

LOCTITE[®] EA 9481

Known as Hysol 9481
January 2015

PRODUCT DESCRIPTION

LOCTITE[®] EA 9481 provides the following product characteristics:

Technology	Epoxy
Chemical Type (Resin)	Epoxy
Chemical Type (Hardener)	Amine
Appearance (Resin)	white, Translucent liquid ^{LMS}
Appearance (Hardener)	Translucent white, light yellow liquid ^{LMS}
Appearance (Mixture)	Clear paste
Components	Two part - Resin & Hardener
Mix Ratio, by volume - Resin : Hardener	2.7 : 1
Mix Ratio, by weight - Resin : Hardener	100 : 33
Cure	Room temperature cure after mixing
Application	Bonding
Specific Benefit	<ul style="list-style-type: none"> Extended pot life Easy to mix Clear bond lines Extended working life
Key Substrates	Glass, Metals, Circuit boards, Fiber optics and Most plastics
Maximum Gap	3.0 mm

LOCTITE[®] EA 9481 is a general purpose, two component epoxy adhesive, suitable for a wide variety of substrates. It is ideal for bonding fiber optics and printed circuit boards. LOCTITE[®] EA 9481 is designed for use in component assembly, appliances, electronics and fiber optics, and general industrial repairs where clear bond lines and long working life are required.

Note: Dual cartridge dispenses adhesive in a 2 : 1 ratio. Tests show no significant effect on bond performance compared to 2.7 : 1 ratio.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin Properties

Specific Gravity @ 25 °C	1.09 to 1.14 ^{LMS}
Flash Point - See SDS	
Thixotropic Index	5

Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):

Spindle 7,, speed 20 rpm,	75,000 to 105,000
Spindle 7,, speed 2.5 rpm	450,000 to 900,000

Hardener Properties

Specific Gravity @ 25 °C	0.96 to 1.01 ^{LMS}
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 5, speed 5 rpm,	30,000 to 80,000

Mixed Properties

Pot Life @ 25 °C, minutes:	
200 g mass	20 to 70 ^{LMS}

TYPICAL CURING PERFORMANCE

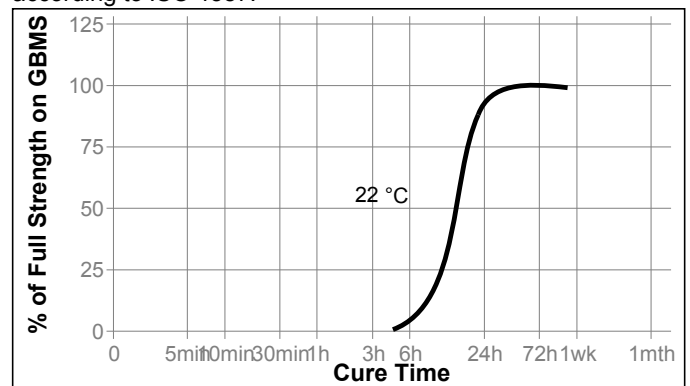
Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, @ 22 °C, hours	5
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Cure Speed vs. Time/Temperature

LOCTITE[®] EA 9481 develops complete cure within 3days at room temperature. Elevated temperatures may be used to accelerate the cure. The following graph indicates development of shear strength on mild steel (grit blasted) lapshears as a function of time and temperature tested according to ISO 4587.



Alternative Curing Conditions

2 hours @ 60 °C
1 hour @ 82 °C
30 minutes @ 120 °C

TYPICAL PROPERTIES OF CURED MATERIAL

4 mm thick samples cured for 7 days @ 22 °C

Physical Properties :

Coefficient of Thermal Expansion ISO 11359-2, K⁻¹:
 Temperature Range: 45 °C to 55 °C 32×10⁻⁶
 Temperature Range: 70 °C to 125 °C 124×10⁻⁶

1.2 mm thick samples cured for 7 days @ 22 °C

Physical Properties :

Coefficient of Thermal Conductivity, , ISO 8302, W/(m-K) 0.4
 Shore Hardness, ISO 868, Durometer D 85
 Glass Transition Temperature, ASTM D 1640, °C 70
 Elongation , ISO 527-3,% 2.85
 Tensile Strength, ISO 527-3 N/mm² 34 (psi) (4,900)
 Tensile Modulus , ISO 527-3 N/mm² 1,676 (psi) (240,000)
 Compressive Strength, ISO 604 N/mm² 76 (psi) (11,000)

Electrical Properties:

Volume Resistivity, IEC 60093, Ω·cm 1×10¹⁵
 Dielectric Breakdown Strength IEC 60243-1, kV/mm 42
 Dielectric Constant / Dissipation Factor, IEC 60250: 1 kHz 3.9 / 5.3×10⁻⁴

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 2 hours @ 60 °C

Lap Shear Strength , ISO 4587:
 Mild Steel (grit blasted) N/mm² 19 (psi) (2,800)
 Stainless Steel N/mm² 14 (psi) (2,000)
 Aluminum (abraded) N/mm² 12 (psi) (1,700)
 (Silicon Carbide Paper, A166 grit, P400A grade)

Impact Resistance , ISO 9653:
 Mild Steel Blocks (grit blasted) kJ/m² 3.9 (ft-lbs/in²) (1.9)

Cured for 5 days @ 22 °C

Lap Shear Strength , ISO 4587:
 Mild steel (grit blasted) N/mm² 16 (psi) (2,300)
 Aluminum (acid etched) N/mm² 10 (psi) (1,500)
 Brass N/mm² 10 (psi) (1,500)
 Zinc dichromate N/mm² 10 (psi) (1,500)
 Galvanized Steel (Hot Dipped) N/mm² 6.7 (psi) (970)
 ABS N/mm² 9 (psi) (1,300)
 GRP N/mm² 8 (psi) (1,200)
 PVC N/mm² 6.6 (psi) (960)
 Glass Fiber Reinforced Epoxy N/mm² 13 (psi) (1,900)

Tensile Strength , ISO 6922:

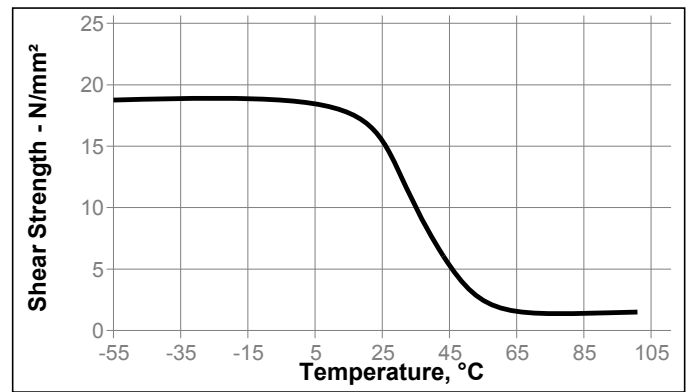
Mild steel pin (grit blasted) to Soda N/mm² 11 (psi) (1,600)
 glass

180° Peel Strength ISO 8510-2:
 Mild steel (grit blasted) N/mm (lb/in) <1 (<5.71)

TYPICAL ENVIRONMENTAL RESISTANCE

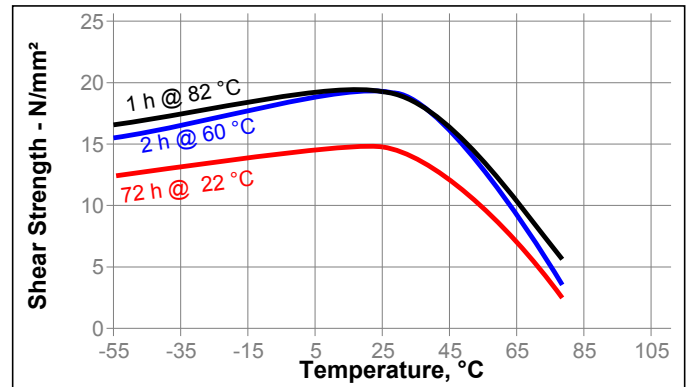
Hot Strength

Tested at temperature:
 Lap Shear Strength , ISO 4587:
 Mild Steel (grit blasted)



Hot Strength

Tested at temperature
 Lap Shear Strength , ISO 4587:
 Aluminum (grit blasted)



Chemical/Solvent Resistance

Cured for 7 days @ 22 °C on mild steel (grit blasted) lapshears with no induced gap, immersed in conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength	
		500 h	1000 h
Motor oil (10W30)	87	80	75
Unleaded gasoline	22	85	75
Water/glycol 50/50	87	70	85
4% Sodium Hydroxide / Water	22	60	-----
98% RH	40	65	55
Water	60	50	45
Water	90	70	45
Acetone	22	75	75
Acetic Acid, 10%	22	75	50
7.5% Salt water solution	22	60	70

Tensile Strength, ISO 6922, Cured for 7 days @ 22 °C, Mild steel pin (grit blasted) to Soda glass

Environment	°C	% of initial strength	
		500 h	1000 h
98% RH	40	35	35

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 Material Safety Data Sheet, (MSDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive.

Directions for use

- For best performance surfaces for bonding should be clean, dry and free of grease. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
- To use, resin and hardener must be blended. Product can be applied directly from dual cartridges by dispensing through the mixer head supplied. Discard the first 3 to 5 cm of bead dispensed. Using bulk containers, mix thoroughly by weight or volume in the proportions specified in the Product Description Matrix. For hand mixing, weigh or measure out the desired amount of resin and hardener and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.
- It is recommended that this product is not mixed and cured in bulk quantities of greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimize the heat build-up.
- Apply the adhesive as quickly as possible after mixing to one surface to be joined. For maximum bond strength apply adhesive evenly to both surfaces. Parts should be assembled immediately after mixed adhesive has been applied.
- For working life please see section 'Typical Properties of Uncured Material'. Higher temperatures and larger quantities will shorten this working time.
- Keep the assembled parts from moving during cure. The

joint should be allowed to develop full strength before subjecting to any service loads.

- Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
- After use and before adhesive hardens, mixing and application equipment should be cleaned with hot soapy water.

Loctite Material Specification^{LMS}

LMS dated May 18, 2005. 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 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 Technical Service Center or Customer Service Representative.

Conversions

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

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference 1.3