



1001 Trout Brook Crossing
Rocky Hill, CT 06067-3910
Telephone: (860) 571-5100
FAX: (860) 571-5465

Product Description Sheet

Hysol® Product 615

Industrial Products, December 2001

Description

Loctite® Hysol® 615 is epoxy paste adhesives used in many applications where fast cure rates and gap filling are needed. Hysol 615 bonds a variety of materials including metals and plastics.

Features

Quick Set
High Strength
10-20 minute handling
Sandable
Non-Conducting

Application: Bonding surfaces should be clean and dry. Once the adhesive is applied, the bonded parts should be held in contact until the part has developed handling strength. It is not necessary to clamp the parts unless movement during cure is likely.

Cure: Complete cure is obtained after 24 hours at room temperature. HYSOL 615 will achieve handling strength in 10-15 minutes at 77°F (note: this can vary with different bond configurations). Hysol 615 can also be fully cured with heat such as; 5-20 minutes at a maximum of 150°F temperature.

Clean Up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

Packaging

3.2 oz. Epoxi Patch Tube Kits
One Gallon, systems

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 20 grams mins	--	--	10
Color	Blue	White	Light Blue
Viscosity, cP	600,000 to 800,000	100,000 to 180,000	--
Specific Gravity	1.56	1.58	--
Mix Ratio			
By weight	1	1	--
By volume	1	1	--

Typical Properties	Typical Value
Hardness, Shore D	65

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
24 Hours @ 77°F	77	2500
	140	800
	180	250

Handling

Mixing: This product requires mixing two components together just prior to application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be close to room temperature.

Application

Mixing - Bulk: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly until the color and consistency are uniform. EPOXI-PATCH® Tube Kits have been designed so that squeezing **EQUAL LENGTH BEADS of Part A & Part B** will give proper ratio. Ratios given above can be used for measuring larger amounts. Mixing the adhesive just prior to use is recommended. Heat buildup during or after mixing is normal. Do not mix quantities greater than one pound as dangerous heat buildup can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat buildup.

NOT FOR PRODUCT SPECIFICATIONS
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.
PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
ROCKY HILL, CT FAX: +1 (860)-571-5473 DUBLIN, IRELAND FAX: +353-(1)-451-9959

Loctite and Hysol are Trademarks of Loctite Corporation USA