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## Product Description Sheet

### Hysol® Product 907

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#### Description

Loctite® Hysol® 907 is a two component paste adhesive suitable for general purpose use. It is relatively insensitive to mix ratio and is tolerant of poorly prepared surfaces. The contrasting colors of the two components help identify when thoroughly mixed.

#### Features

Easy Mix  
Room Temperature Cure  
Color Coded  
Bonds a Variety of Substrates

#### Application

**Mixing - Bulk:** Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly until the color and consistency are uniform. EPOXI-PATCH® Tube Kits have been designed so that squeezing **EQUAL LENGTH BEADS of Part A & Part B** will give proper ratio. Ratios given above can be used for measuring larger amounts. Mixing the adhesive just prior to use is recommended. Heat buildup during or after mixing is normal. Do not mix quantities greater than one pound as dangerous heat buildup can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat buildup.

**Application:** Bonding surfaces should be clean and dry. Once the adhesive is applied, the bonded parts should be held in contact until the part has developed handling strength. It is not necessary to clamp the parts unless movement during cure is likely.

**Cure:** Complete cure is obtained after 24 hours at room temperature. HYSOL 907 will achieve handling strength in 3-4 hours at 77°F (note: this can vary with different bond configurations). Hysol 907 can also be fully cured with heat such as 2 hours at a 140°F or 1 hour at 180°F.

**Clean Up:** It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

#### Packaging

2.3 oz. Epoxi Patch Tube Kits  
Quart, One Gallon, Five Gallon systems

#### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).**

#### Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 200 grams mins	--	--	20
Color	Blue	Cream	Light Blue
Viscosity, cP	100,000	150,000	120,000
Specific Gravity	1.40	1.13	1.25
Mix Ratio			
By weight	100	80	--
By volume	1	1	--

Typical Properties	Typical Value
Tensile Strength, psi, ASTM D 638	3100
Modulus, psi, ASTM D 638	245,000
Elongation, %, ASTM D 638	2.4
CTE, ASTM D 696, in/in/ °C	45 x 10 <sup>-6</sup>
Hardness, Shore D	79

Electrical Properties	Typical Value
Dielectric Constant, MIL 1-16923. K 1kHz	4.58
Dissipation Factor, ASTM D 150 1kHz	0.076

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
24 Hours @ 77°F	-67	2300
	77	3000
	180	1000
	250	400

#### Handling

**Mixing:** This product requires mixing two components together just prior to application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be close to room temperature.

NOT FOR PRODUCT SPECIFICATIONS  
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PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.  
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