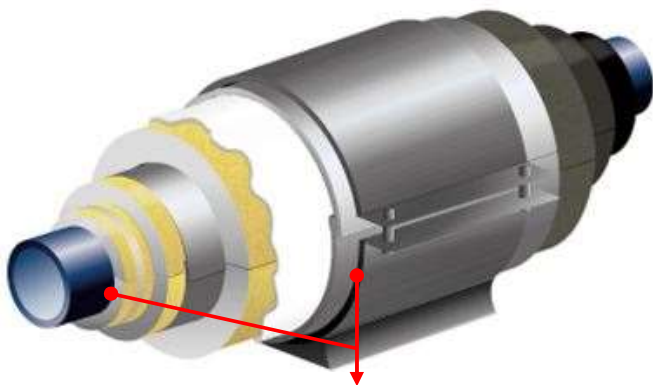


SHC 107-77

CRYOGENIC ADHESIVE



SHC 107-77

MAIN APPLICATION

- ◇ Excellent Adhesion for cryogenic temperature
- ◇ High solid content
- ◇ High tensile strength
- ◇ 3 component adhesive

SHC 107-77 is a cryogenic adhesive for metal and insulation.

COLOR

Black

APPLICATION TOOL

Trowel

AVERAGE WEIGHT / LITER (ASTM D1475)

1.85 ±0.05 kg/Liter ; Mixed (A&B&C)

AVERAGE NON-VOLATILE (ASTM D2369)

99.9% ±4.7 by weight

COVERAGE RANGE (SHTM 13)

(Subject to type of surface and nature of material being bonded)
3~12 kg/m²

Wet Film Thickness: 1.6 ~ 6.4 mm

Dry Film Thickness: 1.6 ~ 6.4 mm

MIXING RATIO

Part A : Part B : Part C = 3.13 : 1 : 9.33 (by weight)

CURING TIME (25°C, 50%RH) (SHTM 12)

Set To Touch: 0~1 hour

Dry Through: 4 hours

Maximum strength: 7 days

POT LIFE (25°C, 50%RH) (SHTM 07)

90 minutes

SERVICE TEMPERATURE LIMITS (SHTM 08)

(Temperature at coated surface)

-196°C ~ 121°C

WET FLAMMABILITY (ASTM D3278)

Flash Point : ≥121°C

REMARKS

Store and apply between 4°C and 38°C.

Contains no asbestos, lead, mercury or mercury compounds.

Pot life is longer at lower temperature.

Always test plastic materials for compatibility when using a solvent base product.



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Preparation for application

- Do not thin product.
- Make sure the mixing ratio of mass of 3 component Part A(3.13), Part B(1) and Part C(9.33)
- Check the quantity to be applied in advance and calculate the weight of A,B,C. As pot life of product is 1-2 hours, do not mix more than that to be applied within 2 hours limit. The excessive quantity will turn into being cured condition which cannot be applied.
- Apply only to clean, dry, oil-free surfaces.
- Keep the container of product firmly closed in times of not in use to prevent evaporation of oil and surface skinning.

Application Method

- Pour SHC 107-77 A and B into the clean container and agitate and then add C slowly and stir well to be homogenous. As the mixing heat occurred by excessive agitating shortens pot life and thereby causes fast curing of product, stir well so slowly.
- Apply to both side of substrate to be applied evenly and homogenously.
- Apply product at a thickness of 1.6 ~ 6.4 mm in wet, which is equivalent to 3~12 kg/m².
- This application provides dry film thickness of 1.6 ~6.4 mm.
- As rough or porous surfaces require more products, higher built thickness is recommended.
- In case of applying on the metal line, remove not only the foreign substrate or oil completely but also sand blasting and chemical treatment should be followed to ensure the most adhering strength.

Tools

- Use clean trowel.
- Be mindful to have uniform thickness using the tools.

Clean up

- As dried product is too difficult to remove, clean them before drying.
- After dried, use mineral spirits or chlorinated solvent, once cured, employ strong solvent like xylene to clean the equipment.