



LAMINATING
EPOXY

ADHESIVES

PROCESS
EQUIPMENT

Technical Data

M1007 Resin/M2012 Hardener

Fast Cure Adhesive

M1007/M2012 is a fast curing epoxy adhesive for general purpose gluing or bonding applications. This adhesive will bond wood, frp, concrete and some thermoplastics to themselves or one another. Working time is approximately 3 minutes and cure to clamps off is approximately 10 to 12 minutes at 72° F. The adherends will be self-supporting at this stage of cure, but not ready to be stressed.

SURFACE PREPARATION

Surfaces should be clean and free of contaminates. Sandblast, solvent wipe or abrade surfaces as appropriate for the substrate to be bonded.

MIXING

Mix the resin and hardener in the proportions described below. Stir thoroughly to ensure complete mixing. Apply to one or both mating surfaces of joint.

We recommend building and testing samples using proposed materials and manufacturing processes to confirm working and curing characteristics under anticipated use conditions.

HANDLING CHARACTERISTICS *(Not for specification purposes)*

Property

Mixed Viscosity @ 72°F 10,000 cps

Mix Ratio (M1007:M2012)	Target
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by weight	1:1
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by volume	1:1
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Pot Life (100g mass)

@ 72° F 3 min.

Cure Time	72° F
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Clamps Off Cure.	10-12 min.
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Full Cure	6-8 hours
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M1007/M2012

PHYSICAL PROPERTIES

Compression Yield (psi) ASTM D-695	9,676
Shore D Hardness ASTM D-2240	60

ADHESION TO VARIOUS SUBSTRATES (psi) ASTM D-4541

Ash*	1,360
Mahogany*	1,422
White Oak*	1,299
Yellow Pine*	1,226
PVC**	534
Lexan**	1,169
Plexiglass**	501
ABS**	1,047
Polyester FRP**	812
Aluminum***	1,218

* Sanded with 100 grit prior to adhesive application

** Sanded with 50 grit prior to adhesive application

*** Sandblasted and chemical etch prior to adhesive application