

LOCTITE EA 9538

May 2014

PRODUCT DESCRIPTION

LOCTITE EA 9538 provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (uncured)	White homogeneous paste
Cure	Heat cure
Specific Benefit	<ul style="list-style-type: none"> One component Fast heat cure Resistant to Gamma sterilization
Application	Needle bonding

LOCTITE EA 9538 is a one component heat cure epoxy resin designed to have suitable flow control during cure. It is designed to be used in needle bonding for medical applications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.3 to 1.4
Casson Viscosity @ 25 °C, Pa·s:	
- Cone & Plate	30 to 40
Casson Yield Point, 25 °C, Pa	17 to 31
Flash Point - See SDS	

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 30 minutes @ 120 °C.

Lap Shear Strength, ISO 4587:

Grit blasted steel	MPa	>10
	(psi)	(>1,450)

Needle Pullout Strength (SOP130), Lb	≥10
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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 Safety Data Sheet (SDS).

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. In some cases these aqueous washes can affect the cure and performance of the adhesive.

Directions for use:

1. For best performance bond surfaces should be clean, dry and free from grease.
2. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
3. Keep assembled parts from moving during cure. The bond should be allowed to develop full strength before subjecting to any service load.
4. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
5. It is recommended that this product is not cured in large quantities as excessive heat build-up and uncontrolled exothermal runaway can occur. Curing smaller quantities will minimize the heat build-up.

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.

Storage

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

Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 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 Technical Service Center or Customer Service Representative.

Conversions

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

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 0.0