



TECHNICAL DATA SHEET

TDS# 2348
DATE: JUNE 2013

BACON INDUSTRIES

HIGH TEMPERATURE ADHESIVE FA-48

Adhesive FA-48, an epoxy resin system based on a blending of new and old technologies, has unusually good high temperature resistance, even if cured at only 212°F. This premium system, based on over two years of intense development, is useful in applications up to 360°F continuous use and to 400° or 450°F intermittently. The high strength and low modulus indicate unusually high toughness for such a high temperature material. This system meets Bacon Industries' requirements for lack of condensable volatiles and for gyro fluid resistance after a cure of 2 hours at 212°F plus 2 hours at 376°F and is "gyro grade".

This is a clear unfilled system and may be considered as a potential replacement for Adhesive FA-8 where superior performance at temperatures above 175°F is required. A filled low coefficient of thermal expansion version of this system, Adhesive LCA-48, is available. See Data Sheet No. 2648.

The curing agent, Activator BA-109, is a clear liquid amine with reduced sensitivity to moisture and carbon dioxide. It does not contain methylene dianiline (MDA) or phenylene diamines. Since it is not based on solid anhydrides, the potential for mixing blending errors is greatly reduced.

RECOMMENDED MIXING AND HANDLING PARAMETERS

Adhesive	FA-48
Activator	BA-109
Parts by weight of activator required per hundred of adhesive	13.42
Work Life at 77°F (25 g), minutes	180
Work life at 135°F (25 g), minutes	40
Pot Life at 212°F (25 g), minutes	7

TYPICAL PROPERTIES OF CURED ADHESIVE:

	Cure, hr/°F	
	<u>2/212°+2/375°</u>	<u>4/212°</u>
Specific Gravity	1.18	1.18
Color	Clear amber	Clear amber
Hardness, Shore D	89	88
Lap Shear Strength to aluminum at Room Temperature, psi		
at -66°F	2800	---
at 77°F	2100	1800
at 300°F	1400	---
at 400°F	250	---

(over)

