

**CHO-BOND® 2165****TWO-COMPONENT POLYURETHANE SEALANT****DESCRIPTION**

**CHO-BOND® 2165** conductive sealant is a stabilized-copper-filled, two-component polyurethane. It has excellent electrical and physical properties for aerospace and military applications. CHO-BOND® 2165 sealant is highly resistant to aircraft fluids and to corrosion. It contains non-chromate inhibitors to prevent copper oxidation and minimize corrosion on metal substrates.

The material is supplied in kit form. It is easily applied with a spatula or caulking gun. CHO-BOND® 2165 achieves full properties in less than 4 hours with a combination room temperature cure plus a 125°C cure, or in 24 hours at room temperature. It is tack-free in 4 hours.

Cured CHO-BOND® 2165 sealant will survive 2,000 hours in salt spray (MIL-STD-810C). It is recommended for applications in corrosive environments.

**APPLICATION**

Surfaces to be bonded must be clean, dry and oil free.

Part A (copper color) should first be mixed separately, as settling may have occurred. When homogeneous, weigh out the Parts A and B in the ratio, 100 : 7.021. Add Part B to Part A. Mix thoroughly to a uniform consistency and color, at least 50 strokes by hand, scrapping the sides and bottom of the container. No marbling or striations should be present.

Immediately apply the material using a spatula or caulking cartridge.

The recommended cure is 7 days at room temperature, or 4 hours at room temperature followed by 0.5 hour at 125°C or 4 hours at room temperature followed by 2 hours at 93°C.

Read and become familiar with the provisions of the MSDS before using this or any other reactive material. Apply in a well-ventilated area.

CHO-BOND® 2165 - TYPICAL PROPERTIES		
Nominal Specific Gravity	2.85 g/cc	Method ASTM-0792
Volume Resistivity	0.007 ohm-cm	Method 95-40-5555
Shelf Life at 25°C (77°F), unopened	9 months	
Mix Ratio, A : B	100 : 7.021	
Working Life, mixed	1 hour	
Recommended Cure	7 days at RT, or 4 hours at RT & 30 Minutes at 125°C	
Continuous Use Temperature	-40°C to 85°C	
Tack-Free Time	4 hours at RT, 50% RH	
Percent Solids	> 95%	Method ASTM-D1259
Hardness, Shore A	73	Method ASTM-D2240

ORDERING PROCEDURE		
Product	Part Number	Unit Size
CHO-BOND® 2165	50-01-2165-0000	1 lb. (0.5 pint) kit
CHO-BOND® 2165	50-02-2165-0000	2.5 lb. (1 pint) kit
CHO-BOND® 2165	50-04-2165-0000	5 lb. (1 qt.) kit

TB 1001 EN 11/05

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