TWO-PART EPOXY ADHESIVE SYSTEM
MS-907

For bonding metals, glass, ceramics, plastics, wood, rubber, fabrics and concrete. Miller-Stephenson's Epoxy 907 Adhesive System is a two-part, equal volume, room temperature curing system particularly useful for general purpose bonding. Fast set-up time. Perfect for in-plant and field use. Develops bond strength to 3,000 psi.

BONDING STRENGTH	To 3,000 PSI
FORM	A two-part paste adhesive packaged in equal volume tubes.
COLOR	Part A is blue. Part B is beige. When thoroughly mixed, the result is light blue.
VISCOSITY	Approximately 120,000 cP, thixotropic.
MIX RATIO	Equal parts by volume.
POT LIFE	20 minutes at 77˚F, 200 grams
CURE TIME	24 hours at 77˚F, or 2 hours at 140˚F, or 1 hour at 180˚F. Do not attempt to cure below 60˚F.
SERVICE TEMPERATURE	-50˚ to 180˚F
SHELF LIFE	More than 1 year at 75˚F.
SPECIAL PROPERTIES	Good adhesion to wide variety of surfaces. Color-coded for proper mixing.

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TYPICAL CURED PROPERTIES @ 77˚F(25˚C)

Tensile Strength, psi (ASTM D 638)……..	3100
Modulus, psi (ASTM D 638)……	245,000
Elongation at Break, % (ASTM D 638)…….……	2.4
Coefficient of Linear Thermal Expansion, in/in/˚C(ASTM D 696)	45 x 10^{-6}
Thermal Conductivity Cal Cm/(CM^2)(Sec)(˚C) x 10^{-4}……	6.8
% Water Absorption	
24 Hours……	0.66
7 Days……...	2.28
Linear Shrinkage, in/in……	0.00025
Hardness, Shore D……..	79

TYPICAL ELECTRICAL PROPERTIES

Volume Resistivity, Ohm-cm @ 100 volts, 77˚F (25˚C)…….	3.16 x 10^{14}
Dielectric Constant, MIL 1-16923. K 1kHz……...	4.58
Dissipation Factor, ASTM D 150 1kHz……..	0.076

TYPICAL TENSILE BOND STRENGTH

Typical tensile shear strengths for bonds to etched aluminum (ASTM D 1002), cured 24 hours at 77˚F are:

Test Temperature, ˚F	Tensile Shear Strength, PSI
-67	2300
77	3000
180	1000
250	400

Typical tensile bond strength obtained at room temperature with various MEK wiped substrates are as follows:

Substrate	PSI @ 75˚F	Substrate	PSI @ 75˚F
Galvanized steel	1800	Epoxy laminate	400
Bonderized steel	1900	Plate glass	1100
Black iron	2200	Penton	600
Tin plate	1300	Polyethylene	500
Terne plate	1200	Polypropylene	400
Brass	500	Plexiglas®	200
Copper	1000	Hi-impact polystyrene	0
Alclad	3000	$CaCO_3$ filled buna rubber	300
Polyester laminate	800	Neoprene	500

Plexiglas ® is a registered trademark of Atoglas Co.

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DIRECTIONS

1. **CLEAN SURFACES** Surfaces to be bonded must be clean, dry and free of oil, grease or wax. Roughen nonporous surfaces with sandpaper or emery paper for hard materials.

2. **MIX EQUAL PARTS** Squeeze a length from tube A on a clean, dry, flat disposable surface. Use uniform pressure for even bead. Parallel to tube A, run an equal length bead from tube B.

3. **MIX THOROUGHLY** Important! Mix the two beads together for 3 minutes or longer. When properly mixed, the adhesive is light blue.

4. **APPLY TO BOTH SURFACES** Cover entire area evenly.

5. **JOIN PARTS TOGETHER FIRMLY** Squeeze out excess adhesive to form a thin glue line. A larger area will require more pressure. Hold parts together with clamps, weights or tape.

5. **REMOVE EXCESS ADHESIVE PROMPTLY** Before adhesive hardens, scrape with putty knife. Clean with lacquer thinner, acetone or turpentine. Once cured, adhesive may be removed by sanding.

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