

PRODUCT DESCRIPTION

LOCTITE[®] EA E-40FL[™] provides the following product characteristics:

Technology	Epoxy
Chemical Type (Resin)	Epoxy
Chemical Type (Hardener)	Polyamide
Appearance (Resin)	Off-white to beige liquid ^{LMS}
Appearance (Hardener)	Dark gray liquid ^{LMS}
Appearance (Mixture)	Gray, opaque liquid ^{LMS}
Components	Two components - requires mixing
Viscosity	Medium
Mix Ratio, (by volume) Resin : Hardener	1 : 1
Mix Ratio, by weight - Resin : Hardener	100 : 85
Cure	Room temperature cure after mixing
Application	Bonding

LOCTITE[®] EA E-40FL[™] is a toughened, medium viscosity, industrial grade epoxy adhesive with a medium working life. Once mixed, the two component epoxy cures at room temperature to form a flexible, gray bondline with excellent resistance to shock and impact. When fully cured, the epoxy is resistant to a wide range of chemicals and solvents, and acts as an excellent electrical insulator. Typical applications include bonding plastic, metal, glass, wood, ceramic, rubber, and masonry materials where flexibility is required. Suited for low-stress, high-impact bonding applications of dissimilar materials. LOCTITE[®] EA E-40FL[™] can also be used for repairing strain gauges, sealing seams on fiberglass components, repairing printed circuit boards, bonding stainless steel inserts, and rubber hose to steel tubing.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin:

Specific Gravity @ 25 °C	1.3
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25°C, mPa·s (cP):	
Spindle 7., speed 10 rpm	60,000 to 90,000 ^{LMS}

Hardener:

Specific Gravity @ 25 °C	1.1
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25°C, mPa·s (cP):	
Spindle 7., speed 10 rpm	50,000 to 85,000 ^{LMS}

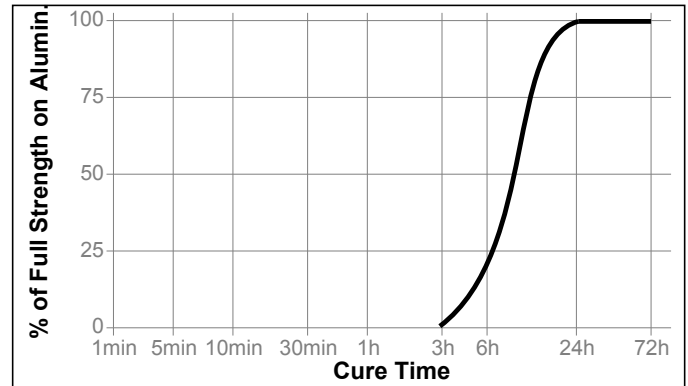
Mixed Properties:

Specific Gravity @ 25 °C	1.2
Working life, minutes	40
Tack Free Time, minutes	130

TYPICAL CURING PERFORMANCE

Cure Speed vs. Time

The graph below shows shear strength developed with time on abraded, acid etched aluminum lapshears @ 25 °C with an average bondline gap of 0.1 to 0.2 mm and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 25 °C

Physical Properties:

Glass Transition Temperature (T _g), °C	30
Shore Hardness, ISO 868, Durometer D	75
Elongation, ISO 527-2, %	22
Tensile Strength, ISO 527-2	N/mm ² 16 (psi) (3,210)

Electrical Properties:

Dielectric Breakdown Strength, IEC 60243-1, kV/mm	16
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TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 3days @ 22°C

Lap Shear Strength, :

Steel (grit blasted)	N/mm ² 4.4 (psi) (640)
Aluminum (acid etched & abraded), 0.1 to 0.2 mm gap	N/mm ² 25.9 (psi) (3,750)
Aluminum (anodised)	N/mm ² 6.3 (psi) (920)

Stainless steel	N/mm ²	5.2
	(psi)	(760)
Polycarbonate	N/mm ²	2.3
	(psi)	(330)
Nylon	N/mm ²	2.6
	(psi)	(380)
Wood (Fir)	N/mm ²	6.6
	(psi)	(960)

Cured for 5days @ 22°C
Lap Shear Strength, :
Steel

Block Shear Strength, ISO 13445:

PVC	N/mm ²	2.8
	(psi)	(400)
ABS	N/mm ²	3.1
	(psi)	(450)
Epoxy	N/mm ²	11
	(psi)	(1,600)
Acrylic	N/mm ²	3.2
	(psi)	(460)
Glass	N/mm ²	12.9
	(psi)	(1,860)

Cured for 2 hours @ 65°C

Lap Shear Strength, :

Aluminum (acid etched) 0.13 mm gap	N/mm ²	≥6.9 ^{LMS}
	(psi)	(≥1,000)

TYPICAL ENVIRONMENTAL RESISTANCE

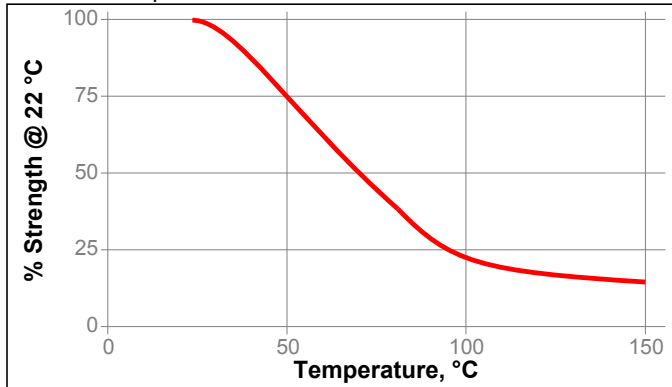
Cured for 12 hours @ 65°C followed by 4 hours @ 22 °C

Lap Shear Strength, :

Aluminum (acid etched & abraded), 0.1 to 0.2 mm gap

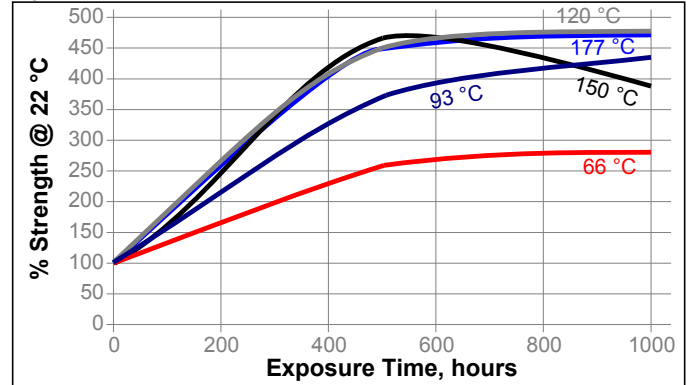
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength	
		500 h	1000 h
Air	87	195	248
Motor oil (10W30)	87	269	215
Unleaded gasoline	87	61	73
Water/glycol 50/50	87	235	134
Salt fog	22	25	5
95% RH	38	60	64
Condensing Humidity	49	61	54
Water	22	50	0
Acetone	22	0	0
Isopropanol	22	68	61

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Directions For Use:

1. For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
2. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
3. **Dual Cartridges:** To use simply insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. If automatic mixing of resin and hardener is desired, attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of the adhesive and mix thoroughly. Mix for approximately



15 seconds after uniform color is obtained.

Bulk Containers: Mix thoroughly by weight or volume in the proportions specified in Product Description section. Mix vigorously, approximately 15 seconds after uniform color is obtained.

4. For maximum bond strength apply adhesive evenly to both surfaces to be joined.
5. Application to the substrates should be made within 40 minutes. Larger quantities and/or higher temperatures will reduce this working time.
6. Join the adhesive coated surfaces and allow to cure at 25 °C for 24 hours for high strength. Heat up to 93 °C, will speed curing.
7. Keep parts from moving during cure. Contact pressure is necessary. Maximum shear strength is obtained with a 0.1 to 0.2 mm bond line.
8. Excessive uncured adhesive can be cleaned up with ketone type solvents.

Loctite Material Specification^{LMS}

LMS dated July 19, 2001 (Resin) and LMS dated July 19, 2001 (Hardener). Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Loctite Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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Reference 0.2

