

HUDCO Industrial Products, Inc.

Adhesives

Fast Curing Epoxy Adhesive

HUDCO Formula 3500

HUDCO Formula 3500 Fast Cure is a 100% solid epoxy resin adhesive for bonding ceramic tiles to metal substrates when limited time is available. When necessary, Formula 3500 can be used to attach tiles on vertical or overhead surfaces. Maximum temperature exposure should not exceed 200° F.

Typical Applications

- Bonds ceramic tile to metal substrates
- For fast curing when temperatures are moderate
- Fast curing for immediate sealing
- Rapid return to service of the hardware equipment being repaired

Physical Properties

Gel Time	6 min @ 70° F
Initial Curing Time	15-30 min @ 70° F
Final Curing Time	3 days @ 70° F
Viscosity	Approx. 5500 poise
Lap Shear Strength: (min) Steel to Steel (ASTM-D 1002)	2600 PSI
Slant Shear Strength: Concrete (ASTM-C882), 7 days cure min	3000 PSI
Volatile content cured system. max	0.4%
Water absorption (ASTM-D570) max	0.8%
Shrinkage during cure (ASTM-C883)	Passes

Packaging

Kit	Resin	Curing Agent	Kit Weight
2 Quarts	2 lbs.	2 lbs.	4 lbs.
2 Gallons	9.5 lbs.	9.5 lbs.	19 lbs.



This reference guide is not intended as a substitute for the product label for the products referenced herein. Product labels for the above products contain important precautions, directions for use and product warranty and liability limitations that must be read before using the product. Applicators must be in possession of the product label(s) at the time of application. Always read and follow all label directions and precautions.

Application Instructions

Surface Preparation:

(A) Surface of substrates must be clean and sound.

(B) Remove grease, oil, or other foreign material with a film free solvent or hot detergent wash.

(C) Roughen surface by grinding or sandblasting (3-5 mil surface profile) Surface must be completely dry with a minimum surface temperature of 75° F before applying. Acid etching the surface is acceptable if followed by thorough flushing with clean water.

Mixing: Combine equal amounts of HUDCO Formula 3100 Resin with HUDCO Formula 3100 Hardener by volume. Mix thoroughly for several minutes making sure all the resin is blended with the entire Hardener. Accurate measuring and mixing are vital to complete curing and optimum performance.

Application: Apply product to prepared surface and use supplied tools to achieve desired finish.

Curing: At 70° F, product will gel in 6 to 10 minutes. Initial cure will occur in 15-30 minutes at 70° F. Final cure occurs in 24 hours.

Safety Precautions

CAUTION: For Industrial Use Only. Keep Away From Children.

HUDCO Formula 3500 Resin contains epoxy resin which is harmful if swallowed. After prolonged exposure it may irritate skin and cause sensitization and/or dermatitis.

HUDCO Formula 3500 Hardener contains organic amine compounds which are harmful if swallowed. After prolonged exposure or repeated skin contact it may cause irritation, sensitization and/or dermatitis.

Emergency and First Aid Procedures

- Eye Contact - Irrigate with clean water for 15 minutes and call a physician.
- Skin Contact - Wash with soap and water.
- Inhalation - Remove to fresh air and provide oxygen if necessary.
- Ingestion - Call a physician at once. Give milk or white of egg beaten with water. Then give a teaspoon of salt in a glass of warm water to induce vomiting.

Protection Procedures

If used in a confined or an enclosed area, use an air supplied mask or respirator with canister for organic vapors and provide mechanical exhaust ventilation. Use protective gloves, safety glasses, and protective clothing. Avoid contact with skin and clothing. Contaminated clothing should be laundered before wearing again. Contaminated shoes should be thoroughly cleaned before wearing again.

Storage

HUDCO Formula 3500 Resin and Hardener should be stored in a cool, dry area. Shelf life is a minimum of one year in unopened containers when stored at 70° F – 85° F.

Warranty

Because the storage, handling and application of these materials are beyond our control, we can accept no liability for the results of their use. Our liability is limited only to replacement of any material proven defective in manufacture. We suggest users try small applications to determine the suitability of the product for their intended use.

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