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Technical Data Sheet

Hysol® Product E-20HP

formerly Durabond E-20HP

Industrial Version, April 2004

PRODUCT DESCRIPTION

LOCTITE® Hysol® Product E-20HP is a toughened, medium-viscosity, industrial grade epoxy adhesive with a medium work life. Once mixed, the two-component epoxy cures at room temperature to form a tough, off-white, bondline that provides high peel resistance and high shear strengths. The fully cured epoxy is resistant to a wide range of chemicals and solvents, and acts as an excellent electrical insulator.

TYPICAL APPLICATIONS

The high performance epoxy provides excellent bond strengths to a wide variety of plastics and metals. Ideal for general purpose industrial assemblies. Used as adhesive for bonding dry concrete or limestone for architectural applications.

PROPERTIES OF UNCURED MATERIAL

Resin	Typical	
	Value	Range
Chemical Type	Epoxy	
Appearance	Pale yellow liquid	
Specific Gravity @ 25°C	1.00	0.9 to 1.1
Viscosity @ 25°C, mPa.s (cP)	65,000	40,000 to 90,000
Flash Point (TCC), °C (°F)	>93 (>200)	

Hardener	Typical	
	Value	Range
Chemical Type	Amine	
Appearance	Yellow liquid	
Specific Gravity @ 25°C	1.10	1.0 to 1.2
Viscosity @ 25°C, mPa.s (cP)	7,000	5,500 to 8,000
Flash Point (TCC), °C (°F)	>93 (>200)	

Mixture	Typical Value
Appearance	Off-white
Specific Gravity @ 25°C	1.03
Mix Ratio (R:H) by Weight	100 to 55
by Volume	2 to 1

Curing Properties

	Typical Value
(@ 25°C unless noted)	
Working Life, minutes	20
Tack Free time, minutes	40

TYPICAL PROPERTIES OF CURED MATERIAL

	Typical Value
(@ 25°C unless noted)	
Physical Properties	
Dielectric Strength, Volts/Mil	500
Tensile Strength ASTM D638, psi	5,700
Tensile Elongation ASTM D-638, %	8
Hardness ASTM D-1706, Shore D	80
Glass Transition Temperature, Tg, °C	60

PERFORMANCE OF CURED MATERIAL

Shear Strength vs Substrate

(Substrates cured for 5 days @ 22°C)

Substrate	Typical Value	
	N/mm ²	(psi)
Lapshear		
Grit-Blasted Steel	22.6	3270
Aluminum (Abraded/Acid Etched, 3 to 9 mil gap)	28.2	4090
Aluminum (Anodized)	17.4	2530
Stainless Steel	22.0	3190
Polycarbonate	3.9	560
Nylon	1.8	260
Wood (Fir)	11.4	1660

Block Shear

	N/mm ²	(psi)
PVC	7.9	1140
ABS	10.4	1510
Epoxy	28.6	4140
Acrylic	2.0	290
Glass	32.3	4690

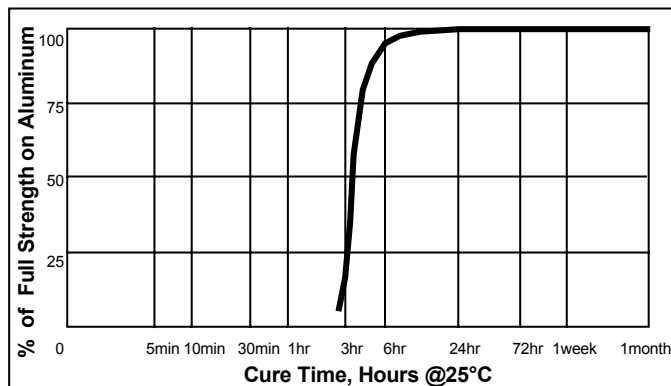
Concrete Strength by ASTM C881/C882-99

E-20 HP passes the requirements of a type IV epoxy. During testing the concrete fractured prior to the adhesive failing. The test was modified as we do not recommend it be used on wet surfaces.

TYPICAL CURING PERFORMANCE

Cure speed

The graph below shows the shear strength developed over time on abraded, acid etched aluminum lap shears with an average bondline gap of 3 to 9 mils and tested according to ASTM D-1002.

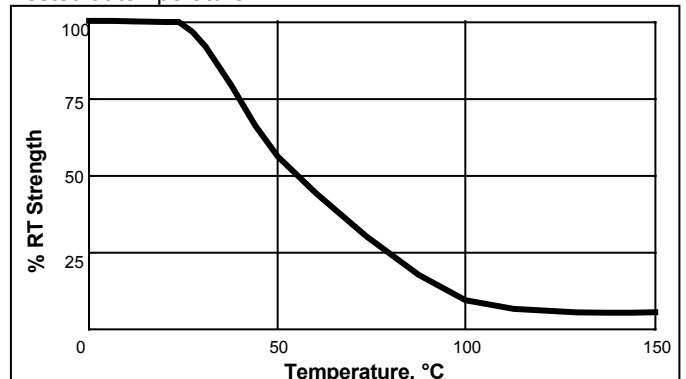


TYPICAL ENVIRONMENTAL RESISTANCE

Hot Strength

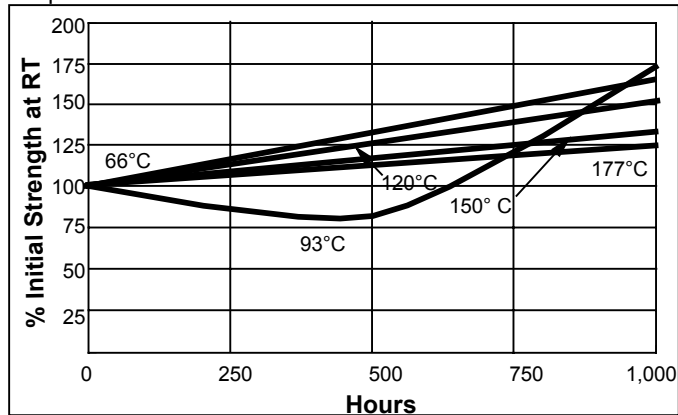
Test procedure :	ASTM D-1002
Substrate:	Abraded, acid etched aluminum
Bondline gap, mils:	3 to 9
Cure procedure:	12 hours at 65°C & 4 hours at 22°C

Tested at temperature.



Heat Aging

Cured for 5 days at 22°C on steel with no induced gap, aged at temperature indicated and tested at 22°C.



Chemical / Solvent Resistance

Cured for 5 days at 22°C on steel with no induced gap, aged under conditions indicated and tested at 22°C.

Solvent	Temp.	% Initial Strength retained at	
		500 hr	1000 hr
Air	87°C	-	137
Motor Oil (10W-30)	87°C	164	171
Unleaded Gasoline	87°C	108	82
Water/Glycol (50%/50%)	87°C	121	125
Salt/Fog ASTM B-117	22°C	-	73
95% Relative Humidity	38°C	-	100
Condensing Humidity	49°C	-	90
Water	22°C	-	81
Acetone	22°C	76	95
Isopropyl Alcohol	22°C	87	125

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).

Directions for use

- For high strength structural bonds, removal of surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
- Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
- Dual Cartridges:** To use simply insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. If automatic mixing of resin and hardener is desired, attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of the adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained. **Bulk Containers:** Mix thoroughly by weight or volume in the proportions specified in Properties of Uncured Material section. Mix vigorously approximately 15 seconds after uniform color is obtained.

- For maximum bond strength apply adhesive evenly to both surfaces to be joined.
- Application to the substrates should be made within 20 minutes. Larger quantities and/or higher temperatures will reduce this working time.
- Join the adhesive coated surfaces and allow to cure at 25°C (77°F) for 24 hours for high strength. Heat up to 93°C (200°F), will speed curing.
- Keep parts from moving during cure. Contact pressure is necessary. Maximum shear strength is obtained with a 3-9 mil bond line.
- Excess uncured adhesive can be cleaned up with ketone type solvents.

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

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

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.