

6424 Epoxy Adhesive

Excellent Surface Gloss, High Adhesion Strength, Good Chemical Resistance

UNCURED PROPERTIES		
Product	6424-A	6424-B
Appearance	Viscous Liquid	
Color	White	Yellow
Viscosity, cP @25°C	30,000 – 60,000	20,000 – 36,000
Thixotropic Index	4.3	1
CURING PROPERTIES		
Mix Rate, (A:B) By Weight	2 : 1	
Pot Life, 25°C min	20	
Surface Dry Time, 25°C, hr	2	
Cure Time, @25°C, days	5 - 7	
Cure Time, @80°C, min	20	
Cure Time, @150°C, min	10	
CURED MECHANICAL PROPERTIES		
Glass Transition Temperature, °C	73	
CTE, (60-70°C) $\mu\text{m}/\text{m}/^\circ\text{C}$	115	
CTE, (175-200°C) $\mu\text{m}/\text{m}/^\circ\text{C}$	204	
Hardness, Shore D	84	
Water Absorption, 24hr, %	0.42	
Degradation Temp, (TGA, 10°C/min) °C	312	
Volume Resistivity, ohm-cm	5×10^{15}	
Surface Resistivity, ohm	5×10^{14}	
Dielectric Constant, 100Hz	4.1	

General Information

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

Storage and Shelf Life

Store product in a cool, dark place when not in use. This product has a one year minimum shelf life after date of manufacture, unless otherwise specified, when stored at 60-80°F (16-27°C) in original, unopened containers.

Certification / Recognition

RoHs Complaint: INCURE 6424 complies with the European Union's "Restriction of Hazardous Substances" (RoHs) initiative 2002/95/EC.

Note

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