DSC	165	205	193
by TMA (2)	130	208	212
Loss in Weight after ageing six months at 300°F, %	8.8	---	---
Coefficient of Linear Thermal Expansion (2), 10 ⁶ /°F			
between -65°F and 77°F	29	29	30
between 77°F and 160°F	60	35	39
between 77°F and 200°F	74	39	41
Dielectric Constant at 77°F and 1 kHz	3.8	3.73	---
Dissipation Factor at 77°F and 1 kHz	0.005	0.008	---
Volume Resistivity, 10 ¹⁶ ohm-cm	>1	>1	---

(over)

