



Authorized Distributor



718 Park East Drive , Woonsocket, RI., USA, 02895  
Phone: (401) 726-4500 ■ Fax: (401) 726-4502  
Email: [info@epoxyset.com](mailto:info@epoxyset.com) ■ Web: [www.epoxyset.com](http://www.epoxyset.com)

# TECHNICAL BULLETIN

## EPOXIBOND-116LV HIGH STRENGTH, FLEXIBLE EPOXY ADHESIVE

**EB-116LV** is a clear, low viscosity, high strength, structural epoxy adhesive. This tough adhesive has an excellent combination of shear and peel strength. It has also excellent impact and vibration resistance and low temperature flexibility. This high performance epoxy adhesive exhibits very good physical, thermal, and electrical insulation properties. It is recommended for bonding glass, metal, ceramics, and engineering thermoplastics. Due to its low viscosity, it can be also used for potting and encapsulating electrical/electronic components.

<b><u>TYPICAL HANDLING PROPERTIES:</u></b>	
Epoxibond	116LV-A
Hardener	116LV-B
Mix ratio by weight, (PART-A/PART-B)	100/100
Mix viscosity at 25°C, cp	2000
Pot Life at 25°C (25 grams), hours	2
Recommended Cure	2 hr at 65°C
Alternate Cure	48 hr at 25°C
<b><u>TYPICAL CURED PROPERTIES</u></b>	
(Tested @ 25°C unless otherwise indicated)	
Color	Amber
Specific Gravity	1.1
Hardness, Shore D	72
Lap Shear Strength to Aluminum, psi	3000
T-peel strength to aluminum, pli	23
Service Temperature range, °C	-55 to 90
Glass Transition Temperature, °C	40
Coefficient of Linear Thermal Expansion, 10 <sup>-6</sup> /°C	
From -55°C to 25°C	97
From 25°C to 90°C	180
Dielectric Strength, Volts/mil	380
Dielectric Constant, 1 kHz	3.81
Dissipation Factor, 1 kHz	0.4
Volume Resistivity, ohm-cm	2x10 <sup>13</sup>

### **INSTRUCTIONS FOR USE:**

1. Mix at room temperature, 100 grams of Part-A with 100 grams of Part-B and vacuum degas.
2. Cure as recommended to achieve the desired properties.
3. Typical cured properties were determined using recommended cure schedule.
4. Some difference in properties may occur with the alternate or other cure schedules.

**NOTE:** For more flexibility, use 2 parts of Part-A to 3 parts of Part-B by weight.

### **FOR INDUSTRIAL USE ONLY:**

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

### **WARNING!**

Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of work place and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. In case of skin contact, wash thoroughly with soap and water. For eyes, flush immediately with plenty of water for at least 10 minutes and seek medical attention. Refer to Material Safety Data Sheet for additional health and safety information.

### **SHELF LIFE:**

The shelf life of these materials is greater than two years when stored in unopened containers at an average temperature of 25°C.

**DISCLAIMER:** All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.