



PART NUMBERS

H15-080-RX (Single Pack)

H15-080-RX-50 (50 Pack)

Replace "X" with 2 or 4 for 2 gram or 4 gram package size

FIS Heat Cure* is a two component, 100% solids, heat curing epoxy designed for high temperature applications. The Heat Cure epoxy exhibits long pot life, excellent glass to ceramic bonding, and a color change from amber to red upon cure.

TYPICAL PROPERTIES

Number of Components	Two	Index of Refraction	1.560
Mix Ratio	Parts By Weight	Viscosity (23° C/20rpm)	mixed 3000-5000 cPs
Part A (Resin)	Clear	Operating Temperature	-50 to 200° C
Part B (Hardener)	Amber	Hardness, Shore D	87
Pot Life		Specific Gravity	
in a vial or dish	4 hours	Part A	1.20
in a syringe	90 minutes	Part B	1.02
Shelf Life		Glass Transition Temp. (Tg)	
One year when stored at room temperature		cured @ 150° C/1 hour	100° C
Curing Schedule		Coefficient of Expansion	
80° C	15 Minutes	Below Tg	54×10^{-6} in/in/°C
Spectral Transmission		Above Tg	160×10^{-6} in/in/°C
550nm	>50%	Lap Shear Strength @ 25°C	
800-1000nm	>98%	Al to Al	1500psi
1100-1600nm	>95%	Moisture Resistance	
		MIL SPEC: MIL-1-16923-D	
		After 7 days @ 96% RH %	0.03%
		Weight increase	