



FDA Epoxy Series

Product	AL419FD	AL420FD	AL421FD	AL422FD	AL423FD	AL424FD	AL425FD	AL426FD	AL427FD	
Base	E p o x y									
Color	A v a i l a b l e i n D i f f e r e n t C o l o r s									
Solvent	N o n e (1 0 0 % S o l i d s)									
Density @ 25°C (g/ml)	0.97	0.97	0.97	0.96	0.96	0.96	0.96	0.97	0.97	
Viscosity @ 25°C (poise)	500	310	120	8.5	12	9.0	9.0	9.0	11	
Mix Ratio (resin:hardener)	1:1	2:1	2:1	2:1	10:3.5	2:1	2:1	2:1	10:1.4	
Gel Time @ 25°C (mins.)	180	120	200	135	40	115	70	385	30	
Cure Schedule	12 Hours @ 25°C + 1 Hour @ 60°C			2 – 7 Days @ Ambient Conditions					4 Hours @ 25°C	
				Or 2 Hours @ 140°F + 1 Hour @ 212°F					Or 1 Hour @ 60°C	
Service Temp. (°C)	-40 to 165	-40 to 165	-40 to 165	-40 to 165	-40 to 165	-40 to 165	-40 to 165	-40 to 165	-40 to 165	
Hardness SD	78	80	79	79	78	79	79	78	80	
Tensile Shear Strength Al-Al (psi)	2,700	2,800	2,800	3,000	3,000	2,900	2,800	2,700	2,800	
Flexural Strength (psi)	320,000	239,000	326,000	273,000	280,000	282,000	275,000	278,000	280,000	
Tensile Strength (psi)	6,000	6,100	6,400	6,850	7,030	6,550	6,600	6,500	6,400	
Flexural Modulus (psi x 10 ³)	320	239	326	330	273	280	278	285	300	
% Elongation	8.0	5.0	3.8	2.0	1.9	1.9	2.0	2.0	4.0	