



TECHNICAL DATA SHEET Tacusil EPA0406

27/03/2023

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DESCRIPTION:

Tacusil EPA0406 is two parts, medium viscosity, very fast set adhesive. Its hybrid epoxy resin improves the adhesion to versatile substrate, special for plastic, stainless steel. It cures under room temperature within 24 and exhibit good resistance to mechanical impact. It's flame retardant and self-extinguish at 3mm thickness.

SPECIAL FEATURES:

- self-extinguish.
- Fast fixing
- Good adhesion to plastic material and Don't attack PC material
- High resistance to mechanical impact

TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Clear	Visual
Mix Ratio	Part A to Part B	Calculated
By weight	100 to95	
By volume	1: 1	
Cure Schedule	48hours@RT	
Viscosity – Part A	60000 cps @1/s	Rheometer parallel plate 25mm@1/s
Viscosity – Part B	15000 cps @1/s	
Viscosity - Mixed	40000cps @1/s	
Specific Gravity – Part A	1.15	Calculated
Specific Gravity – Part B	1.05	
Specific Gravity - Mixed	1.09	
Pot Life,	3mins	Rheometer parallel plate 25mm@1/s
Gel Time	5minutes/10cc sample	Gardco Hot Pot Gel Timer
Full cure time	24hours under RT	
Glass Transition Temperature/Tg	70 °C	by DSC
Hardness	70 Shore D	/ASTM D2240
Tensile Properties:		ASTM D638/MTS
Strength	2800 psi	
Elongation	10%	
Lap shear strength		ASTM D1002
Al/Al(2042T3)	12Mpa	
PC/PC	7Mpa	
Volume Resistivity	2 x 10E15ohm-cm (@ 25 °C)	ASTM D257
Dielectric Constant / Dissipation Factor		ASTM D150
@ 100 Hz	3.2	
Non volatile content	100 %	

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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. 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.
2. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
3. 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
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.