



# TECHNICAL DATA SHEET Tacusil EPA 0180

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Technology Chuangxin Park, West of Dayabay, Huizhou City, Guangdong, P.R. China

## DESCRIPTION:

Tacusil EPA 0180 is a two-parts very low viscosity general purpose epoxy potting. It's a translucency potting system with adjustable light transmittance and designed for some component potting with special light transmittance. It also has excellent weather resistance, chemical resistance and good adhesion to versatile substrate.

## TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Translucency	Visual
Mix Ratio By weight By Volume	Part A to Part B 100 to 45 2:1	Calculated
Cure Schedule	24hours @RT	
Viscosity – Part A Viscosity – Part B Viscosity - Mixed	3200 cps @1/s 500 cps @1/s 1100 cps @1/s	Rheometer parallel plate 25mm@1/s 455300006291
Specific Gravity – Part A Specific Gravity – Part B Specific Gravity - Mixed	1.12 0.99 1.05	Calculated
Pot Life,	25~30mins	Rheometer parallel plate 25mm@1/s 455300006291
Gel Time	100 minutes/50cc sample	455300005339/Gardco Hot Pot Gel Timer
Glass Transition Temperature/Tg	30 °C	453560822409 by DSC
Hardness	72 Shore D	455300006287/ASTM D2240
Water Absorption	0.2% after 24 hours	457561824543/ASTM D570
Tensile Properties: Strength Elongation Modulus	2000 psi 10% 75,00 psi	455300006285/ASTM D638/MTS 4535601224470/ASTM D638/Instron
Bulk Resistivity	15 ohm-cm	455300004460/Jandel 4 point probe
Non volatile content	100 %	455300005646

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. Cartridge format: Mixer should be attached keeping the cartridge vertical and any air pocket purged this way. Attach a new static mixer with each cartridge, then pre-bleed the first 3 inches of dispensed material or until a uniform color is obtained. Maintain adequate velocity during dispensing to ensure complete mixing.

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2. Bulk format: stir until homogeneous 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.
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. Storage at 25 +/- 10 °C is optimum for most products.