

Tra-Con Tra-Bond F253 Color Keyed High Temperature Epoxy Adhesive

Category : Polymer , Adhesive , Thermoset , Epoxy

Material Notes:

TRA-BOND F253 is a low viscosity, high temperature, two-part epoxy formulation that changes color during the curing process to indicate cure status. The unmixed components are light yellow; the mixture is green/blue; and the fully cured adhesive is reddish-amber. It exhibits excellent wicking, and develops strong, tough mechanically stable bonds to a wide variety of fiber optic and optical materials that includes most metals, ceramics, glass and many plastics. In addition, TRA-BOND F253 has good impact and thermal shock resistance, demonstrates low stress, and yields excellent pot and polish connections. It is also resistant to water and weathering, vapors and gases, most petroleum products, and an extended range of organic and inorganic environments. An additional post-cure of 30 minutes at 150°C is recommended when application temperatures higher than 150°C are anticipated. Information provided by Tra-Con Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Tra-Con-Tra-Bond-F253-Color-Keyed-High-Temperature-Epoxy-Adhesive.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	Mixed
Solids Content	100 %	100 %	Reactive Solids Content
Volatile Organic Compounds (VOC) Content	19.6 g/l	19.6 g/l	
Water Absorption	0.0040 %	0.0040 %	After 24 hours
Viscosity	1750 cP @Temperature 25.0 °C	1750 cP @Temperature 77.0 °F	Mixed (sp #2, 6 rpm)

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	88	88	
Adhesive Bond Strength	18.6 MPa	2700 psi	Lap shear, alum to alum

Thermal Properties	Metric	English	Comments
CTE, linear	62.7 µm/m-°C	34.8 µin/in-°F	Below Tg
	202 µm/m-°C	112 µin/in-°F	Above Tg
Maximum Service Temperature, Air	175 °C	347 °F	
Minimum Service Temperature, Air	-60.0 °C	-76.0 °F	
Glass Transition Temp, Tg	116 °C	241 °F	Ultimate Tg

Optical Properties	Metric	English	Comments
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Refractive Index Optical Properties	1.58 Metric	1.58 English	Comments
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Processing Properties	Metric	English	Comments
Cure Time	1.00 min	0.0167 hour	
	@Temperature 150 °C	@Temperature 302 °F	
	5.00 min	0.0833 hour	
	@Temperature 125 °C	@Temperature 257 °F	
	15.0 min	0.250 hour	
	@Temperature 100 °C	@Temperature 212 °F	
Pot Life	60 min	60 min	25 grams

Descriptive Properties	Value	Comments
Color	Green Blue	Mixed
	Light Yellow	Unmixed
	Reddish-Amber	Cured
Mix Ratio, parts by weight	100/10	Resin/Hardener
Working Life hours	2	25 grams

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