

PRODUCT DESCRIPTION

Modified epoxy | 1 part | solvent-free | heat-curing

- Potting
- Automotive
- Medical devices

- Short curing times at low temperatures
- Very good oil- and media resistance
- Low ion content, electronic grade (<900ppm)</p>
- certified according to ISO 10993-5

CURING PROPERIES

This adhesive must be cured with heat. Typical curing temperatures are listed in the table below.

Temperatures	Time
80°C	3 h
100°C	15 min
130°C	5 min
150°C	2 min
180°C	1 min

The heat cure times are only provided as a guideline. They are derived from curing a 2g adhesive sample without affixed substrates in a laboratory environment. Actual cure times can vary based on part size, configuration, adhesive volume, temperature control, and the time required for the component substrates to attain oven temperature.

The final bond strength of the adhesive is achieved no sooner than 24 h after the bonded components are removed from the oven.



Resin	TECHNICAL DATA	
Appearance Beige Filler Chalk Filler weight [%] 3.0 20 20 20 20 20 20 20		
Filler Chalk Filler Weight % 30 Particle size D95 [µm] 12.5		
Filler - weight [%] Particle size D95 [µm] 12.5 Uncured Material Viscosity [mPas] (Brookfield LVT, 25 °C, Sp. 4/8 rpm) Test Instruction P001 Density [g/cm²] Test instruction P004 Working life [days]	' '	<u> </u>
Particle size D95 [µm] 12.5		
Uncured Material		
Viscosity [mPas] (Brookfield LVT, 25 °C, Sp. 4/6 rpm) 30,000 − 45,000 Test instruction PO01 1.2 − 1.5 Density [g/cm²] 7 Test instruction PO04 7 Working life [days] 7 Ø room temperature 80 − 90 Cured Material 80 − 90 Hardness shore D 80 − 90 Test instruction PO06 80 − 90 Typical operating temperature [°C] −40 − 200 Linear shrinkage [%] √1 Test instruction PO03 √1 Water absorption [wt%] √1 Test instruction PO06 125 − 140 Class transition temperature − DSC [°C] 125 − 140 Test instruction PO09 30 − 50 Test instruction PO09 30 − 50 Test instruction PO17 140 − 180 Test instruction PO17 50°C, 30min Test instruction PO62 50°C, 30min Surface resistance [Ohm] 5 × 10°² − 2 × 10°² 1EC 60093-1980 1 × 10°² − 2 × 10°² Young's modulus − Tensile test [MPa] 4,200 − 6,300 Tensile strength [MPa] <td< td=""><td>Particle size D95 [µm]</td><td>12.5</td></td<>	Particle size D95 [µm]	12.5
Density [g/cm²] 1.2 - 1.5	Uncured Material	
Test instruction PO01 Test instruction PO04 Test instruction PO04 Test instruction PO04 Test instruction PO04 Test instruction PO05 Test instruction PO06 Test instruction PO01 Test instruction PO01 Test instruction PO01 Test instruction PO01 Test instruction PO06 Test instruction PO06 Test instruction PO09 Test instruction PO09 Test instruction PO07 Test instruction PO08 Test	Viscosity [mPas] (Brookfield LVT, 25 °C, Sp. 4/6 rpm)	30,000 45,000
Test instruction P004	Test instruction P001	30,000 - 45,000
Test instruction PO04 Working life (days)	Density [g/cm³]	12 _ 15
Cured Material Hardness shore D 80 − 90 Typical operating temperature [°C] −40 − 200 Linear shrinkage [%] ⟨1 Test instruction P031 ⟨1 Water absorption [wt%] ⟨1 Test instruction P016 ⟨1 Glass transition temperature − DSC [°C] 125 − 140 Coefficient of thermal expansion [ppm/K] below Tg 30 − 50 Test instruction P017 30 − 50 Test instruction P017 140 − 180 Thermal conductivity [W/m*K] 0.5 − 0.7 Thest instruction P062 0.5 − 0.7 Surface resistance [Ohm] 5 × 10¹² − 8 × 10¹² IEC 60093-1980 1 × 10¹⁴ − 2 × 10¹⁴ Volume resistivity [Ohm*cm] 1 × 10¹⁴ − 2 × 10¹⁴ Young's modulus − Tensile test [MPa] 150°C, 30min 4,200 − 6,300 Test instruction P056 Tensile strength [MPa] 30 − 45	Test instruction P004	1.2 – 1.5
Cured Material Hardness shore D 80 − 90 Test instruction P006 80 − 90 Typical operating temperature [°C] −40 − 200 Linear shrinkage [%] √1 Water absorption [wt%] √1 Test instruction P016 √1 Glass transition temperature − DSC [°C] 125 − 140 Test instruction P009 30 − 50 Coefficient of thermal expansion [ppm/K] below Tg 30 − 50 Test instruction P017 30 − 50 Test instruction P017 140 − 180 Test instruction P017 150 °C, 30min Test instruction P062 0.5 − 0.7 Surface resistance [Ohm] 5 × 10 °2 − 8 × 10 °2 Surface insulation resistance [Ohm] 5 × 10 °2 − 8 × 10 °2 GB/T 10064 − 2006 1 × 10 °4 − 2 × 10 °4 Volume resistivity [Ohm*cm] 1 × 10 °4 − 2 × 10 °4 Young's modulus − Tensile test [MPa] 150 °C, 30min Test instruction P056 1 × 10 °4 − 2 × 10 °4 Tessile strength [MPa] 30 − 45	Working life [days]	7
Hardness shore D Test instruction P006 80 – 90	@ room temperature	<u> </u>
Test instruction POO6 Typical operating temperature [°C] -40 - 200 Linear shrinkage [%] -41 Test instruction PO31 Water absorption [wt%] -41 Glass transition temperature - DSC [°C] -125 - 140 Coefficient of thermal expansion [ppm/K] below Tg 150°C, 30min -100°C,	Cured Material	
Typical operating temperature [°C]	Hardness shore D	80 <u>-</u> 90
Linear shrinkage [%] Test instruction PO31 Water absorption [wt%] Test instruction PO16 Glass transition temperature - DSC [°C] Test instruction PO09 Coefficient of thermal expansion [ppm/K] below Tg 150°C, 30min Test instruction PO17 Coefficient of thermal expansion [ppm/K] above Tg 150°C, 30min Test instruction PO17 Thermal conductivity [W/m*K] Test instruction PO17 Thermal conductivity [W/m*K] Test instruction PO69 Surface resistance [Ohm] 1EC 60093-1980 Surface insulation resistance [Ohm] 1x 10 ¹⁴ - 2 x 10 ¹⁴ Voung's modulus - Tensile test [MPa] 150°C, 30min Test instruction PO66 Tensile strength [MPa] 150°C, 30min 30 - 45	Test instruction P006	80 – 90
Test instruction PO31	Typical operating temperature [°C]	-40 - 200
Water absorption [wt%]	Linear shrinkage [%]	×1
Glass transition temperature – DSC [°C] Test instruction P009 Coefficient of thermal expansion [ppm/K] below Tg 150°C, 30min Test instruction P017 Coefficient of thermal expansion [ppm/K] above Tg 150°C, 30min Test instruction P017 Thermal conductivity [W/m*K] Test instruction P062 Surface resistance [Ohm] IC 60093–1980 Surface insulation resistance [Ohm] GB/T 10064–2006 Volume resistivity [Ohm*cm] IC 60093–1980 Young's modulus – Tensile test [MPa] 150°C, 30min Test instruction P056 Tensile strength [MPa] 150°C, 30min 30 – 45	Test instruction P031	XI
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150°C, 30min 30 - 50 Test instruction P017 Test instruction P017 Thermal conductivity [W/m*K] 140 - 180 Test instruction P017 Thermal conductivity [W/m*K] 0.5 - 0.7 Test instruction P062 5 x 10¹² - 8 x 10¹² Surface resistance [Ohm] 1 x 10¹⁴ - 2 x 10¹⁴ GB/T 10064-2006 1 x 10¹⁴ - 2 x 10¹⁴ Volume resistivity [Ohm*cm] 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10¹⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10⁴ FC 60093-1980 1 x 10¹⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴ FC 60093-1980 1 x 10⁴ - 2 x 10⁴		
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140 - 180 140 - 180 140 - 180 Test instruction PO17		
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Surface resistance [Ohm] 15 x 10 ¹² - 8 x 10 ¹² Surface insulation resistance [Ohm] 15 x 10 ¹⁴ - 2 x 10 ¹⁴ Surface insulation resistance [Ohm] 15 x 10 ¹⁴ - 2 x 10 ¹⁴ Volume resistivity [Ohm*cm] 15 x 10 ¹⁴ - 2 x 10 ¹⁴ 15 x 10 ¹⁴ - 2 x 10 ¹⁴ Tensile strength [MPa] 150°C, 30min Tensile strength [MPa] 150°C, 30min 30 - 45		110 100
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Surface insulation resistance [Ohm] GB/T 10064-2006 Volume resistivity [Ohm*cm] IEC 60093-1980 Young's modulus – Tensile test [MPa] 150°C, 30min Test instruction P056 Tensile strength [MPa] 150°C, 30min 30 – 45		
Surface insulation resistance [Ohm] $1 \times 10^{14} - 2 \times 10^{14}$ Volume resistivity [Ohm*cm] $1 \times 10^{14} - 2 \times 10^{14}$ Young's modulus – Tensile test [MPa] 150° C, 30min Test instruction P056 Tensile strength [MPa] 150° C, 30min $30 - 45$		$5 \times 10^{12} - 8 \times 10^{12}$
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Young's modulus – Tensile test [MPa] 150°C, 30min Test instruction P056 Tensile strength [MPa] 150°C, 30min 30 – 45		$1 \times 10^{14} - 2 \times 10^{14}$
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150°C, 30min 4,200 – 6,300 Test instruction P056 Tensile strength [MPa] 30 – 45	IEC 60093-1980	1 x 10··- 2 x 10··
150°C, 30min 4,200 – 6,300 Test instruction P056 Tensile strength [MPa] 30 – 45	Young's modulus - Tensile test [MPa]	
Test instruction P056 Tensile strength [MPa] 150°C, 30min 30 – 45		4.200 - 6.300
Tensile strength [MPa] 150°C, 30min 30 – 45		.,200 0,300
150°C, 30min 30 – 45		
		30 – 45



Elongation at break [%]	
150°C, 30min	<1.5
Test instruction P014	
Lap shear strength (ABS/ABS) [MPa]	
120°C, 15min	3 – 5
Test instruction P013	
Lap shear strength (steel/steel) [MPa]	
100°C, 60min	15 – 20
Test instruction P013	
Lap shear strength (stainless steel/stainless steel) [MPa]	
120°C, 45min	18 – 25
Test instruction P013	
Lap shear strength (AIMg1/AIMg1) [MPa]	
120°C, 45min	8 – 15
Test instruction P013	

TRANSPORT/STORAGE/SHELF LIFE

Package type	Transport	Storage	Shelf life*
Syringe/Cartridge	0°C – 10°C	0°C – 10°C	At delivery min. 3 months
Other packages	0 0 - 10 0	0 0 - 10 0	max. 6 months

^{*}Store in original, unopened containers!



INSTRUCTIONS FOR USE

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP® from Hoenle, or a solution of Isopropyl Alcohol at 90% or higher concentration. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or by using compatible dispensing systems and automation. Many commercially available valve and controller options are available to ensure accurate and consistent adhesive dispensing. For assistance with dispensing and curing questions, please contact our Applications Engineering department. To obtain best results, the adhesive and substrates to be bonded may not be cold and should be allowed to warm to room temperature prior to processing. For safety information refer to our Material Safety Data Sheet (MSDS).

Storage

Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Hoenle cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!



DISCLAIMER

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.

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