



4121 1:1 CARBON FIBER EPOXY

GENERAL DESCRIPTION

Emecole Metro 4121 gel and cure times are affected by ambient temperature and epoxy mass, or glue line thickness. Curing data is based on 72° F (22° C) ambient temperature. Warmer temperatures and a larger mass will increase cure speed, reducing cure time. Cure time is reduced by approximately one half with every 18° F (10° C) increase in temperature. A smaller mass or cooler temperature will reduce the cure speed. Always dispense adhesive at 70° F or above to assure the proper mix ratio.

TECHNICAL DATA

PROPERTIES

Emecole Metro 4121		Test Method
Mix Ratio (Resin:Hardener by weight)	1.0:0.86	_____
Mix ratio (Resin:Hardener by volume)	1.0:1.0	_____
Pot Life (of 70ml @ 720F)	8 min	ASTM C-881
Working Time (1/2' bead)	16 min	_____
Clamps Off Cure Time (1/16" bond line) @ 75°F	1.5 hrs	_____
Minimum Cure Temperature	45° F	_____

*The product will cure at temperatures as low as 45° F , however keep cartridges at 70° F or above when dispensing.

PROPERTIES (CURED)

Emecole Metro 4121		Test Method
Tensile Strength	5900 PSI	ASTM D-638
Tensile Elongation	10%	ASTM D-638
Compressive Yield	8540 PSI	ASTM D-695
Tensile Modulus (x103 PSI)	2.79	ASTM D-638
Flexural Strength	9750 PSI	ASTM D-790

PRODUCT DATA (cont'd)

TECHNICAL DATA (cont'd)

PROPERTIES (CURED) cont.

Emecole Metro 4121		Test Method
Deflection Temp	120° F	ASTM D-648
Shore Hardness		
1 day	D77	ASTM D-2240
2 weeks	D84	ASTM D-2240
Flexural Modulus (x105 PSI)	2.95	ASTM D-790
Onset of Tg by DSC	115° F	_____

WARRANTY

Recommendations concerning the performance or use of this product are based upon independent test reports believed to be reliable. If the product is proven to be defective, at the option of the Manufacturer, it will be either replaced or the purchase price refunded. The Manufacturer will not be liable in excess of the purchase price. The user will be responsible for deciding if the product is suitable for his application and will assume all risk associated with the use of the product. This warranty is in lieu of any other warranty expressed or implied, including but not limited to an implied warranty of merchantability or an implied warranty of fitness for a particular use.