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## T-249-4

# Two Part Epoxy Laminating System

Star Technology, Inc.'s **T-249-4** epoxy system is a two-component epoxy used for laminating and potting various substrates. **T-249-4** has been used successfully to bond the following items: expanded polystyrene beadboard, aluminum, lauan, Melamine/Formica, Masonite, cold rolled steel (CRS), and plywood.

Versabond **T-249-4** has found uses in laminating exterior and interior steel doors, gasoline station canopies, insulated building and roof panels, RV side panels and roofs, and potting of various electronic components.

Versabond **T-249-4** can be cleaned up by using mild solvents including vinegar.

### TYPICAL PROPERTIES

	<u>TEST METHOD</u>	<u>VALUE</u>
Viscosity (centipoise)	ASTM D2393	
Component A:		~60,000 cps
Component B:		~60,000 cps
Mixed:		~60,000 cps
Density (lbs./gal.)	ASTM D1475	
Component A:		~14
Component B:		~14
Mixed:		~14
Color		
Component A:		Grey
Component B:		Black
Mixed:		Grey
Mix Ratio, Resin to Hardener		
Parts by Weight		100:50
Parts by Volume		100:50
Pot Life at 23°C (minutes)	ASTM D2471	60
Ultimate Cure Time at 23°C (hours)		48
Shore Hardness (Type D)	ASTM D2240	80 min
Shear Strength (psi)		
24 hours at 23°C	ASTM D638	1800psi
Aged (336 hours at 100°C)		1200psi
Tg (°C):		100°C

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