



# DA 581-2 Two Part Epoxy Adhesive

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## DESCRIPTION

DA 581-2 is a two part, filled thixotropic epoxy paste adhesive for applications requiring low or moderate temperature cures and service temperatures above 300 degrees F. The product bonds to a variety of substrates.

## PHYSICAL PROPERTIES

	<u>Part A</u>	<u>Part B</u>
Color:	Grey thixotropic paste	Amber Gel
Mix ratio:	100 parts A to	33 parts B by weight
Working Life:	75 minutes for a 100 gram mass at 78 °F	
Shelf Life:	One year at 0°F Six months at 40°F Three months at 75°F	One year at 0°F One year at 40°F One year at 75°F

## MECHANICAL PROPERTIES

Data obtained on 0.063" P2 etched 2024-T3 aluminum per MMM-A-132

	<u>Cure one hour @ 180F</u>	<u>Cure seven days @ 75F</u>
Lap Shear @ 75°F	2400 psi	2300 psi
Lap Shear @ 180°F	2000 psi	2000 psi
Lap Shear @ 300°F	1000 psi	1000 psi

Data obtained on P2 etched 2024-T3 aluminum, 0.063" thick, cured at 140°F for two hours at 10 psi pressure..

Dead Load Stress Durability	140°F and 90-100% RH
@1600 psi	350 hours
@1200 psi	2600 hours

**ADHESIVE PREPREGS FOR COMPOSITES MANUFACTURERS**  
**P.O. BOX 264 1366 NORWICH RD. PLAINFIELD CT 06374**  
**PHONE 860-564-7817 FAX 860-564-1535 [www.prepregs.com](http://www.prepregs.com)**

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## CURE CYCLE

The recommended cure cycle for DA 581-2 is seven days at 75°F or for one hour at 180°F at approximately 10 psi. Care must be taken when curing this material not to cause an exotherm

## STORAGE

Store material in a contaminate free container and store at 0 degrees F for extended storage. For shorter storage time requirements store at 40 degrees F, this enables quicker stabilization times.

## APPLICATION

Remove material from cold storage at least 20 hours prior to use to allow for stabilization at room temperature. Keep the material containerized to prevent moisture from condensing on the material. Weigh out only enough part A into a clean, dry container to be used within the working life of the adhesive. Add the appropriate amount of part B. Mix well to a uniform consistency and color, about 1 to 2 minutes, scraping the sides of the container. Apply to clean, dry substrate with spatula or roller or putty knife. Join the parts to be bonded and apply sufficient pressure to squeeze out some adhesive( approx. 5 psi) Cure per one of the recommended cure cycles.

## CLEAN UP

The adhesive can be removed from non-bonding areas with ketones or methylene chloride. Be sure to follow all Material Safety Data Sheet (MSDS) guidelines for the solvent to be used.

## CAUTION

This material contains epoxy resins and amines which may cause irritation to sensitive skin. Avoid contact with eyes or skin. If contact with skin occurs, wash as soon as possible with soap and water. If contact with eyes occurs, flush with water for 15 minutes. Do not handle or use this material until Material Safety Data Sheet has been read and understood. The user of this material is required to use the necessary protective equipment as directed by applicable state and federal laws when handling, curing, and grinding this material.

## IMPORTANT NOTICE

Information in this data sheet has been obtained under controlled laboratory conditions and is believed to be accurate. Properties listed are typical values and are not intended for use in preparing specifications. Actual values may vary. No warranty is expressed or implied for which APCM assumes legal responsibility. APCM cannot be responsible for misapplication or handling and use under conditions beyond its control and under no circumstances shall be liable for incidental or consequential damage resulting from handling or use of this material.

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