



# TECHNICAL DATA SHEET

TDS# 2601

DATE: JUNE 2013

## BACON INDUSTRIES

### FLEXIBLE PASTE-LIKE EPOXY ADHESIVE FTA-101

Adhesive FTA-101 is a modified epoxy adhesive whose flexibility may be varied with different activator ratios. Because of its paste-like consistency, it does not run from vertical surfaces. It is useful as a general purpose adhesive for application to a wide variety of substrates.

### RECOMMENDED MIXING AND HANDLING PARAMETERS

Adhesive	FTA-101	FTA-101
Activator <sup>1</sup>	BA-161	BA-161
Parts by weight of activator required per hundred of adhesive	100	150
Consistency	Light paste	Light paste
Work life at 77°F, hr	6	4

### TYPICAL PROPERTIES OF CURED ADHESIVE:

	<u>2hr/160 7day/77</u>		<u>2hr/160 7day/77</u>	
	Black	Black	Black	Black
Cure, time/°F				
Color	Black	Black	Black	Black
Hardness, Shore D	73	72	52	62
Flexural Modulus, 10 <sup>3</sup> psi	80	190	---	---
Yield Strength, psi	3200	6800	---	---
Lap Shear Strength to aluminum, psi	3600	3400	1600	2100
Coefficient of Linear Thermal Expansion, 10 <sup>-6</sup> /°F				
between -65°F and 32°F	43	40	47	42
between 160°F and 212°F	124	151	137	165
Glass Transition temperature (TMA), °F	113	105	37	52
Water Absorption (24 hour immersion at 77°F), %	0.71	---	2.52	---
Dielectric Constant at 1 kHz	3.5	3.9	4.2	4.0
Dissipation Factor at 1 kHz	0.04	0.06	0.09	0.06
Volume Resistivity, 10 <sup>12</sup> ohm-cm	430	1200	6	25

#### NOTE:

1. Activator BA-15 may be used instead of Activator BA-161 at the same mix ratios and will give the same cured properties. Activator BA-161 is a paste whereas Activator BA-15 is a free-flowing liquid. When using Activator BA-15, the mixed system will flow and can be classified as a thixotropic liquid.

(over)

**INSTRUCTIONS FOR USE:**

Mix at room temperature, 100 parts by weight of Adhesive FTA-101 with either 100 or 150 parts by weight of Activator BA-161 (or Activator BA-15, see Note 1, above). Mix well until uniform in color and consistency. Because of the paste-like nature of these materials, good mixing is essential. Degas if necessary to remove entrapped bubbles. Frequent "bumping" during degassing will be necessary. Apply and cure as indicated.

**FOR INDUSTRIAL USE ONLY! WARNING!!**

These materials may cause injury to skin following prolonged or repeated contact. Use with adequate ventilation. In case of contact, flush immediately with plenty of water. For eyes, seek medical attention.

**SHELF LIFE:**

The shelf life of these materials is greater than two years when stored in unopened containers at an average temperature below 85°F. The shelf life of the premixed and frozen FREEZE-PAK is greater than six months when stored at a temperature of -40°F, or colder.

**AVAILABILITY:**

Adhesive FTA-101 is available in two-quart and two-gallon kits as well as premixed, degassed, and frozen FREEZE-PAKS.