



# TECHNICAL DATA SHEET

## EPA0168

02/21/2022

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

### DESCRIPTION:

Tacusil EPA0168FS is a single component epoxy with long room temperature pot life. It can cure at relatively low temperatures such as 80 °C (30minutes typical),and can cure very quickly at high temperatures such as 100 °C (10~15 minutes typical). This epoxy adhesive after full cured has high bonding strength with high hardness. It also has good temperature resistance and pass reflow oven without crack

### 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>	Light Black	Visual
<b>One or two Components</b>	One	
<b>Cure Schedule</b>	30 min @ 80 °C (176 °F) or 15 min @100°C (212 °F)	
<b>Viscosity</b>	60000 cps 23000cps	Haake Mars 40 Rheometer parallel plate 25mm@1/s 25mm@10/s
<b>Thixotropy Area</b>	184Pa/s	Haake Mars 40 Rheometer@ 0.01~20 1/s
<b>Specific Gravity</b>	1.20	Calculated
<b>Pot Life</b>	> 1 week	Estimated
<b>Hardness</b>	85 Shore D	ASTM D2240
<b>Tensile Properties:</b>		Type IV ASTM D638
<b>Strength</b>	45Mpa	Crosshead rate 5mm /min. Tested at 25 °C /
<b>Elongation</b>	1~2%	50%RH
<b>Lap Shear Strength***</b>		ASTM D1002
<b>0.005" bond line Al to Al</b>	2500 psi	Etched 2024T3, Crosshead rate 5mm/min, specimen cures under 100C for 10mins

\*\*\* 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.

### INSTRUCTIONS:

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.



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1. Thaw for one or two hours at room temperature before using. Do not heat syringe above 27 °C when warming.
2. Apply to substrate with flow applicator, then 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:**

12 months at -20 °C (-4 °F) from the date of adhesive manufacture when stored  
in original 30 mL syringes

**NOTE:** This product is sensitive to excursions above room temperature. Exposure to higher temperature, or cycling of product temperature, will shorten product shelf life.