

DETAIL SPECIFICATION -SPOT BONDING COMPOUND-FASTENERS

<u>MATERIAL</u>	LSE SPEC #	PREPARED BY:
EPON 828		QA:
VERSAMID 125	QAP-D-309	PROJECT:

1.0 SCOPE

THIS SPECIFICATION COVERS THE PREPARATION, HANDLING, AND DISPOSAL OF EPON 828/V125 FOR USE IN SPOT BONDING OF FASTENERS ON ELECTRONICS ASSEMBLIES.

2.0 APPLICABLE DOCUMENTS

- NASA SPECIFICATION NHB 5300.4(3J).
- GSFC INSPECTION OF POLYMERIC MATERIALS-APPLICATIONS MANUAL.
- SHELL PRODUCTS CO. TECHNICAL INFORMATION BULLETIN FOR EPON 828 AND V125
- SHELL PRODUCTS CO. MSDS SHEET FOR EPON 828/V125.

3.0 HANDLING

- HANDLING IN ACCORDANCE WITH EPON 828/V125 MSDS SHEET.
- FIRE AND REACTIVITY- HAZARDS SLIGHT.
- TOXICITY- HAZARDS MODERATE
- HANDLE WITH VINYL GLOVES. MIX IN FUME HOOD.

4.0 DISPOSAL

- CURED SAMPLE TO BE STORED AS WITNESS SAMPLE FOR A MINIMUM OF 30 DAYS; THEREAFTER, DISPOSE WITH DAILY TRASH DISPOSAL.
- UNCURED LIQUID TO BE DISPOSED OF VIA CSR SAFETY PERSONNEL THROUGH M.I.T. SAFETY OFFICE.

5.0 MIXING PROCEDURE

- CLEAN BEAKERS, MIXING RODS, SPATULAS, ALUMINUM DISHES, ETC WITH REAGENT GRADE ISOPROPYL ALCOHOL PRIOR TO USE.

- PREPARE EPON 828
 - MIX CAN CONTENTS, THOROUGHLY, WITH METAL SPATULA.
 - USING OHAUS CT 1200 SCALE, PLACE 5 GRAMS OF EPON 828 IN AN ALUMINUM DISH.

- ADD V125 TO EPON 828
 - MIX CONTENTS OF V125 CAN, THOROUGHLY, WITH METAL SPATULA.
 - USING OHAUS CT 1200 SCALE, ADD 5 GRAMS OF V125 TO EPON 828 IN ALUMINUM DISH.
 - ADD ~5 GRAMS OF ALUMINUM OXIDE TO THICKEN.
 - MIX WITH METAL SPATULA FOR 1 MINUTE.
 - SEPARATE CONTROL SAMPLE FROM BEAKER AND PLACE IN OVEN AT 100°C FOR 5 MINUTES.
 - USE AS IS OR TRANSFER TO SYRINGE FOR APPLICATION.

- CURE
 - 24 HOURS AT 25°C - FULL CURE. (USABLE AFTER OVERNIGHT CURE)