



APTEK LABORATORIES, INC.

ISO 9001 / AS9100 Certified

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TECHNICAL DATA & INFORMATION

APTEK® 6513-A/B

Versatile, fast set adhesive

PRODUCT DESCRIPTION

APTEK 6513-A/B is a transparent, two component, general purpose, semi-rigid, paste adhesive for bonding to steel, aluminum, wood, concrete, glass, ceramics, brass, and a variety of plastics. It is specifically designed to fully cure at room temperature or can be accelerated with moderate heat.

KEY FEATURES AND BENEFITS

- Fast set - Reaches 90% of properties in 24 hours at 25°C (77° F)
- Available in convenient dual cartridge mixer/dispensers for field repair applications.
- Smooth, thixotropic consistency for easy handling and minimum sag.
- Contains no diluents or solvents to minimize formation of voids during cure.
- Capable of curing at ambient temperatures as low as -7°C (20°F).

HANDLING INFORMATION

Mix ratio, parts by weight or volume	100 (6513-A)/100 (6513-B)
Gel time @ 25°C (77°F), 45% RH, 10 gms, minutes	5-10

SURFACE PREPARATION

- Thoroughly clean surface area with detergent and water to remove all dirt, grease, or wax.
- Using 40-60 grit paper, thoroughly sand all surfaces to be bonded.
- Clean all parts with a solvent such as methyl ethyl ketone (MEK) or isopropyl alcohol (IPA).
- All surfaces must be dry before applying adhesive.

MIXING INSTRUCTIONS

1. For hand mix operation: weigh out equal amounts (up to 5 grams each) of Part A and Part B into a clean, dry container or onto a clean, dry, flat mixing surface. Thoroughly mix Part A and Part B using a clean metal spatula or other suitable blade, including a wooden tongue depressor.
2. For dual cartridge kits the adhesive is mixed and dispensed in one operation. See handling instructions included with kit.

Application Notes:

1. **IMPORTANT** - **APTEK 6513-A/B** is a **fast set** adhesive therefore do not mix more than is needed.
2. Work life depends on temperature and mass. If more material is mixed together, work life will be drastically reduced.

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3. Parts must be held in place with clamps or tape until a firm set is achieved, 30-45 minutes for most parts. The length of time required for the adhesive to achieve a firm set depends on the temperature of both the work area and the parts at time of bonding.

CURE SCHEDULE

5-7 days @ RT
or
RT Gel + 1 hour @ 65°C

TYPICAL PROPERTIES

(values not to be used for specification purposes)

<u>CHARACTERISTICS</u>	<u>6513-A</u>	<u>6513-B</u>	<u>TEST METHOD</u>
Color	Hazy	Clear	Visual
Specific gravity	1.17	1.16	ASTM D-1475
Viscosity, @25°C,	Paste	Semi-paste	ASTM D-1824
Flash Point, °C	>125	>125	ASTM D-92
Shelf life @ 25°C, mos factory sealed containers	12	12	

<u>CURED PHYSICAL PROPERTIES</u>	<u>APTEK 6513-A/B</u>	<u>TEST METHOD</u>
Hardness, Durometer D		
cured 1 hr @ 25°C	70	ASTM D-2240
cured 24 hrs @ 25°C	77	ASTM D-2240
cured 7 days @ 25°C	80	ASTM D-2240
Lap shear, Al to Al, psi @ 25°C (50 grit sanded/solvent wiped)		
cured 1 hr @ 25°C	1100	ASTM D-1002
cured 24 hrs @ 25°C	2250	ASTM D-1002
cured 7 days @ 25°C	2600	ASTM D-1002

SAFETY AND FIRST AID

APTEK 6513-A is safe to handle when used properly. Avoid contact with skin and eyes and use in a well-ventilated area and avoid breathing vapors. In case of eye contact, flush with fresh clean water for at least 15 minutes; for skin contact, wash thoroughly with soap and water. If swallowed, do not induce vomiting, drink at least one pint of water and call a physician. Refer to Material Safety Data Sheet for more details.

APTEK 6513-B is considered a slight irritant however, may cause eye and skin irritation on prolonged and repeated exposure. Inhalation of vapors may be harmful in large amounts. Avoid skin and eye contact and use in a well-ventilated area. In case of eye contact or skin contact, flush profusely with water. If swallowed, do not induce vomiting, dilute with at least one pint of water and contact physician. Refer to Material Safety Data Sheet for more details.

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