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**TECHNICAL DATA SHEET**  
**RF 912 A/B**  
**EPOXY ADHESIVE**

**Description**

RF 912 A/B is an epoxy adhesive system for bonding a wide variety of substrates. This product is thixotropic, and so can be used on vertical surfaces without excessive run out from the bond line. RF 912 part A is composed of a Bis-Phenol-A epoxy resin blend with suitable inert fillers. RF 912 part B is a blend of polyamide resins and suitable fillers. There are no solvents or any other chemical present that would cause any incompatibility with plastic substrates.

**Handling Properties, Typical**

Property	RF 912 A/B
Mix Ratio: by Weight	100:96
by Volume	1:1
Mixed Color	Tan or Custom
Viscosity Part A @ 77°F (25°C), cps	≈ 80,000 (Thixotropic)
Viscosity Part B @ 77°F (25°C), cps	180,000
Gel Time, 100 grams @ 77°F (25°C)	90 min
Cure Schedule	2-5 days @ 25°C

Cure the adhesive for 12 hours to achieve handling strength. Full cure is achieved in several days at room temperature, although, for most purposes one day is sufficient. Cure can be accelerated with mild heat. For example: 150°F for 2 hours or 180°F for 30 minutes.

**Physical Properties, Typical Cured Performance**

** Property	Test Method	Unit	Value
Shore Hardness		D	75+
Lap Shear, Al-Al	ASTM D1002	psi	2100

\*\* Cure: 24 hr @ 25°C

**SAFETY INFORMATION:** See Materials Safety Data Sheet for RF 912 A & B for proper storage and handling.

**Notice to Buyer: Exclusion of Warranties and Limitation of Liability**

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tests to determine its suitability for their particular purpose. No warranty is expressed or implied regarding such information, the data upon which the same is based, or the results to be obtained from the use of such information or product will not infringe any patent.

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