Product Description Sheet

LOCTITE® EA 615

Known as
Hysol® Product 615
August 2015

Description
Loctite® EA 615 is epoxy paste adhesives used in many applications where fast cure rates and gap filling are needed. Loctite® EA 615 bonds a variety of materials including metals and plastics.

Features
Quick Set
High Strength
10-20 minute handling
Sandable
Non-Conducting

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 20 grams mins	--	--	10
Color	Blue	White	Light Blue
Viscosity, cP	600,000 to 800,000	100,000 to 180,000	--
Specific Gravity	1.56	1.58	--
Mix Ratio			
By weight	1	1	--
By volume	1	1	--

Typical Properties	Typical Value
Hardness, Shore D	65

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	**Test Temp ºF**	**Typical Value**
24 Hours @ 77ºF	77	2500
	140	800
	180	250

Handling
Mixing: This product requires mixing two components together just prior to application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be close to room temperature.

Application
Mixing - Bulk: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly until the color and consistency are uniform. EPOXI-PATCH® Tube Kits have been designed so that squeezing **EQUAL LENGTH BEADS of Part A & Part B** will give proper ratio. Ratios given above can be used for measuring larger amounts. Mixing the adhesive just prior to use is recommended. Heat buildup during or after mixing is normal. Do not mix quantities greater than one pound as dangerous heat buildup can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat buildup.

Application: Bonding surfaces should be clean and dry. Once the adhesive is applied, the bonded parts should be held in contact until the part has developed handling strength. It is not necessary to clamp the parts unless movement during cure is likely.

Cure: Complete cure is obtained after 24 hours at room temperature. Loctite® EA 615 will achieve handling strength in 10-15 minutes at 77°F (note: this can vary with different bond configurations). Loctite® EA 615 can also be fully cured with heat such as; 5-20 minutes at a maximum of 150°F temperature.

Clean Up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

Storage
Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

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).

Note
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