

## 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

