

NOTE: GL137 MAY BE USED AS AN ALTERNATE.

**DIRECTIONS**

**1. PREPARATION**

A. THOROUGHLY CLEAN AND DRY BONDING SURFACES.

**2. APPLICATION**

- A. SEE NOTE NO. 3 FOR APPROXIMATE AMOUNTS OF ADHESIVE TO APPLY.
- B. APPLY ADHESIVE DIRECTLY FROM CONTAINER OR WITH DROPPER (BEST RESULTS ARE OBTAINED BY APPLYING ADHESIVE TO ONLY ONE BONDING SURFACE).
- C. WITH WOODEN SPATULA (OR SIMILAR TOOL), SPREAD ADHESIVE AS THINLY AS POSSIBLE WITHOUT USING UNDUE PRESSURE.
- D. QUICKLY PLACE UNTREATED BONDING SURFACE ON TREATED SURFACE AND ALIGN (ANY FINAL ADJUSTMENTS OF MOVING THE TWO SURFACES AFTER CONTACT MUST BE DONE WITHIN A FEW SECONDS DUE TO RAPID SET TIME OF ADHESIVE). SEE NOTE NO. 4.
- E. APPLY SUFFICIENT MANUAL PRESSURE UPON MATED SURFACES UNTIL BOND IS SET (SEE CHART 1).

**CAUTIONS**

- 1. AVOID PROLONGED BREATHING OF VAPOR AND USE WITH ADEQUATE VENTILATION.
- 2. AVOID CONTACT WITH SKIN AND EYES (ADHESIVE WILL ADHERE TO SKIN).
- 3. BEFORE CLOSING CONTAINER, REMOVE ALL EXCESS FROM CAP AND NECK OF CONTAINER WITH CLEAN CLOTH OR TISSUE.

CHART 1	
BOND SET TIMES (ROOM TEMP.)	
MATERIALS	SET TIME (APPROX.)
Glass-Glass	10-30 Sec.
Rubber-Rubber	1-2 Min.
Wood-Wood	3-8 Min.
Steel-Steel	2-4 Min.
Steel-Neoprene	30-60 Sec.
Aluminum-Aluminum	2-4 Min.

CHART 2		
TENSILE PROPERTIES (EXAMPLES)		
METAL TO METAL BONDS AT ROOM TEMP.		
MATERIAL	Tensile Strength PSI 48 Hr. Cure Time	Shear Strength PSI 48 Hr. Cure Time
Steel-Steel	5030	2200
Alum.-Alum.	4500	2600

REF: ARMSTRONG CORK CO., INDUST. DIV.  
(EASTMAN 910 ADHESIVE)

**NOTES**

STANDARD	
Q'TY./UNIT	MODEL USED ON
SCALE	CODE
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.	

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GL-129

**REVISIONS**

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
A	GL137 NOTE ADDED	5-7-65	14031	RL	RLB	

**SPECIFICATIONS**

- 1. UNAFFECTED TEMP. RANGE: -17°C. (+1.4°F.) TO +80°C. (+176°F.)
- 2. TENSILE PROPERTIES: SEE CHART 2
- 3. PHYSICAL PROPERTIES:
  - A. BASIC MATERIALS - APPROX. 90% MONOMER AND 10% THICKENING AGENT, PLASTICIZER AND STABILIZER
  - B. APPEARANCE - CLOUDY, COLORLESS LIQUID
  - C. WEIGHT PER GALLON - 9.15 POUNDS
  - D. FLASH POINT AND FIRE POINT - 180°F.

**NOTES**

- 1. STANDARD USE: WITHIN 6 MONTHS FROM DATE OF SHIPMENT.
- 2. MUST BE KEPT TIGHTLY CAPPED WHILE NOT IN USE.
- 3. APPROXIMATE AMOUNT OF ADHESIVE TO APPLY:
  - A. FOR SMOOTH, NONPOROUS SURFACES (SUCH AS GLASS OR MACHINED METAL) - ONE DROP OR LESS PER SQUARE INCH OF BONDING SURFACE.
  - B. FOR POROUS SURFACES (SUCH AS WOOD, LEATHER) - MORE THAN ONE DROP PER SQUARE INCH.
- 4. LENGTH OF TIME THAT ADHESIVE CAN BE EXPOSED TO THE AIR AFTER IT HAS BEEN PLACED ON ONE SURFACE PRIOR TO MATING WITH A SECOND SURFACE IS APPROXIMATELY 3 OR 4 HOURS PROVIDING CONDITIONS ARE: LOW HUMIDITY, LOW TEMPERATURE, CLEAN SURFACE. ONCE ADHESIVE IS PRESSED OR SPREAD VERY THIN, BONDING OCCURS WITHIN SECONDS.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
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**GELLMAN LIST OF MATERIAL**

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE ADHESIVE, QUICK SETTING		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL	DATE
	RH	5/31/63	TFH	6-4-63
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	CHECKED	DATE	GL-129	A
	MECH. DES.	DATE		
TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'		SHEET	REV. LTR.