



TECHNICAL DATA SHEET EPA 0135H

8/20/2020

DESCRIPTION:

Tacusil EPA 0135H is modified version of EPA 0135M . It's long work time under room temperature and designed for bonding application with high temperature resistance and impact resistance requirement. It also has good weather resistance and adhesion to versatile substrate, such as metal, ceramic and some engineering plastic.

TYPICAL PROPERTIES:

All properties given are at 25 °C unless otherwise noted.

| Property: | Value: | Test Method or Source: |
|---|---------------------------------|---------------------------------|
| Color | Silver Gray | Visual |
| Cure Schedule(recommended curing condition) | 30 mins@135C Or 60mins @120C | |
| Work time | >4hours@25C | |
| Viscosity | 75000 cps | Haake Mars 40, 25mm plate, 10/S |
| Specific Gravity | 1.3 | Calculated |
| Hardness | 85 Shore D | ASTM D2240 |
| Water Absorption | 0.2% after 24 hours | ASTM D570 |
| Tensile Properties: | | ASTM D638 |
| Strength | 6500 psi | |
| Elongation | 0-1% | |
| Modulus | 500,000 psi | |
| Lap Shear Strength 0.010" bond line Al to Al | 2800 psi | ASTM D1002 |
| Compressive Properties: | | ASTM D695 |
| Strength | 13,000 psis | |
| Modulus | 800,000 psi | |
| Thermal Conductivity by Hot disk | 0.3 W / (m.K) | |
| Volume Resistivity | 6×10^{13} ohm-cm* | |
| Dielectric Strength | 500V/mil* 20 kV/mm* | |
| Temperature Rating | -40 to 204 °C** | |

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* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results. ** Temperature Rating is based on average design requirements and is not intended as a guarantee of suitability for all applications operating at that temperature.

Approximate time to 95% cure at various temperatures by DSC

| Temperature | 95% cure |
|-------------|------------|
| 90C | 24hours |
| 135°C | 30minutes |
| 150°C | 20 minutes |

NOTE: This chart reflects the thermal response of a very small sample run in a DSC, actual assemblies will require longer times to cure due to heat transfer, mass and method of heating. The cure schedule provided on page 1 provides times and temperatures more in line with use in a typical application.

INSTRUCTIONS:

1. Bring to room temperature for unfreezing prior to dispensing.
2. Apply heat to cure.
3. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
4. Clean up uncured resin with suitable organic solvent such as MEK, acetone or other organic solvent.

SHELF LIFE AND STORAGE:

9 months at 0~ 5 °C

Usable shelf life is dependent upon method of application, storage conditions and user requirements.

Note: Tacusil EPA 0135H is sensitive to excursions above room temperature. Exposure to higher temperature, or cycling of product temperature, will shorten product shelf life.