

**Product
Bulletin**

AL427FD Two-Part Epoxy Resin

GENERAL DESCRIPTION

AL427 is a two-part, heat-resistant and low exothermic epoxy adhesive formulation. It is a 100% solid epoxy adhesive, with superior chemical resistance and shear strength. AL427 contains a thixotropic agent, which impedes thinning out of the material during heat cure when properly mixed and cured.

ADVANTAGES

- Develops a strong bond
- Durable to numerous construction materials such as metals, glass, rubber, ceramics, concrete and phenolic plastics
- Provides premium resistance to water, salt solutions, galvanic action, acids, alkalis and most chemicals

APPLICATION

1. Clean and thoroughly dry all surfaces to be bonded
2. Follow mixing-dispensing instructions as shown on package
3. Apply a thin coat of the mix (not more than 0.010 inches) by brush, spray, or roller to the surfaces to be bonded
4. Gently press surfaces firmly together

SPECIFICATIONS

Base	Epoxy
Solvent	None
Flammability	Non-Flammable
Color	Available in a variety of different colors
Solids Contents	100%
Coverage	250-350 ft ² /gal
Shelf life	2 years, closed packaging, unopened
Service Temperature	-40°C to 165°C
Hardness SD	80
Tensile Shear Strength Al to Al	2800 psi
Passes 10 day humidity test mil std 8:0 above 95% with condensation	

Curing times for various temperatures are as follows:

1. 2-7 days @ ambient temp.
2. 2 hrs. @ 140°F + 1 hr. @ 212°F.

WORKING TIME

AL427's pot life and exotherm are dependent upon several factors: mass of resin, amount of catalyst used, ambient temperature and type of equipment used, among others. A 200 grams mix will have a pot life of approximately 30 minutes at room temperature.

FDA INFORMATION

Title 21 of the Code of Federal Regulations (CFR) permits and regulates the use of epoxy resins such as AL427FD - Part A as an indirect food additive in food contact applications. Some of the sections of 21 CFR that support the above are 175.105, 175.300, 175.320, and 176.17.

AL427FD - Part B complies with FDA regulations listed in the Title 21 of the CFR, Sections:

- 175.105 (c)(5) Adhesives
- 175.300 (b)(3)(viii)(c) Coatings - adjunct for epoxy resins
- 176.170 (b)(1) Components of paper and paper-board in contact with aqueous and fatty foods.
- 175.300 (b)(xxxii) Side seam cements

AL427FD - Part B will comply with the above regulations as long as it is used only with other approved materials, and as long as the finished product conforms with extractives limitations for the use-situation as specified in those regulations.

PACKAGING INFORMATION

AL427 is available in 50 grams divided plastic bags and in large unit (two-container) pint, quart, and gallon kits. Each kit consists of the correct amount of the specified epoxy material and curing agent hardener formulations, each supplied in separate containers with complete proportioning, use and cure instructions.