MAX 1618 A/B

PHYSICAL PROPERTIES

Density	1.10 g/cc +/- 0.03 grams per cubic centimeter Part A 0.98 +/- .05 grams per cubic centimeter Part B 1.09.+/-.03 grams per cubic centimeter Mixed
Pounds per Gallon Mixed	9.07 +/- .02 Pounds Per Gallon
Form and Color	PART A = Clear Liquid Gardner Color Scale <1 (Similar to Glycerin or Pure water) PART B = Clear Liquid Gardner Color Scale <1 (Similar to Glycerin or Pure water) MIXED = Clear Gardner Color Scale 1-2 (Cured specimen 50 grams Mass)
Viscosity	PART A = 980 to 1040 cPs @ 25ºC PART B = 300 to 310 cPs @ 25ºC MIXED = 337 to 420 cPs @ 25ºC
Mix Ratio	100 Parts “A” to 50 Parts “B” By Weight Or 2:1 By Volume
Working Time	30 Minutes @ 25ºC (300 gram mass)
Peak Exotherm Temperature	174ºC (300 gram concentrated mass) after 50 minutes
Handle Time	6 – 8 Hours Set to Touch, 10 Hours Green Strength
Maximum Operating Temperature	95ºC
Glass Transition	105ºC
Full Cure Time	36 Hrs. Minimum @ 25ºC
Accelerated Cure Schedule	4 hours at 25ºC or until dry to the touch plus 60 Minutes @ 110ºC

Mechanical Properties

Hardness	87 +/- 5 Shore D
Tee-Peel Strength	5.7 Lbs Per Inch Width Polycarbonate
Tensile Shear Strength	2,300 psi @ 25°C (77°F)
6063 T4 Aluminum	1,800 psi @ -80°C (-112°F)
Overlap Shear	550 psi @ 100°C (212°F)
Elongation	6.0% @ 25°C (77°F)
Flexural Strength	13,500 psi @ 25°C (77°F)
Flexural Modulus	500 psi @ 25°C (77°F)
Compressive Strength	8,200 psi @ 25°C (77°F)
Heat Distortion Temp	80°C (176°F)

Electrical Properties

Volume Resistivity	2.7 x 1012 Ohms-cm (Ω-cm)
Dielectric Strength	510 Volts/Mil @ 60 Hz