

Product Description

Vibra-Tite 930 is a single-part heat cured epoxy adhesive with excellent adhesion to metal oily surfaces as well as composite material. This epoxy can be used to enhance joint stiffness and joint durability. The high bond strength of this adhesive allows it to replace mechanical fasteners, soldering, brazing, or welding. This material requires heat in the range of 120°C to 200°C. Vibra-Tite 930 is non-sagging allowing this product to be used in large gaps and on vertical surfaces.

Features and Benefits

- Excellent Adhesive Strength
- Enhanced Joint Durability
- Bonds Through Oily Substrates
- Easy to Use 1K System
- High Shear and Peel Strengths
- Good High Temperature Performance
- Good Chemical Resistance

Properties of Uncured Material

Chemical Type	Epoxy
Appearance	Silver Paste
Specific Gravity	1.38
Toxicity	Low
Solids	100%
Viscosity @ 25°C, cP	900,000
Thixotropic Index	3.01
Peel Strength, PLI	48

Typical Curing Performance

Cure Speed

Heat is required to cure the epoxy. The cure time is dependent on the temperature used. The following is time required to cure the epoxy at different temperatures.

Temperature, °C	Cure Time, minutes
121	45
163	30
177	15
200	10

Performance of Cured Material

	Typical Values
Shear Strength	PSI
Steel	5,000
Galvanized	4,500
Aluminum	3,900

Environmental and Fluid Resistance (Shear strength values)

	Typical Values
Heat age	100%
Environmental Cycles	90%
Humidity	90%
Salt Spray	90%
SAE J2334	80%

General Information

Storage

Product should be stored in cool, dry conditions. VIBRA-TITE 930 when un-mixed has a shelf life of 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.