Laboratory Data Sheet

Loctite® E-4100

(Formerly BMS Eccobond A 410-5P)

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PRODUCT DESCRIPTION

LOCTITE® Product E-4100 is single component epoxy that bonds well to metals, thermoset and composite materials. The single component epoxy cures at elevated temperatures.

FEATURES

- High strength
- High impact strength
- High vibration resistance
- Excellent durability

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy
Appearance	Gray Paste
Viscosity	High
Specific Gravity, 25°C	1.50

CURING PROPERTIES

The product may generate excessive heat if cured in thicknesses greater than 0.25 inch at temperatures above 300ºF.

Temperature (°F)	Cure Time, min
275	40
300	30
325	15
350	5

Curing large or massive assemblies may require additional time to reach the cure temperature.

LAP SHEAR STRENGTH (ASTM D-1002)

Material	Typical Value, psi
Steel / Steel	3500
Aluminum / Aluminum	4000
Stainless Steel / Stainless Steel	3000
Copper / Copper	2000*
Brass / Brass	2000*
Ferrite / Ferrite	1000*
SMC Plastic / SMC Plastic	1000*

* Denotes substrate failure of the bonded joint

THERMAL RANGE

Property	Typical Value
Long Term Service, °F	-40 to 350
Intermittent Service, °F	-40 to 375

USE AND APPLICATION

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).

Storage

Store product frozen, in a dry location, in unopened containers at a temperature between -20°C (-4°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 Application Engineering at (860) 571-5100.

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

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