



# Product Information

[www.miller-stephenson.com](http://www.miller-stephenson.com)

## MS-917 Plus Thermoset Epoxy

### Description:

MS-917 is a two component, thixotropic, room temperature curing epoxy adhesive. It's specially formulated where a limited of flow is desirable. It is ideal for bonding most materials, such as metal, glass, ceramics, plastics, wood and rubber. The thixotropic nature of the adhesive will hold parts in place without special fixtures while the hardening process is taking place. Versatility in curing options between 74°F/23°C and 212°F/100°C.

### Advantages:

- 24 hour cure at room temperature
- 1:1 ratio mix ratio
- Good adhesion to wide variety of surfaces
- Packaged in cartridge form for ease of mixing

### Ratio & Cure:

Part A (Resin) Tan, Part B (Hardener) Tan

Mixed: Tan

Mix Ratio: 1:1 by weight

Pot Life: 1 Hour at 74°F/23°C

Recommended cure: 176°F/80°C for 2 Hours

Minimum Alternative Cure(s):

May not achieve performance properties listed below

212°F/100°C for 30 Minutes

74°F/23°C for 24 hours

### Physical Properties<sup>1</sup>

|  |   |
|--|---|
| Viscosity (74°F/23°C) @ 2.5 rpm:.....  | 80,000-120,000 cPs  |
| Thixotropic Index:.....                | 2.1   |
| Glass Transition Temp:.....            | ≥ 55°C (Dynamic Cure: 20-200°C/ISO 25 min; Ramp-10-200°C @ 20°C//Min) |
| Coefficient of Thermal Expansion (CTE) |   |
| Below Tg:.....                         | 66 x 10 <sup>-6</sup> in/in°C   |
| Above Tg:.....                         | 248 x 10 <sup>-6</sup> in/in°C  |
| Shore D Hardness:.....                 | 64  |
| Lap Shear @ 23°C:.....                 | > 2,000 psi   |
| Die Shear @ 23°C:.....                 | ≥ 10 Kg 3,556 psi   |
| Degradation Temp:.....                 | 687°F/364°C   |
| Weight Loss:                           |   |
| @ 200°C:.....                          | 1.4 %   |
| @ 250°C:.....                          | 2.2 %   |
| @ 300°C:.....                          | 4.16%   |
| Suggested Operating Temperature:.....  | < 250°C (Intermittent)  |
| Storage Modulus:.....                  | 123,527 psi   |
| Particle Size:.....                    | ≤ 20 microns  |

For technical information call 800.992.2424 or 203.743.4447

For product sales: CT 800.442.3424, CA 800.771.8161

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## Electrical and Thermal Properties<sup>1</sup>

|                                  |                                |
|----------------------------------|--------------------------------|
| Thermal Conductivity.....        | NA                             |
| Volume Resistivity @ 23°C.....   | $\geq 3 \times 10^{13}$ Ohm-cm |
| Dielectric Constant (1KHz):..... | 3.17                           |
| Dissipation Factor (1KHz).....   | 0.021                          |

**Note:** Test for compatibility before use.

## Directions

1. Clean surfaces to be bonded. Both surfaces must be clean, dry and free of oil, grease or wax. Roughen nonporous surfaces with sandpaper or emery paper for hard materials.
2. The paste-like appearance allows it to be spread by hand using a spatula or blade.
3. Cover entire area.
4. 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, weight or tape.
5. Remove excess adhesive promptly before adhesive hardens. Scrape with a putty knife.

## Clean Up

Always wear appropriate protective equipment such as safety glasses and gloves. Clean uncured material with a mild solvent. Cured materials can only be removed mechanically.

**Safety Data Sheet (SDS) is available upon request.**

<sup>1</sup>Cure condition: 80°C for 2 hours. Different batches, conditions & application yield differing results. The data is not guaranteed. To be used as a guide only, not as a specification.

**LIMITATION OF LIABILITY AND REMEDIES:** Manufacturer warrants that, at the time of shipment by the Manufacturer, this product is free from defect in material and manufacture. If the product is proved to be defective, the exclusive remedy, at Manufacturer's option, shall be refund of the purchase price or replacement of the defective product, provided written notice of the defect is given no later than one year after the date of shipment by the Manufacturer. Manufacturer shall not otherwise be liable for loss or damages whether direct, indirect, incidental or consequential, regardless of the legal theory asserted, including negligence and strict liability. **Manufacturer expressly disclaims all implied warranties, including the implied warranty of merchantability and the implied warranty of fitness for a particular purpose. There are no warranties which extend beyond the description on the face hereof.**

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