

Hapweld™ 38

Thermoplastic

Hapco Inc.

Message:

Similar in most characteristics to HAPWELD 36 A/B, mix ratio, clarity, etc., but also has the ability to gel and cure very quickly (gel time, 5-10 minutes). May be used in all the same type applications as HAPWELD 36 and should be used when either a faster set or cold cure is required. In some applications, the need for exotic holding fixtures, or large amounts of storage or "rack space", is eliminated. May be used in high production applications.

General Information			
Features	Bondability		
	Fast Cure		
	High Clarity		
	Machinable		
Uses	Adhesives		
	Fabrics		
	Filling Applications		
	Repair Purpose Filler		
Appearance	Clear Amber		
Forms	Liquid		
Physical	Nominal Value	Unit	
Weight - Per gallon	4300	g	
Service Temperature	-73 to 71	°C	
Gel Time			
-18°C	6.0 to 8.0	hr	
0°C	3.0 to 4.0	hr	
10°C	0.5 to 0.8	hr	
21°C	0.3	hr	
38°C	0.1	hr	
Work Time ¹	4.0 to 6.0	min	
Cure Time (21°C)	30.0	min	
Hardness	Nominal Value	Unit	
Durometer Hardness (Shore D)	78		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	53.8	MPa	
Shear Strength	17.2	MPa	ASTM D732
Electrical	Nominal Value	Unit	
Volume Resistivity (25°C)	1.0E+11	ohms · cm	

Dielectric Constant (25°C)	4.10	
Thermoset	Nominal Value	Unit
Thermoset Components		
Part A	Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0	
Part B	Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0	
Thermoset Mix Viscosity	6000	cP
NOTE		

1. Depending on mix ratio. Longest working life is at 2 parts A to 1 part B, and the shortest is at 1:1 mixing ratio.

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