



# ES6240 Toughened, High Peel Strength Epoxy Adhesive

## DESCRIPTION

ES6240 is a two component toughened epoxy adhesive with very good cured properties that provides excellent bonds to a variety of substrates. Its blend of high lap shear and T-Peel values allow superior performance in demanding bonding applications. ES6240 adheres very well to wood, metal, composites and some plastics. The bonded components exhibit tough and durable performance for long term stability in use.

## PRODUCT SPECIFICATIONS

	ES6240 Part A	ES6240 Part B	ASTM Method
Color	White*	Translucent Amber	Visual
Viscosity,	28,000 cps	42,400 cps Gel	D2392
Specific Gravity, gms./cc	1.12	1.10	D1475
Mix Ratio	100 : 48 By Weight; 100 : 50 By Volume		PTM&W
Pot Life, 4 fl.oz. Mass @ 77°F	40 - 45 minutes		D2471

\* A Black Version of ES6240 is available by special order. Order as ES6240 Black.

## DIRECTIONS FOR USE

**PREPARATION:** All surfaces to be bonded or patched must be free of dirt, oil and grease. The better the surface prep, the better the results! Sanding or roughening the area to be bonded increases the surface area and enhances the bond. See PTM&W Bulletin “Guidelines for Metal Surface Preparation” for more information.

**MIXING:** Measure out equal parts of ES6240 A and B, combine, and mix thoroughly until a uniform color and consistency is reached. Mix for at least 1 to 2 minutes, scraping the sides and bottom of the container to avoid leaving unmixed material that will cause soft spots in the cured material.

**APPLICATION and CURING:** Apply mixed material to roughened area of the parts to be bonded. Press surfaces firmly together and let set for 24 hours or more at 75°F. If necessary, place assembly in a jig or other device to prevent movement during initial curing time. Curing time is 24 to 36 hours at 75°F, or 2 to 4 hours at 140°F. The material to be bonded may be preheated to accelerate curing time, or very light heat can be applied after the parts have been bonded.

## PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit
ES6240 Part A	2 lb.	8 lb.	40 lb.
ES6240 Part B	1 lb.	4 lb.	20 lb.
Kit	3 lb.	12 lb.	60 lb.

**TYPICAL MECHANICAL PROPERTIES**

	ES6240 A/B	ASTM Method
Mix Ratio,	100 : 48 By Weight, or 100 : 50 By Volume	PTM&W
Color	White or Black*	Visual
Mixed Viscosity, centipoise	72,000 cps	D2393
Pot Life, 4 fl. Oz. Mass, @77°F	40 - 45 minutes	D2471
Cured Hardness, Shore D	84 Shore D	D2240
Cure Time	@ 77°F 24 - 36 hours @ 140°F 2 - 4 hours	PTM&W
Specific Gravity, grams, cc	1.113	D1475
Density, lb. / cu. inch	.0402	D792
Specific Volume, cu. in. / lb.	24.86	
Tensile Strength, psi	7,458 psi	D638
Elongation at Break, %	25.2 %	
Tensile Modulus, psi	317,075 psi	
Flexural Strength, psi	11,505 psi	D790
Flexural Modulus, psi	343,138 psi	
Compressive Strength, psi	10,388 psi	D695
Lap Shear, 2024-T3 Aluminum, ASTM D2651 FPL Etch	4,009 psi	D1002
T-Peel, 2024-T3 Aluminum, ASTM D2651 FPL Etch	26.9 pli	D1876
Glass Transition Temp., DMA, Tg Peak	186.3 °F	D7028

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**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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