

BLUE OX EP 640 is a two component 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. Combined with a static mixer tip, **BLUE OX EP 640** provides fast fixture speeds without compromising positioning time.

BLUE OX EP 640 is recommended anywhere an adhesive with exceptional resistance to water, humidity, thermal cycling, vibration, heat and solvents is required.

Typical Applications:

- Structural bonding
- Encapsulating commutators
- Bonding motor magnets
- Aluminum lap shear joint bonding
- Loudspeaker magnet assembly
- Structural bonding
- Filter end cap and side seam assembly
- Fiberglass structural bonding

PHYSICAL PROPERTIES

Standard Color	Gray
Viscosity	Paste
Shore D	75-80
Specific Gravity	1.18 gm/cc
Operating Temperature	-40°F to 400°F
Lap Shear AL/AL Fiberglass	>2500 psi Substrate Failure

CURE SCHEDULE

Pot Life: 100 grams	7-10 minutes at 75°F
Fixture: 100 grams	30 minutes at 75°F

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