



ES6224

Black, Fast Setting Epoxy Adhesive

DESCRIPTION

ES6224 is a very fast setting, black, epoxy adhesive with good adhesion to a variety of surfaces. ES6224 has a mix ratio of 1 to 1 by weight or volume for easy measuring. It has a working time of 2 to 3 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

ES6224 is useful for bench assembly, patching and quick repairs, and holding or fixturing components for final structural bonding. ES6224 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

	ES6224-A	ES6224-B	ASTM Method
Color	Black	Amber	Visual
Viscosity, @ 77°F, centipoise	14,000 - 15,000 cps	13,000 - 14,000 cps	D2392
Specific Gravity, gms./cc	1.20	1.13	D1475
Mix Ratio	100 : 100 By Weight or Volume		PTM&W
Pot Life, 4 fl.oz. Mass @ 77°F	2 to 3 minutes		D2471

PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit
ES6224 Part A	2 lb.	8 lb.	40 lb.
ES6224 Part B	2 lb.	8 lb.	40 lb.
Kit	4 lb.	16 lb.	80 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 ES6224 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. ES6224 cures rapidly, and the parts can be handled in a matter of minutes.

TYPICAL MECHANICAL PROPERTIES

		ES6224 A/B	ASTM Method
Mix Ratio,	By Weight	100 : 100 By Weight or Volume	PTM&W
Color		Black	Visual
Mixed Viscosity, centipoise		14,000 - 15,000 cps	D2393
Pot Life, 4 fl. Oz. Mass, @77°F		2 to 3 minutes	D2471
Cured Hardness, Shore D		82 Shore D	D2240
Cure Time	@ 77°F @ 140°F	10 - 15 minutes Not Recommended	
Specific Gravity, grams, cc		1.164	D1475
Density	lb./cu.in. lb./gallon	0.0420 9.71	D792
Specific Volume, cu.in. / lb.		23.78	
Tensile Strength, psi		3,000 psi	D638
Elongation at Break, %		7 %	
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, 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, nitrile rubber 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.

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