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## Technical Data Sheet

# Magnobond 7500 A/B Magnolia 7500 A/B

### *Description*

Magnobond 7500 A/B is a two-part, low viscosity epoxy resin/adhesive having good peel strength, high temperature properties and a long pot-life. After setting-up at room temperature, Magnobond 7500 A/B must be cured at 200° F for one to two hours to complete the cure.

### *General Uses:*

Magnobond 7500 A/B is often used with dry glass or carbon fiber as a wet lay-up resin for composite structure reinforcement and construction. Other adhesive applications include:

- Wet lay-up and Composite-to-Composite bonding
- Metal and/or Composite repair
- Structural adhesive bonding in areas that require flexibility and good vibration resistance
- Can be used for resin transfer molding (RTM) applications

### *Features:*

- Excellent tensile lap shear and peel at wide range of temperatures
- Good physical properties in excess of 250° F
- Excellent chemical, moisture and environmental resistance
- 100% solids (does not contain any solvents)
- Long pot-life (3 ½ to 4 hours)
- Can be meter mixed and dispensed (with agitation of the Part B)
- Magnobond 7500 A/B Part A is an off white in color paste. Part B is an amber liquid.

## Properties

Property	Magnobond 7500 A/B
Cure Schedule	18 Hours @ Room Temperature Plus 2 Hours @ 200° F
Mix Ratio - Parts By Weight (Part A : Part B) Parts By Volume (Part A : Part B)	100:46 2:1
Pot Life, 3 ounces	> 3 Hours
*Shelf Life (Part B must be mixed prior to mixing with Part A).	Part A: 12 Months at 75°F Part B: 12 Months at 75°F
Specific Gravity	Part A: 1.1 Part B: 1.0 Mix: 1.1
Viscosity @ 77 °F	A: (6/10) 21,000 cps B: (3/10) 450 cps Mix: (6/10) 3,200 cps

### Typical Cured Properties (after 1 to 2 hours at to 200° F)\*

	Cure 2 hrs at 200F
<b>ASTM D 1002 Lap shear Strength (psi) 2024 T-3 Aluminum FPL Etch at:</b>	
- 67° F	3,500
75° F	4,000
180° F	2,750
250° F	1,500
300° F	900
400° F	400
<b>ASTM D 1002 Tensile Lap Shear Strength (psi) @ RT after Soak for 7 Days in:</b>	
Jet A Fuel	4,000
MIL H 83282	4,000
MIL L 7808J	4,000
MIL H 5606	4,000
MIL L 23699	4,000
<b>ASTM D 1002 Tensile Lap Shear Strength (psi) at:</b>	
RT after 30 day soak @125F / 85% humidity	4,000
180F after 30 day soak @125F / 85% humidity	2,500
<b>ASTM D 1876 T-peel Strength (pli) at:</b>	
RT	10
180° F	15
RT after 7 days in Jet A fuel @ RT	15
RT after 7 days in MIL H 83282 @ RT	15
RT after 7 days in MIL H 5606 @ RT	15
RT after 7 days in MIL L 7808J @ RT	15
RT after 7 days in MIL L 23699 @ RT	15
RT after 30 day soak @125F / 85% humidity	15
180F after 30 day soak @125F / 85% humidity	15

### ***Other Typical Cured Properties and Information***

#### **Coefficient of thermal expansion (Magnolia Plastics LWR 07-4957):**

- $76 \times 10^{-6}$  in./in./°C

#### **Compressive strength at RT (0.5 x 0.5 x 1.0 cured at 200°F):**

- Ultimate: 10,000 psi
- Compressive Modulus: 300,000

#### **Other cured physical properties:**

- Ultimate Flexural Strength (psi): 9,717
- Ultimate Tensile Strength (psi): 6,062
- Tensile Modulus (psi): 301,156
- Elongation, %: 3.5

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