



TECHNICAL DATA SHEET *EPA0168*

02/21/2022

Room 9,11 Floor, Chuangxin Building Block 1, No.1, Technology Road, Technology Chuangxin Park,
West of Dayabay, Huizhou City, Guangdong, P.R.C.

DESCRIPTION:

Tacusil EPA0168 is a single component epoxy with long room temperature pot life. It can cure at relatively low temperatures such as 80 °C (30minutes typical),and can cure very quickly at high temperatures such as 100 °C (10~15 minutes typical). This epoxy adhesive after full cured has high bonding strength with high hardness. It also has good temperature resistance and pass reflow oven without crack

TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Light Black	Visual
One or two Components	One	
Cure Schedule	30 min @ 80 °C (176 °F) or 15 min @100°C (212 °F)	
Viscosity	60000 cps 23000cps	Haake Mars 40 Rheometer parallel plate 25mm@1/s 25mm@10/s
Thixotropy Area	184Pa/s	Haake Mars 40 Rheometer@ 0.01~20 1/s
Specific Gravity	1.20	Calculated
Pot Life	> 1 week	Estimated
Hardness	85 Shore D	ASTM D2240
Tensile Properties:		Type IV ASTM D638
Strength	45Mpa	Crosshead rate 5mm /min. Tested at 25 °C /
Elongation	1~2%	50%RH
Lap Shear Strength***		ASTM D1002
0.005" bond line Al to Al	2500 psi	Etched 2024T3, Crosshead rate 5mm/min, specimen cures under 100C for 10mins

*** 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.



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INSTRUCTIONS:

1. Thaw for one or two hours at room temperature before using. Do not heat syringe above 27 °C when warming.
2. Apply to substrate with flow applicator, then 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:

12 months at -20 °C (-4 °F) from the date of adhesive manufacture when stored
in original 30 mL syringes

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