



TECHNICAL DATA SHEET

Formulated Resins

EASYPOXY® K-230

DESCRIPTION

EASYPOXY K-230 Optically Clear Kit is a two-component, 100% solids system that is used in thin films to bond glass. This adhesive is recommended for bonding substrates with widely different coefficients of expansion because of its cured resiliency. This same resiliency favors bonding elastomeric to rigid substrates. Its neutral color is an advantage where the bond line should not be noticeable.

Features	Benefits
Clear	Less noticeable bond line
Paste	Non-flow

CHARACTERISTICS AND PROPERTIES

Table 1 | Product Description

Property	Resin PART A	Curative PART B
Viscosity @ 25°C (77°F)	Light Paste	Light Paste
Specific Gravity @ 25°C (77°F)	1.17	1.08
Color	Clear	Light Amber
Solids Content	100%	100%
Mix Ratio, Parts by Weight (A/B)	100	45
Shelf Life, from date of manufacture in original unopened containers	18 months	18 months

Table 2 | Cured Properties

Property	Value
Color	Clear
Hardness, Shore D	80
Flexibility	Semi-Flexible
Tensile Strength, psi	
Etched AL/AL, 25°C (77°F)	2450
Etched AL/AL, -55°C (-67°F)	1360
Etched AL/AL, 82°C (180°F)	1520
Linear shrinkage, %	0.67
Water Absorption, 24 hr. immersion @ 25°C (77°F), %	0.37
Flexural Strength, psi	10,000
Compressive Strength, psi	18,000
Thermal Conductivity, cal/sec/cm ² /°C/cm x 10 ⁻⁴	50
Fungus Resistance	Non-nutrient
Values are average, based on several determinations and are not intended for use in preparation of specifications	

Table 3 | Electrical Properties

Property	Value @ 25°C (77°F)
Dielectric Constant, @ 1 KHz	4.60
Dissipation Factor, @ 1 KHz	0.012
Dielectric Strength, ohm-cm	4.0 x 10 ¹³

SURFACE PREPARATION

Apply to dry, oil-free surfaces. Remove mold releases from plastic surfaces. When bonding metals, degrease and dry. Chemical etching of the metal surface gives optimum results. For specific recommendations, request Cytec's **Surface Preparation Guide**, Bulletin AC-107.

PROCESSING PARAMETERS

Mix equal length beads from the convenient two-tube kit, or in bulk packages mix 100 pbw Part A and 45 pbw Part B.

Pot Life of mixture is 60 minutes at 25°C (77°F), and cure is achieved in 24-36 hours at 25°C (77°F). Cure can be accelerated by heating at 65°C (149°F) for 2 hours.

Apply adhesive with spatula or stiff brush to each surface. Apply light pressure to ensure good wetting and contact of the bonded surfaces.

Clean equipment before the adhesive hardens; a good hydrocarbon solvent is recommended.

In case of crystallization:

These materials may crystallize. If this occurs, place tubes or can into a container and fill with warm tap water. Do not submerge container. Let stand until the epoxy returns to a liquid state. It may be necessary to replenish the warm water to accelerate the melting process. Once melted remove the tube or container from the water bath and let it stand until the material returns to room temperature before using.

CAUTION

For Industrial Use Only! Always read the Material Safety Data Sheets before using. Uncured materials contain epoxy resins, which are strong eye and skin irritants. Absorption through skin or breathing of vapors may cause serious health conditions. Avoid skin contact. Wear neoprene or nitrile gloves if hand contact is a possibility. If skin contact does occur, clean immediately with denatured alcohol, followed with soap and water. Use only in a well-ventilated area, or wear respirator with organic vapor cartridges, particularly if heated. Always ventilate and provide respiratory protection for sanding or grinding.

HANDLING AND STORAGE INSTRUCTIONS

EASYPOXY K-230 is available in quart, gallon, 5-gallon, and 55-gallon units, as well as 4.5 oz. repair kits.

See the **Comparison Chart for the EASYPOXY® Series** to compare properties.

CAUTION: Responsible handling of Cytec Industries Inc. products requires a thorough review of safety, health, and environmental issues prior to use. Review the Material Safety Data Sheets(s) for the specific Cytec Industries Inc. product(s) and container label information before opening containers. Ensure that employee exposure issues are understood, communicated to all workers, and controls are in place to prevent exposures above Permissible Exposure Limits (PELs). Review safety and environmental issues to be certain controls are in place to prevent injury to employees, the community, or the environment, and ensure compliance with all applicable Federal,

State, and Local laws and regulations. For assistance in this review process, please call your Cytec Industries Inc. representative or our office noted below.

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