

Aerodux 185 / HRP 155 Directions for Use

When used properly Aerodux 185 provides a structural waterproof bond which meets a wide range of specifications including HPVA Type 1 and ASTM 2559 Wet Use.

Instructions:

Aerodux 185 must be mixed with HRP 155 by weight due to density variations in the powder. The ratio is 5:1, liquid resin to powder.

Example: You have 1 lb (16oz. of resin); you will need 3.2 oz. of powder.

Powdered catalyst should be stirred into resin until smooth.

At room temperature (70 degrees F) the mixture will have a pot life of around 2 hours. A small amount (up to 1%) of water can be added once if it starts to thicken.

Surfaces to be glued should be clean, oil free and freshly machined. Aerodux 185 requires a slightly thicker spread rate than traditional adhesives. Approximately 7 wet mils should be applied to both surfaces being glued. Once applied it provides a 5-7 minute open time at room temperature. Increased working time (10-15 minutes) can be achieved by putting parts together before clamping. At room temperature, a minimum of five hours in clamps is required. This can be reduced with the addition of heat.

Hint: A consistent bead of squeeze out at the glue joint indicates the proper amount of adhesive and clamping pressure.

Clean up:

While still wet warm soapy water will clean up excess glue. Once cured, it will require scraping or sanding.

Consult SDS for safety warnings and recommended protective clothing.