

LOCTITE[®] EA 210213

September 2020

PRODUCT DESCRIPTION

LOCTITE[®] EA 210213 provides the following product characteristics:

Technology	Epoxy
Appearance	Light tan
Product Benefits	<ul style="list-style-type: none">• One component• Fast cure• Low temperature cure• Excellent stability
Cure	Heat cure
Application	Structural adhesive, Structural bonding
Typical Applications	Bonding stainless steel cannulae into hubs for needle assemblies

LOCTITE[®] EA 210213 is a one-part, heat cure epoxy adhesive. This adhesive cures rapidly at temperatures as low as 100°C (212°F) while maintaining excellent stability.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield - RTV, 25 °C, mPa·s (cP):	
Spindle SSA #14, speed 20 rpm	31,000
Specific Gravity @ 25°C	1.4

TYPICAL CURING PERFORMANCE

Cure Speed

Typical cure times were estimated as >99% conversion using differential scanning calorimetry

Recommended Cure Schedule

- 24 minutes @ 100°C or
- 13 minutes @ 125°C or
- 10 minutes @ 150°C

The above cure profile are guideline recommendations. These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PERFORMANCE OF CURED MATERIAL

Needle pull strengths were determined using Loctite standard test specimens.

Sample cured 30 minutes @ 100°C.

Miscellaneous

Needle Pull Strength, lb (N):

ABS:

22 Gauge Cannula	68 (15)
27 Gauge Cannula	36 (8)

Polypropylene (plasma treated):

22 Gauge Cannula	40 (9)
27 Gauge Cannula	30 (7)

Polyethylene (plasma treated):

22 Gauge Cannula	49 (11)
27 Gauge Cannula	32 (7)

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

Storage

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

Optimal Storage: 2 to 8 °C. Storage below minus 2°C or above 8°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.

Data Ranges

The data contained herein may be reported as a typical value and/or range values based on actual test data and are verified on a periodic basis.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Conversions

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

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Reference 0.1