

BLUE OX EP 540 is a one component, heat curable thixotropic paste epoxy adhesive. The thixotropic characteristics of this product allow it to wet the surfaces between mating faces of substrates, while maintaining non-sag characteristics in applications where the product must remain in place before curing.

BLUE OX EP 540 is particularly well suited for use on electric motor commutators. It is recommended anywhere an adhesive with exceptional resistance to water, humidity, thermal cycling, vibration, heat and solvents is required.

Typical Applications:

- Encapsulating commutators
- Bonding motor magnets
- Loudspeaker magnet assembly
- Structural bonding
- Filter end cap and side seam assembly

PHYSICAL PROPERTIES

Standard Color	Gray
Viscosity	78,000 cps
Durometer	82 Shore D
Specific Gravity	1.55 gm/cc
Dielectric Strength	300-480 volts/mil
Operating Temperature	-40°F to 400°F
Lap Shear	
AL/AL	2500 psi
Steel/Steel	3000 psi

CURE SCHEDULE

250°F	10 minutes
300°F	2 minutes
350°F	1 minute

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