

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) µm/m/ °C	115	
CTE, (175-200°C) µm/m/ °C	204	
Hardness, Shore D	84	
Water Absorption, 24hr, %	0.42	
Degradation Temp, (TGA, 10°C/min) °C	312	
Volume Resistivity, ohm-cm	5 x 10 ¹⁵	
Surface Resistivity, ohm	5 x 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

The data contained in this technical data sheet are furnished for information only. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein. INCURE will not be liable for any indirect, special, incidental or consequential loss or damage arising from this INCURE product, regardless of the legal theory asserted. INCURE recommends that each user adequately test its proposed use and application before repetitive use, using this data as a guide.