TECHNICAL DATA SHEET

210008

03/19/2019

Room 9,11 Floor, Chuangxin Building Block 1, No.1, Technology Road, Technology Chuangxin Park,
West of Dayabay, Huizhou City, Guangdong, P.R. China

DESCRIPTION:

Tacusil 210008 is a two part polyurethane sealant. It has a low mixed viscosity which allows for ease in operation. 210008 also offers a strong cohesive force which allows it to bond to alloy devices. It is also suitable for use in a clean room or HEPA environment.

TYPICAL PROPERTIES:

All properties given are at 23 °C unless otherwise noted.

Property:	*Value:*	*Test Method or Source:*
Color	Light Brown	Visual
Mix Ratio **By weight**	Part A to Part B 1 to 2	
Cure Schedule	3-6 hours @60 °C 48-72 hours at room temperature	
Viscosity - Mixed	1,300 cps	
Specific Gravity - Mixed	1.30	Calculated
Gel Time	35-40 minutes/ 20 g sample	
Hardness	60 - 70 Shore A	
Tensile Properties **Strength** **Elongation**	 >= 1.5 MPa >=80%	
Temperature Range	-60 – 120 °C with relative humidity at <70%	

** Temperature Rating is based on average design requirements and is not intended as a guarantee of suitability for all applications operating at that temperature.
*** This TDS contains values that have been updated. The values reported in this technical data sheet are typical values of the product, and are highly dependent on test conditions and methodology. We actively seek the most precise and accurate ways to measure and interpret performance of our products, and to update estimated values with measured values. The formula has not been revised or changed in any way. Although the values on paper have changed, you can expect the same performance of the product.

Instructions for Injection Process:

1. Open and mix component B.

2. Add the A and B components to the corresponding cylinders of the filling machine. If the machine has a mixing function, it is recommended that the B component is stirred and opened. When the room temperature is below 15 °C, set the heat to 30 – 40 °C.

3. Adjust the ratio of A to B on the machine according to the suggested proportion above. Perform at least three verifications of the dispense to ensure error is within the range of no more than 1%.

4. Load the injection machine with 50 – 100 grams of material ensuring any trapped air or bubbles travel to the tip and can be expelled.

5. Cast the material.

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6. Allow the resin to cure according to instructions. Cure times will increase with lower temperatures and higher humidity may introduce additional air into the resin. The preferred operating temperature is ambient at 23 /-3 °C with a relative humidity of <60%.

7. Clean up uncured resin with suitable organic solvent such as MEK, acetone or other organic solvent. It is recommended to clean the injection machine daily.

STORAGE: Store in a dark place ambient at 5-35 °C with a relative humidity of 45-80%RH Seal package immediately after use to avoid contact with moisture.

The performance data listed above is considered typical to associated similar systems or has been extrapolated from other test results of similar products. The data and temperature rating is based on average design requirements and is not intended as a guarantee of performance or stability for all applications.

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