

**DAUBOND® R-415-132M3**

**PRODUCT  
 INFORMATION**

Adhesive, epoxy, one component per Ford Engineering Specification ESH-M2G251-A

<b>3. PROPERTIES</b>	<b>TYPICAL VALUES</b>	<b>SPECIFICATION</b>
3.1 Color	Neutral	
3.2 Viscosity, as prepared (Brookfield:6 @ 2.5 -23°C)	156,000-175,000 cps	
3.3 Solids	>99.5	99.75 ± 0.25
3.4 Weight per volume	14.30 - 14.70 lb/gal	
3.5 Shear adhesion strength. 1/4 in. overlap using AA 3005-0 aluminum. Cure cycle: 30 min. @ 200°C. Instron pullrate: 0.2 in/min.		
	<b>TYPICAL VALUES</b>	<b>SPECIFICATION</b>
3.5.1 High temperature strength @ 133°C		
As cured, @ RT	2252 PSI	1500 PSI (minimum)
As cured, @ 133°C	2452 PSI	1300 PSI (minimum)
After 336 H @ 133°C, @ RT	2100 PSI	1500 PSI (minimum)
After 336 H @ 133°C, @ 133°C	2120 PSI	1300 PSI (minimum)
3.5.2 Immersion in engine oil After 336 H @ 133°C, @ RT	1988 PSI	1300 PSI (minimum)
3.5.3 Immersion in transmission fluid After 336 H @ 133°C, @ RT	1440 PSI	1200 PSI (minimum)
3.5.4 Immersion in engine coolant F2FZ-19549-A After 336 H @ 133°C, @ RT	1000 PSI	500 PSI (minimum)
3.5.5 Immersion 5% salt water After 336 H @ 25°C, @ RT	2252 PSI	1100 PSI (minimum)
3.5.6 Low temperature exposure (-40°C)		
As cured	2360 PSI	1350 PSI (minimum)
After 336 H @ 133°C	2040 PSI	1350 PSI (minimum)
3.4.7 Thermal Shock @ RT	2348 PSI	1350 PSI (minimum)
3.5.8 Impact/Shear @ RT	2340 PSI	1450 PSI (minimum)



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