

LOCTITE® EA 9930

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Product description

LOCTITE® EA 9930 provides the following product characteristics:

Technology	Epoxy
Appearance	Amber
Product benefits	<ul style="list-style-type: none">• One component• Visible light curable• Good adhesion and impact strength• Re-workable
Cure	UV cure
Application	Encapsulants, Structural bonding
Key substrates	Copper, Ink Glass

LOCTITE® EA 9930 is a high performance visible light curable material specifically designed to suit for structural material for molding. It is applied at room temperature and visible light cured.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, CP51, mPa.s (cP) 10 rpm	10,000
Thixotropic Index CP51, (1 rpm/10 rpm)	2.5
Shelf life @ 2-8°C, days	180
Work life, days Viscosity change ≤ 20%	1

TYPICAL CURING PERFORMANCE

UV cure light source	LED
UV wavelength, nm	470
Light intensity, mW/cm ²	350
Exposure time, min	5
Depth of cure, mm	> 4

LOCTITE® EA 9930 can be cured by exposure to visible light of sufficient intensity. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of the light source, exposure time and light transmittance of the substrate through which the light must pass.

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

TYPICAL PROPERTIES OF CURED MATERIALSample cured 5 min @ 350mW/cm², 470nm**Physical properties**

Glass transition temperature, DMA, °C	75
Storage modulus, DMA, 25°C, GPa	2.1

Adhesive propertiesSample cured 5 min @ 350mW/cm², 470nm**Adhesion properties**

Block shear strength, kgf	
Adhesion on ink glass, after 24 hours	15.0
C-IC	9.0

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

Thawing

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
4. DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.



Direction for use

1. This product is UV light sensitive: exposure to daylight, UV light, and artificial lighting should be kept to a minimum during storage and handling.
2. Cure rate is dependent on lamp intensity, distance from light source, depth of cure needed or bondline gap and light transmission of the substrate through which the radiation must pass.
3. Thawed material should immediately be placed on dispense equipment for use.
4. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
5. Adhesive must be completely used within the product's recommended work life.
6. Alternate dispense amounts may be used depending on the application requirements.
7. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.

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 the specifications of 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: 2-8 °C

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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 Henkel representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 KV/mm x 25.4 = V/mil
 mm / 25.4 = inches
 $\mu\text{m} / 25.4 = \text{mil}$
 N x 0.225 = lb
 N/mm x 5.71 = lb/in
 N/mm² x 145 = psi
 MPa x 145 = psi
 N·m x 8.851 = lb·in
 N·m x 0.738 = lb·ft
 N·mm x 0.142 = oz·in
 mPa·s = cP

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Reference 1