

# MAKOBOND COMPOUND 035

## PRODUCT DESCRIPTION

Makobond CD 035 is a flame-retardant epoxy compound suitable for aerospace applications. It's a two-part, low-density material with room temperature storage, application, and curing capabilities. Meeting FAR 25.853 (a) (d) standards, it offers excellent water and chemical resistance. Tailored for both metal and non-metal honeycomb sandwich designs, it functions to reinforce edges and corners while also filling voids and gaps in various aircraft interior.

## PRODUCT HIGHLIGHTS

- Low Density
- Non Sag
- Room Temp Cure
- Passes Fire Smoke Toxicity

## PRODUCT CHARACTERISTICS

	CD 035A	CD 035B
Viscosity @ 25°C	Paste	Paste
Specific Gravity	0.57	0.58
Color	Dark Red with Black Flakes	Off White

## HANDLING PROPERTIES

Compound 035	
Mix Ratio By Weight, Resin, Hardener	100:50
Mix Ratio By Volume, Resin, Hardener	2:1
Mixed Viscosity @ 25°C	Thixotropic Paste
Pot Life @ 25°C	120-150 minutes

## PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	70-72D	D2240
Compressive Strength (psi)	3,866 psi	D695

## HANDLING AND CURING

Measure out proper weights of CD 035 and mix until uniform with no streaks are present throughout. Scrape container for any unmixed material. Apply CD 035 to prepared surface and let set at 25°C (77°F) for a couple hours. CD 035 has a working time of two hours. Pot life will change based on volume and temperature. Allow 48 hours for a full cure of CD 035 at 25°C (77°F). If a faster cure is desired, 1 hour at 80°C (176°F) will provide full cure properties after initial two hour pot life.

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### PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit
CD-035A	1 lbs	4 lbs	20 lbs
CD-035B	0.5lbs	2 lbs	10 lbs
CD-035 Kit	1.5lbs	6 lbs	30 lbs

### STORAGE AND SAFETY

Makobond CD 035 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.