

High Temperature Graphite Adhesive

- One Part Adhesive
- Mix well before each use
- Max Temperature: 3000° F (in vacuum)
- Curing Time: 3 Hours @ 350° F (in air)

This adhesive is used to bond:

- Graphite Flexible Foil to Graphite Rigid Insulation
- Graphite Flexible Foil to Carbon/Carbon Composite
- Graphite Flexible Foil to Graphite/Carbon Felt
- Carbon/Carbon Composite to Graphite Rigid Insulation
- Graphite to Graphite

Shelf Life:

3 months at room temperature 70 F

6 months when refrigerated 40 F

Instructions:

1. Mix adhesive well before each use
2. Apply light coating of adhesive to one or both surfaces with a paint brush or paint roller
3. Apply weight or pressure for best bond results
4. Dry & harden at room temperature for a few hours or in an oven at 100C until temperature is achieved.
5. For thick cross sections (greater than ¼ inch thick), heat in air or vacuum at 1 degree per minute until 350° F. Soak at 350F for 2 hours, then heat at 2 degrees per minute to 700C and soak for 1 hour.
6. For thin sections (less than ¼ inch thick), heat at heat in air or vacuum at 2 degree per minute until 350° F. Soak at 350F for 1 hours, then heat at 2 degrees per minute to 700C and soak for 1 hour.

** Special Notes **

1. For best results when bonding graphite flexible foil to graphite rigid insulation use our Graphite Coating (Graphite Insulation Surface Coating) before applying the High Temperature Graphite Adhesive.
2. Caution – Adhesive is flammable, be careful when curing. Adhesive will cure if ignited.
3. Use isopropyl alcohol to thin if needed (caution bonding may differ when thinned)
4. Graphite fiber may be added to adhesive to produce a paste that may be used to patch graphite rigid insulation

