

2112 INDUSTRIAL P.O. BOX 124  
HOWELL, MI 48843

**60F0639**  
**EPOXY ADHESIVE PART A**

[www.nyatex.com](http://www.nyatex.com)

rev. date: 10/11/2016

60F0639 is an excellent general purpose epoxy adhesive recommended for applications requiring durability, solvent & abrasion resistance, excellent adhesion to a number of substrates, 60F0639 should be used with epoxy curing agent 65F0641 Part B

**Designed Uses:**

For use on rigid multi-planed substrates. For bonding flock to ABS, polycarbonate, polystyrene plastics, wood, rubber and some metals. This epoxy gives latitude as well as a long open time. It can be applied in a variety of ways. This adhesive package can be tinted with colorants that are customized to meet buyer's needs.

**Technical Specifications:**

*Odor and Appearance:* Opaque thixotropic gel with characteristic aromatic solvent odor

*Viscosity:* 25,000 ± 3,000 cP, RVDVE 6-20 @ 25 °C

*Density:* 9.8 ± 0.2 lbs/gal.

*Solids:* 77 ± 2%

*pH:* N/A

*Flash Points:* 7.2 °C (45 °F) TCC

*Film:* N/A

*Minimum Film Temp:* 15.6 °C (60 °F)

*Borax Tolerance:* N/A

*Base:* DGEBA

*FDA Status:* N/A

**APPLICATION:**

**Surface Preparation:**

Substrate must be clean, dry, and free of contaminants; e.g., release agents, dirt, dust, etc.

**Mixing Ratio:**

One part by volume 60F0639 epoxy adhesive part A to one part by volume epoxy curing agent part B.

**Pre-use Induction Time:**

Epoxy resin/curing agent blend must be aged 15 minutes prior to use to avoid wetting problems. Remix after aging.

**Application:**

The viscosity of the mixed epoxy (Part A to Part B) is most applicable to dipping. Epoxy mix can also be applied with brush, roller or spray equipment.

**Expected Mileage:**

Approximately 320 sq.ft. per gal. @ 5 mils wet.

**Open Time:**

Varies with temp., air circulation, wet film thickness (WET), and other factors, 10-30 minutes may be expected in typical applications.

**Suggested film thickness:**

A dry film thickness equal to 10% of the fiber length is recommended for optimum cost/performance results.

**Cure-Air Dry:**

Dry to touch may be expected in 12-18 hrs; optimum film properties develop in 5-7 days; again variables which effect cure are similar to those effecting open time.

**Force Dry:**

Heat cure 3-15 minutes @ 200 - 300 ° F.

**Pot Life:**

4-6 hrs.; will vary with amount mixed and initial temperature of mixture.

**Clean Up:**

May be cleaned or removed from substrate or equipment with aromatic solvents such as acetone, xylene, toluene or MEK (before cure).

**Storage:**

Store in controlled dry area. Keep well sealed and at ambient temperature.

**Recommended Inventory:** 1 year

**Precautions:**

**Health:**

Work in well ventilated areas. Avoid prolonged or repeated contact with skin. Wear safety glasses. More details can be found on accompanying MSDS.

**Fire:** Regulated as flammable by USDOT.

**Environmental:**

Incinerate or bury in landfill in accordance with all local, state, and federal regulations.

**Standard Packaging:**

5 Gallon Steel Pails, 1 Gallon Cans

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**65F0641**  
**EPOXY CURING AGENT PART B**

[www.nyatex.com](http://www.nyatex.com)

rev. date: 10/11/2016

65F0641 is an epoxy curing agent formulation designed for use with 60F0639 Epoxy adhesive or similar part A epoxy resins. 65F0641 is suitable for most curing applications.

**Designed Uses:**

Epoxy curing agent for flocking on ABS, ABS/PC and Polypropylene plastics.

*See product data sheet for 60F0639 Epoxy Flock Adhesive Part A which will be used with 65F0641 for details of application, cure and storage requirements.*

**Technical Specifications:**

*Odor and Appearance:* Aromatic solvent odor with amber color

*Viscosity:* 550 ± 150 cP, RVDVE 2-20 @ 25 °C

*Density:* 7.9 ± 0.2 lbs/gal.

*Solids:* 70.8 ± 2%

*pH:* N/A

*Flash Points:* 7.2 °C (45 °F) TCC

*Film:* N/A

*Minimum Film Temp:* N/A

*Borax Tolerance:* N/A

*Base:* Polyamide

*FDA Status:* N/A

**APPLICATION:**

**Surface Preparation:**

Substrate must be clean, dry, and free of contaminants; e.g., release agents, dirt, dust, etc.

**Mixing Ratio:**

(1:1) One part by volume epoxy adhesive part A to one part by volume 65F0641 epoxy curing agent part B. For more flexible coating use 2 parts by volume of 65F0641.

**Pre-use Induction Time:**

Epoxy resin/curing agent blend must be aged 15 minutes prior to use to avoid wetting problems. Remix after aging.

**Application:**

The viscosity of the mixed epoxy (Part A to Part B) is most applicable to dipping. Epoxy mix can also be applied with brush, roller or spray equipment.

**Clean Up:**

May be cleaned or removed from substrate or equipment with aromatic solvents such as acetone, xylene, toluene or MEK (before cure).

**Storage:**

Store in controlled dry area. Keep well sealed and at ambient temperature.

*NOTE: Product will settle over time.*

*Recommend agitating can prior to each use.*

**Recommended Inventory:** 1 year

**Precautions:**

**Health:**

Work in well ventilated areas. Avoid prolonged or repeated contact with skin. Wear safety glasses. More details can be found on accompanying MSDS.

**Fire:** Regulated as flammable by USDOT.

**Environmental:**

Incinerate or bury in landfill in accordance with all local, state, and federal regulations.

**Standard Packaging:**

5 Gallon Steel Pails, 1 Gallon Cans