Technical Data Sheet

LOCTITE ECCOBOND 3193-17

November 2012

PRODUCT DESCRIPTION

LOCTITE ECCOBOND 3193-17 provides the following product characteristics:

Technology	Epoxy
Appearance	Gray
Cure	Heat cure
Product Benefits	• Thixotropic • One component • Fast oven cure • Process ease • Compatible for use with plastics
Percent Solids, %	100
Application	Assembly
Typical Assembly Applications	Ink jet applications and MEMS devices
Operating Temperature	-40 to +130 °C

LOCTITE ECCOBOND 3193-17 is designed for bonding dissimilar substrates used in ink jet applications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Sag Resistance, inch	0.4 to 0.8
Density , g/cm³	1.17
Shelf Life @ 0°C, months	3

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Cure Schedule

60 minutes @ 100°C or
45 minutes @ 120°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 120ºC in masses up to approximately 30grams.

Cure continues at room temperature. Properties continue to improve 2 to 4days after cure at oven times and temperature shown. Longer cure times in the oven also improve properites.

Alternate cure schedules may also be possible. Contact your Henkel representative for further information.

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

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties :

Hardness, Shore D:	
@ 25°C,	80
@ 100°C,	48

GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.

DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. Apply adhesive to all surfaces to be bonded and join together.
3. In most applications only contact pressure is required.
4. Usable shelf life may vary depending on method of application and storage conditions.
5. Do not open containers while product is cold or submit liquid material to a high humidity environment.

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 : 0 °C

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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Disclaimer

Note:

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