

# MAX BOND Medium Viscosity A/B

## Viscosity Comparison Chart

MATERIAL	VISCOSITY (centipoises)
Water @ 70° F	1-5
Blood or Kerosene	10
Anti-Freeze or Ethylene Glycol	15
Motor Oil SAE 10 or Corn Syrup	50-100
Motor Oil SAE 30 or Maple Syrup	150-200
Motor Oil SAE 40 or Castor Oil	250-500
Motor Oil SAE 60 or Glycerin	1,000-2,000
Corn Syrup or Honey	2,000-3,000
Blackstrap Molasses	5,000-10,000
Hershey Chocolate Syrup	10,000-25,000
Heinz Ketchup or French's Mustard	50,000-70,000 THIXOTROPIC
Tomato Paste or Peanut Butter	150,000-200,000 THIXOTROPIC
Crisco Shortening or Lard	1,000,000-2,000,000
Caulking Compound	5,000,000-10,000,000
Window Putty	100,000,000

## Physical and Mechanical Properties

Density (Mixed)	1.10 g/cc
Form and Color Cured	Translucent Straw Color
Shelf Life	12 Months
Viscosity Mixed	15,540 cPs @ 77°F (25°C)
Mix Ratio	Equal parts by weight or by volume
Working Time	120 Minutes @ 77°F(25°C 200 gram mass)
Peak Exotherm	180 °F to 190°F 200 gram mass
Cure Time	36 Hrs. Minimum <i>Ultimate properties achieved after 7 Days Cure</i>
Accelerated Cure Schedule	2 Hrs. @ room temperature plus 120 min. @ 212°F (100°C)

**Samples and specimens were vacuumed and cured for 24 Hrs. @ room temperature plus 120 min. @ 212°F (100°C)**

Hardness	85 to 90 Shore D
Tee-Peel Strength	6.3 Pounds Per Inch Width
Compressive Strength	15,800 psi @ 77°F (25°C)
Tensile Shear Strength	4,100 psi @ 77°F (25°C) 2,200 psi @ -112°F (-80°C) 1450 psi @ 212°F (100°C)
Elongation	2.3% Maximum Yield
Tensile Strength	8500 psi (Ultimate @ break)
CHEMICAL RESISTANCE TEST 10 Day Soak Test @ 77°F (25°C) 3% Salt Water Sulfuric Acid 30% Nitric Acid Ammonia 10% Sodium Hydroxide Anti-Freeze Motor Oil Soak Skydrol	WEIGHT CHANGE % 1.231.93.83.710.00 No Effect No Effect No Effect
Specimen Cure Cycle And Condition	7 days room temperature Plus 2 hours 250F Post Cure

### **ELECTRICAL PROPERTIES**

Volume Resistivity	2.7 x 10 <sup>12</sup> Ohms-cm ( - cm)
Dielectric Strength	510 Volts/Mil @ 60 Hz.
Dielectric Constant	3.23 @ 60 Hz

### **SERVICE TEMPERATURE**

**- 67 °F to 230 °F or - 55 °C to 110 °C**