



# ES6220 Fast Setting Liquid Epoxy Adhesive

## DESCRIPTION

ES6220 is a fast setting, liquid epoxy adhesive with good adhesion to a variety of surfaces. ES6220 has a mix ratio of 1 to 1 by weight or volume for easy measuring. It has a working time of 4 to 6 minutes at 77°F, and cures very rapidly. The resin and hardener are of a similar consistency, so they can be combined easily. This is important with the short working time of this system.

## TYPICAL APPLICATIONS

ES6220 is useful for bench assembly, quick repairs, and holding or fixturing components for final structural bonding. ES6220 works very well on wood and rigid foam, and can be used on aluminum, fiberglass and metals for non-structural bonding. It is ideally suited for bonding situations where a fast cure at room temperature, or good cures at low temperatures, are required.

## PRODUCT SPECIFICATIONS

	ES6220 A	ES6220 B	ASTM Method
Color	Light Amber	Amber	Visual
Viscosity, @77°F, centipoise	13,000-14,000 cps	13,000-14,000 cps	D2392
Specific Gravity, gms./cc	1.16	1.14	D1475
Mix Ratio, By Wt.	100 : 100 By Weight or Volume		PTM&W
Pot Life, 4 fl. Oz. Mass @ 77°F	4 to 6 minutes		D2471

## PACKAGING WEIGHTS

	Pint Kit	Quart Kit	Gallon Kit	Pail Kit
ES6220 A	1 lb.	2.25 lb.	9 lb.	45 lb.
ES6220 B	1 lb.	2.25 lb.	9 lb.	45 lb.
Kit	2 lb.	4.5 lb.	18 lb.	90 lb.

## DIRECTIONS FOR USE

**PREPARATION:** All surfaces to be bonded or patched must be free of dirt, oil and grease. Sanding or roughening the area to be bonded increases the surface area and enhances the bond.

**MIXING:** Measure out equal parts of ES6220 A and B, combine and mix thoroughly until a uniform consistency is reached. Mix for approximately 1 minute, scraping the sides and bottom of the container to avoid leaving unmixed material which will cause poor bonds.

**APPLICATION and CURING:** Apply mixed material to the roughened and cleaned area of the parts to be bonded. Press surfaces firmly together and leave undisturbed until cured. ES6220 cures rapidly, and the parts can be handled in a matter of minutes.

## TYPICAL MECHANICAL PROPERTIES

	ES6220 A/B	ASTM Method
Mix Ratio, By Weight or Volume	100 : 100	PTM&W
Gel Time, @ 77°F	4 to 6 minutes	D2471
Color	Amber	Visual
Mixed Viscosity, @77°F, centipoise	13,000 - 14,000 cps	D2393
Cure Time, @ 77°F @ 140°F	10 - 15 minutes Not Recommended	PTM&W
Cured Hardness, Shore D	82 Shore D	D2240
Specific Gravity, grams, cc	1.16	D1475
Tensile Strength, psi	3,000 psi	D638
Elongation at Break, %	7 %	D638
Compressive Strength, psi	6,500 psi	D695
Aluminum to Aluminum Tensile Lap Shear @ 77°F @ 140°F	2,000 psi 200 psi	D1002

## SAFETY and HANDLING

PTM&W epoxy products are made from raw materials carefully chosen to minimize or even eliminate toxic chemicals, and therefore offer the user high performance products with minimum hazard potential when properly used. Generally, the PTM&W epoxy resins and hardeners will present no handling problems if users exercise care to protect the skin and eyes, and if good ventilation is provided in the work areas. However, all epoxy resins and hardeners can be irritating to the skin, and prolonged contact may result in sensitization; and breathing of mist or vapors may cause allergenic respiratory reaction, especially in highly sensitive individuals. As such, avoid contact with eyes and skin, and avoid breathing vapors. Wear protective rubber apron, clothing, gloves, face shield or other items as required to prevent contact with the skin. In case of skin contact, immediately wash with soap and water, followed by a rinse of the area with vinegar, and then a further wash with soap and water. The vinegar will neutralize the hardener and lessen the chances of long term effects. Use goggles, a face shield, safety glasses or other items as required to prevent contact with the eyes. If material gets into the eyes, immediately flush with water for at least 15 minutes and call a physician. Generally, keep the work area as uncluttered and clean as possible, and clean up any minor spills immediately to prevent accidental skin contact at a later time. Keep tools clean and properly stored. Dispose of trash and empty containers properly. Do not use any of these types of products until Material Safety Data Sheets have been read and understood.

ES6220 Bulletin / ZW-38 / 103003-C1



## PTM&W Industries, Inc.

10640 S. Painter Avenue Santa Fe Springs, CA 90670-4092  
 562-946-4511 800-421-1518 FAX: 562-941-4773  
 Visit Us At: [www.ptm-w.com](http://www.ptm-w.com) Send Questions To: [info@ptm-w.com](mailto:info@ptm-w.com)