



FH8516 Data Sheet

Electronic Materials Two-part Epoxy Adhesive

Material Description

FH8516 is a two part, room temperature curing epoxy adhesive. FH8516 features for high strength, good flexibility and good impact strength after curing. It's designed for the bonding of variable substrates including composite, metal, glass, ceramic.

Features & Benefits

- Medium curing speed
- Excellent adhesion
- Good Flexibility
- Excellent reliability

Typical application

Design for bonding of composite, metal, glass, ceramic where high reliability is needed.

Curing Profile

Recommended cure:
24hours @ 25°C
Or 4hours@ 60°C

Contact HB Fuller technical support for additional curing recommendations.

Typical Uncured Properties Part A	
Property	Value
Color	Black liquid
Viscosity(cps@25°C)	16,000
TI	1.9
Specific Gravity, g/cm ³	1.25

Typical Uncured Properties Part B	
Property	Value
Color	Yellow paste
Viscosity(cps@25°C)	14,000
TI	4.2
Specific Gravity, g/cm ³	1.18

Typical Uncured Properties Mixed	
Property	Value
Mix Ratio, by volume, Part A:Part B	2:1
Open time, (mins 25°C)	30
Gel time, 2g (mins 25°C)	80
Specific Gravity, g/cm ³	1.2

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Typical cured Properties Cure at 25°C for 24hours	
Property	Value
Hardness, Shore D	80
Lap-shear strength	Mpa
Al/Al	14
Steel/Steel	16
FR4/FR4	20

Preparation for Material Usage

1. Bonding surface area should be clean and free of any fluxes, residues, dust or any other contaminations.
2. Use gloves to minimize skin contact.
3. Application to the substrates should be made as soon as possible. Larger quantities and /or

higher temperatures will reduce the working time.

4. Keep assembled parts from moving during cure. The bond should be allowed to develop full strength before subjecting to any service load.

Contact HB Fuller technical support for additional material handling recommendations.

Storage & Shelf Life

FH8516 is supplied in 50ml/ dual- cartridge. It should be stored in 15°C to 28°C in the unopened container in a dry location. Shelf life is 6 months from date of manufacture.

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