VIBRA-TITE IS A REGISTERED TRADEMARK OF ND INDUSTRIES, INC.

# Product Description

*Vibra-Tite VT919* is 1:1 by volume mix ratio epoxy adhesive that exhibits good peel strength, shear strength and environmental aging. Once mixed, the two component epoxy cures at room temperature to form a tough grey adhesive that provides good adhesive strength to many substrates including aluminum, steel, composites, glass, ceramic, wood and some plastics. When mixed VT919 is a low flow adhesive for clean, no-mess bonding applications.

## Features and Benefits

- Easy 1:1 volumetric mix ratio
- 90 minute work life
- Flexible
- Good shear and peel adhesions
- Low flow

## Properties of Uncured Material (resin)

| | |
|---|---|
| Chemical Type | Epoxy |
| Appearance | Off white |
| Specific Gravity | 1.33 |
| Toxicity | Low |
| Solids | 100% |
| Viscosity @ 25ºC, cps | 75,000-150,000 |

## Properties of Uncured Material (hardener)

| | |
|---|---|
| Chemical Type | Polyamide/Amine |
| Appearance | Grey |
| Specific Gravity | 1.28 |
| Toxicity | Low |
| Solids | 100% |
| Viscosity @ 25ºC, cps | 50,000-75,000 |

## Properties of Mixed Material

| | |
|---|---|
| Vol. Mix Ratio, Resin: Hardener | 1:1 |
| Wt. Mix Ratio, Resin: Hardener | 1.04:1 |
| Appearance | Light Grey |
| Mixed Viscosity @ 25ºC, cps | ~100,000 |
| Gel Time, 100g @ 25ºC | 90 minutes |
| Time to Handling Strength | 8-12 hours |
| Full Cure @ 25 °C | 7 days |
| Alternate Cure Cycle | 24 hrs at 25 °C<br>plus 2 hrs at 70 °C |

## Properties of Cured Material

**Hardness @ 25ºC**

Shore A (reading taken at 5 seconds)
7 Days @ 23 °C TBD

**Shear Adhesion**
Per ASTM D1002 at 0.1 in/min
Steel to steel abraded with 50 grit paper
24 Hours @ 23 °C .....900 psi
24 Hours @ 23 °C .....1500 psi
plus 2 hrs at 70 °C
7 Day @ 23 °C..... 1500 psi

Al to Al (2043T3 Bare) abraded with 50 grit paper
24 Hours @ 23 °C .....1500 psi
plus 2 hrs at 70 °C

# General Information

## Storage

Product should be stored in cool, dry conditions. *VIBRA*-TITE 919 when un-mixed has a shelf life of at least 12 months when stored at 25°C. Storage in cool, clean areas is recommended. Usable shelf life may vary depending on method of applications and storage conditions.

## Note

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.