



**ALFA INTERNATIONAL**

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**OPTICS & FIBER OPTICS EPOXIES SELECTOR GUIDE**

Product	Mix Ratio by Weight Resin/Curative	Viscosity typical@25°C CPS	Pot Life 25 GM @ 25°C	Specific Gravity gm/cc	Cure Schedule	Lap Shear Strength AL-AL PSI	Hardness Shore D	Index of REF nD
AL 400	100/25	100	100 gm-30 min 25 gm-60 min	1.16	RT/overnight or 65° C/1 hour	1700	82	1.54
AL 401	100/35	260	1 day	0.95	1.5 hour @ 80°C or 2 days @ RT	1800	82	1.564
AL 402	100/10	3000	5 hours @ RT	1.17	30 min @ 80°C or 5 min @ 120°C	1600	86	1.56
AL 403	100/28	300	20 min	1.15	16 hours @ RT or 1 hour @ 65C°	750	72	1.511
AL 404	100/10	400	8 hours @ RT	1.14	5 min @ 150°C or 10 min @ 120°C	2440	84	1.561
AL 405	100/28	200	2.5 hours @ 25°C	1.2	16 hours @ RT or 2 hours @ 60°C	1800	83	1.552
AL 408	100/12	1890	3 hours @ RT	1.15	15 min @ 100°C or 1 min. @ 150°C	1900	84	1.55