

**VALTRON® - Temporary Bonding System - Water Removable****VALTRON AD 4110-A RESIN  
VALTRON AD 4017-B HARDENER****Features**

- ⇒ Cure time of 2 hours at room temperature
- ⇒ Easily debonded with hot water
- ⇒ Removes completely from all bonding surfaces with VALTRON alkaline detergent
- ⇒ Increased potlife
- ⇒ Lower viscosity system
- ⇒ Available in various packaging systems

**Description**

The VALTRON Temporary Bonding System is a two component epoxy system consisting of VALTRON AD 4110-A resin and VALTRON AD 4017-B hardener. The room temperature cure time for this adhesive is app. 2 hours. The fast curing adhesive system effectively adheres materials and allows for quick and efficient removal.

**Typical Physical Properties**

Specific Gravity (@ 20° C):	AD 4110-A	1.09 g/cc
	AD 4017-B	1.14 g/cc
Color:	AD 4110-A	Cream
	AD 4017-B	Clear
Viscosity (Brookfield Model):	AD 4110-A	80.000 cps @ 25° C
	AD 4017-B	13.000 cps @ 25° C

**Packaging**

- ⇒ 5 gallon pail
- ⇒ 4x1 gallon case
- ⇒ One gallon container
- ⇒ One pint can
- ⇒ Pre-measured syringe

**VALTRON® - Temporary Bonding System - Water Removable****VALTRON AD 4110-A RESIN  
VALTRON AD 4017-B HARDENER****Application**

- Step 1** Thoroughly clean all surfaces to be adhered using Isopropyl Alcohol or Acetone.
- Step 2** Accurately weigh the two adhesive components into a mixing cup using 100 parts by weight of the resin, AD 4110-A and 50 parts by weight of the hardener, AD 4017-B. (2:1 mix ratio by weight and by volume)
- Step 3** Thoroughly mix the two adhesive components until a uniform color is achieved.
- Step 4** Apply a very thin uniform layer of the adhesive on the surface to be bonded.
- Step 6** Allow adhesive to cure for app. 15 min. at 20 - 32° C (70 - 90° F).  
The adhesive will begin to gel in 7 minutes.

**Demounting/Removal**

The VALTRON Adhesive System is designed to provide a temporary bond. The unique properties of this adhesive system allow for removal of the epoxy adhesive using a heated VALTRON liquid detergent solution. This process allows the parts to be cleaned of epoxy, coolant and kerf in a simple procedure.

- Step 1** Place component into boiling deionized water for app. 4 min.
- Step 2** Carefully remove material from boiling water (95° C.).
- Step 3** Place material into a 4.0% solution of VALTRON SP 2200 heated to app. 71° C (160° F).
- Step 4** Remove components from detergent solution and spray rinse with DI water or use an ultrasonic deionized water bath app. 2 min. at app. 71° C (160° F).

**Storage and Shelf Life**

Valtron AD 4110-A (resin) & AD 4017-B (hardener) has a shelf life of 6 month when stored below 32° C. (90°F). Keep out of sunlight and in original unopened containers.

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4/6/06