



TECHNICAL DATA SHEET EPA0126

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DESCRIPTION

Tacusil EPA0126 is a one part heat cure 100% solids epoxy adhesive. It's flowable and long work time under room temperature and designed for small gap potting in Type C connector. It has good 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	Gray	Visual
Cure Schedule(recommended curing condition)	30mins@135C	
Work time	>4hours@25C	
Viscosity	75000 cps	Brookfield DVII,6#spindle
Specific Gravity	1.7	Calculated
Glass Transition Temperature/Tg	110 °C (see below for additional information)	R050-61 by DSC
Hardness	85 Shore D	R050-17/ASTM D2240
Water Absorption	0.13% after 24 hours	R050-35/ASTM D570
Tensile Properties:		R050-36/ASTM D638
Strength	7500 psi	
Elongation	0-1%	
Modulus	500,000 psi	
Lap Shear Strength		R050-37/ASTM D1002
0.010" bond line Al to Al	2200 psi	
Compressive Properties:		R050-38/ASTM D695
Strength	18,000 psi	
Modulus	800,000 psi	
Thermal Conductivity by LFA	1.1 W / (m.K)	ASTM D 5470
Volume Resistivity	6 x 10 ¹³ ohm-cm*	
Dielectric Constant	3.5*	
Dielectric Strength	500V/mil* 20 kV/mm*	
Coefficient of Thermal Expansion by TMA	30 ppm/ °C below Tg 80 ppm/ °C above Tg	455300005340 /ASTM E831 TMA, 5 °C/min
Temperature Rating	-40 to 180 °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
80C	24hours
135°C	20 minutes
150°C	15 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:

6 months at 0~ 5°C

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

Note: Tacusil EPA0126 is sensitive to excursions above room temperature. Exposure to higher temperature, or cycling of product temperature, will shorten product shelf life.

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