

DESCRIPTION:

Tacusil EPA0216 is an UV + heat dual cure adhesive. It can fast cure under UV light and secondary heat cure under 100°C for 30mins will fully cure the shadow area. Full cured UVA0216 demonstrates good adhesion to hard plastic material and flexibility.

Because of oxygen inhibition on its surface during curing process, short wavelength UV light such as 260nm or heat cure process will reduce its surface tack. This product is Halogen free and full compliant with RoHS directive 2011/65/EU and Reach directive 1907/2006(SVHC: 201 Items).

FEATURES:

- ❖ UV+Heat dual cure
- ❖ High tensile strength and Good adhesion to PBT and PA
- ❖ Good resistance to HTHM

TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Translucent	Visual
Minimum UV light intensity	200 mJ/mm ²	455300005390 / Power Puck II
Typical Curing time(0.5mm thickness)	15 sec	Radiometer
Heat cure under 100C	30 mins	
Viscosity	21,280 cps @1/s	Rheometer parallel plate 25mm
Thixotrophy area	120 Pa.s	455300006291
Specific Gravity	1.1	Calculated
Hardness	75 Shore D	455300006287/ASTM D2240
Water Absorption	2.5% after 24 hours	457561824543/ASTM D570
Tensile Properties		
Strength	16 MPa	455300006285/ASTM D638/MTS
Elongation	10%	4535601224470/ASTM 8/Instron
Lap Shear Strength		
PBT/PBT	12.5 MPa	ASTM 1002
PC/PC	8.0 MPa	

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Non-Volatile content	100%	455300005646
Linear Shrinkage	2.0%	ASTM2556
Dielectric Constant	4	
Dielectric Strength	510V/mil	
Coefficient of Thermal Expansion	220 ppm/ °C below Tg	455300005340/ASTM E831 TMA, 5 °C/min
Recommend Service Temperature	-40 to 150 °C	

INSTRUCTIONS:

1. This product would be cured with exposure to UV light. Dispensing components including needles and fluid lines should be 100% UV blocking, light blocking should be better.
2. For the best performance bond surfaces should be clean and free from grease. Good exhaustion is necessary in the curing circumstance.
3. Cure speed is dependent upon many variables including lamp intensity, adhesive thickness and percent light transmission of components.
4. Oxygen in the atmosphere may inhibit surface cure. UVC light and high inert gas content in curing ambient will help to eliminate this surface tack.
5. Heat under UV light will warm the assembled parts, peeled it off after cooling down.

SHELF LIFE AND STORAGE:

Store product in the unopened container in a dry location.

Storage information may be indicated on the product container labeling.

Shelf life: 9 months under 0 °C to 10 °C

Material removed from containers may be contaminated during use. Do not return product to the original container. We cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated.

Note:

This product is intended for industrial use only. Keep it way from children. Personal protection wearing is necessary in using this adhesive including gloves, glass and face mask. In case contact it, remove it with soap and water. Make sure the operator to know clearly its safety information in SDS before use.