Adhesive Prepregs for Composite Manufacturers, LLC

DA 2206
Two Part Epoxy Adhesive

DESCRIPTION

DA 2206 is a two part, epoxy adhesive which bonds well to wood, metal, fiberglass, and plastics. This adhesive can be mixed in a 1:1 volume ratio and cured at room temperature. Elevated temperature cures are capable with DA2206

PHYSICAL PROPERTIES	Part A	Part B
Color:	Translucent white	Amber
Mix ratio:	1 part A to	1 part B by weight
Working Life:	90 minutes for a 100 gram mass at 75 °F	
Shelf Life:	One year at 75°F	One year at 75°F

MECHANICAL PROPERTIES

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

	Cure two hours @ 150	Cure seven days @ 75F
Lap Shear @ 75°F	5300 psi	4000 psi
Lap Shear @ -67°F	3600 psi	2600 psi
Lap Shear @ 180°F	800 psi	500 psi
Lap Shear @ 250°F	500 psi	400 psi
Lap Shear @ 350°F	400 psi	250 psi

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CURE CYCLE

The recommended cure cycle for DA 2206 is seven days at 75°F or for two hours at 150°F or 30 minutes at 250°F with approximately 10 psi. Care must be taken when curing this material not to cause the resin to be squeezed completely out of the bond line.

STORAGE

Store material in a contaminate free container and store at 75 degrees F.

APPLICATION

Material can be supplied in the following containers, Mix Pac 50 ml size with mix nozzle, Manual dispensing gun sold separately . Quart kit, 1/2 gallon kit, 1 gallon kit, or 5 gallon quantities.

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 1-2 minutes, scraping the sides of the container. Apply to clean, dry substrates with a spatula or rubber roller. Join parts to be bonded and apply sufficient pressure to squeeze out some adhesive (approximately 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,

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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