

BONDLINE 6500

HIGH PERFORMANCE ADHESIVE

Bondline 6500 is a rapid cure structural epoxy adhesive, offering 1 hour work life. This low outgassing adhesive is used on assemblies requiring strong bonds to materials like ferrite, steel, aluminum and glass.

ADHESIVE PROPERTIES

Color	Clear
Viscosity*	1500 cps
Work Life @ 25°C	1 hour
Hardness (Shore D)	80
Cure Options	5 minutes @ 125°C or 20 minutes @ 65°C or
Service Temperature Range	-55°C to 125°C
Lap Shear Strength @ 25°C (Al to Al)	4000 psi
Specific Gravity	1.15
Glass Transition Temperature (Tg)**	81°C
Outgassing @ 85°C	9 ppm
@ 105°C	34 ppm
Coefficient of Thermal Expansion**	
Below Tg	52×10^{-6} in/in/°C
Above Tg	176×10^{-6} in/in/°C
Shelf Life	6 months @ -40°C
Availability	Net volume 1 cc to 2.5cc, available in disposable 3cc syringes.

Adhesive properties are not intended to be used as specification limits.

**Cured 30 minutes @ 100°Ct

* Brookfield DV II+, CP 51 Spindle, 50 rpm, 20°C

GENERAL INSTRUCTIONS FOR ADHESIVE STORAGE/ USE

FROZEN STORAGE

This adhesive must be stored at (minus) -40°C (°F) or colder at all times. Storing this adhesive at temperatures warmer than (minus) -40°C (°F) will shorten its work life.

DO NOT RE-FREEZE adhesive that has already been thawed!

THAWING PROCESS

Remove frozen syringe from freezer. Place in vertical position with lure lock end pointed down during thaw.

Adhesive must reach room temperature before use. See chart below based on syringe size.

SYRINGE SIZE	THAW TIME
1cc	5 minutes
3cc	10 minutes
5cc	15 minutes
10cc	20 minutes

SURFACE PREPARATION

Make sure that all surface areas to be bonded are free of any contamination. If parts have been solvent cleaned make sure solvent is dried before applying adhesive

APPLICATION

Check the work life of the adhesive, on the technical data sheet. Adhesives must be used within its work life .The adhesives' properties will change if it is used past the allowable work life. Apply adhesive using dispensing equipment of choice. Contact Bondline Technical Service with questions about dispensing adhesives.

CURE

Choose a Cure Option (time & temperature) from the Bondline technical data sheet. Preheat the oven to the temperature of the selected cure option. For optimum cure, do not deviate from the selected cure option. Be sure to allow additional time for holding fixtures to reach cure temperature. Avoid opening oven doors during cure. Large fixtures and/or multiple fixtures may require extended cure time.

SAFETY

Review the adhesive Safety Data Sheet (SDS) before using. Refer to the SDS in case of emergency. Always wear protective gloves and goggles while handling adhesives. Only work with adhesives in well-ventilated areas, with curing ovens vented outside. For industrial use only.

TECHNICAL SERVICE CONTACT

For recommendations and help with any aspect of adhesive applications please contact the Bondline Technical Service Department (408) 830-9200, or via email: info@bondline.net or visit our website, www.bondline.net

CAUTION: For industrial use only. People with sensitive skin may have a reaction to this adhesive. Avoid skin contact. Wash all areas with soap and water immediately if contact does occur. It is important to refer to Safety Data Sheet (SDS) OSHA for more details.

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