



53 C Otis Street  
West Babylon, NY 11704  
Tel. 631-920-5079 Fax. 631-920-0503  
E-mail SalesSET@optonline.net  
www.SET-mfg.com

## Set-Bond 5000

### General Purpose Epoxy Casting Compound

**Set-Bond 5000** is a fast curing epoxy adhesive that develops handling strength in about 3 to 5 minutes and will cure rapidly in thin films at low temperatures. It is an excellent industrial adhesive characterized by a non-critical mixing ratio. **Set-Bond 5000** will readily bond most plastics, metals, ceramics, paper, wood and some rubbers. It is ideally suited to applications in electronics, and general product assembly.

#### Physical Properties

<u>Liquid</u> Appearance	Clear (mixed)
Viscosity	14,000 cP
(cP @ 68°F)	
Peak Exotherm	150°C
100 gram preparation	
Shelf Life @40°F	12 months unopened
Odor	Mild
Specific Gravity	1.16 gm/cc

#### Curing Properties

Gel Time	3 minutes
100 gram preparation	

#### Solid

Shore D Hardness	15
10 minutes	52
20 minutes	72
1 hour	79
24 hours	
Operating Temperature	-40°F to 200°F

#### Performance Results

<b>Shear Strength (ASTM D1002)</b>	Strength (psi)
Substrate/Surface Preparation	
CRS, Abraded	2000
2024-T3 Aluminum, Acid Etched	2400
SS 304, Abraded	2200
Electrogalvanized Steel, IPA wipe	1900
ABS, IPA wipe	570
PVC, IPA wipe	490 (material failure)
Brass, Abraded	1900
Copper, Abraded	1200

Read Warranty on Back of Technical Data Sheet

**General Instructions:** Surfaces to be bonded must be clean, dry and free of other contaminants. Measure out equal amounts of parts A and B and stir until homogenous or use a static mixing nozzle. Apply the uniform mixture to both surfaces. An optimum bond line is 5 mils. Allow to cure while being held in place with light clamping. Adhesive will set in 3 to 5 minutes with handling strength developed in 5 to 10 minutes. Majority of cure will take place within 1 hour with full cure in 24 hours.

**Storage:** Product should be stored in a cool dry place out of direct sunlight. Shelf life is 12 months when properly stored in unopened, original containers.

## **Warranty**

**Silicone & Epoxy Technology** accepts no liability, in negligence or otherwise, in this communication. Under no circumstances shall the company be liable for incidental, consequential or other damages from alleged negligence, breach of warranty, strict liability or any other theory, arising out of the use or handling of this product. The sole liability shall be the purchase price of the product. You should test the material to determine if the material is suitable, and/or claims are valid, in your particular circumstances. None of the possible or suggested uses of the materials in this communication are licensed under any Silicone & Epoxy Technology patent covering such use or a recommendation for use of such materials in the infringement of any patent.

### **Silicone & Epoxy Technology**

Phone: 631-920-5079      Fax: 631-920-0503

Place Orders To: SalesSET@optonline.net

**www.SET-mfg.com**