

**DESCRIPTION:**

Tacusil™ EPA0134W-2 is a highly filled, high viscosity white adhesive designed for applications requiring a non-sag and a low CTE metal bonding application. It's updated version of EPA0134W in long work time and size stability in curing process. This formula gives excellent resistance to acids, bases, water, and most organic compounds. The high filler content also enhances resistance to thermal cycle stresses.

Warming the assembly prior to filling will aid in flow and air release.

**TYPICAL PROPERTIES:**

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

<b>Property:</b>	<b>Value:</b>	<b>Test Method or Source:</b>
<b>Color</b>	White	Visual
<b>Mix Ratio</b> By Weight By Volume	Part A to Part B 1 to 1 1 to 0.96	
<b>Cure Schedule</b>	48 hours @RT	
<b>Viscosity:</b> Part A Part B Mixed	500,000 cps 1,000,000 cps 800,000 cps	Rheometer parallel plate 25mm@1/s 45530006291
<b>Specific Gravity</b> Part A Part B Mixed	1.20 1.25 1.22	Calculated
<b>Pot Life</b>	85 mins	Rheometer parallel plate 25mm@1/s 45530006291
<b>Gel Time</b>	150 mins	455300005339/Gardco Hot Pot Gel Timer
<b>Glass Transition Temperature/Tg</b>	70 °C	453560822409 by DSC
<b>Hardness</b>	88 Shore D	455300006287/ASTM D2240
<b>Water Absorption</b>	0.1% after 24 hours	457561824543/ASTM D570
<b>Tensile Properties</b> Strength Elongation Modulus	4,000 psi 1% 1,150,000 psi	455300006285/ASTM D638/ MTS 4535601224470/ASTM D638/Instron
<b>Compressive Properties</b> Strength Modulus	11,500 psi 300,000 psi	455300006265/ASTM D695/MTS 4535601224467/ ASTM D695/ Instron
<b>Thermal Conductivity by LFA</b>	0.6 W/m.K	453560822409/ASTM E1461
<b>Dielectric Constant @ 100 kHz</b>	3.8	Estimated
<b>Dielectric Strength</b>	410 V/mil	ASTM D149 Method A, immersed in

Tacusil. MAKES NO EXPRESS OR IMPLIED WARRANTIES OR MERCHANTABILITY, FITNESS OR OTHERWISE with respect to its products. In addition, while the information contained herein is believed to be reliable, no warranty is expressed or implied regarding the accuracy of the data or the results to be obtained from the use thereof. All recommendations or suggestions for use are made without guarantee inasmuch as conditions of use are beyond our control. The properties given are typical values and are not intended for use in preparing specifications. Users should make their own test to determine the suitability of this product for their own purposes.

25/02/2020

		ASTM D3487 Type II Oil, Specimen thickness was ~1-2 mm
<b>Bulk Resistivity</b>	15 ohm-cm	455300004460/Jandel 4 point probe
<b>Non-volatile content</b>	100%	455300005646
<b>Temperature Range</b>	-40 to 150 °C	

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:**

1. Bring both components to room temperature prior to mixing. Part A of this product in bulk form should be stored at a cool temperature (5 °C +/- 3 °C) for maximum shelf life. Part B should be stored at 20 °C +/-3 °C. Inventory should be rotated on a FIFO (first in, first out) basis.
2. Bulk format: weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Do not pour from mixing container, transfer to a new container as residual unmixed material may cause a tacky spot on the surface of the casting. Maintain adequate velocity during dispensing to ensure complete mixing.
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:**      12 months at 25 °C in bulk package  
Specialty packaging may be less.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50°C) aggravate this phenomenon. Heating the individual component to 50 to 60°C while stirring can usually restore products to original state.

Tacusil. MAKES NO EXPRESS OR IMPLIED WARRANTIES OR MERCHANTABILITY, FITNESS OR OTHERWISE with respect to its products. In addition, while the information contained herein is believed to be reliable, no warranty is expressed or implied regarding the accuracy of the data or the results to be obtained from the use thereof. All recommendations or suggestions for use are made without guarantee inasmuch as conditions of use are beyond our control. The properties given are typical values and are not intended for use in preparing specifications. Users should make their own test to determine the suitability of this product for their own purposes.