

LOCTITE EDAG 24639 SS E&C

March 2019

PRODUCT DESCRIPTION

LOCTITE EDAG 24639 SS E&C provides the following product characteristics:

Technology	Thermoplastic
Appearance	Silver
Product Benefits	<ul style="list-style-type: none">• Easily applied by flexigraphic or rotogravure print techniques
Cure	Air dry
Application	Conductive coating
Typical Assembly Applications	<ul style="list-style-type: none">• Body contact pads• Medical sensors• ECG/EKG disposable electrodes• TENS pads

LOCTITE EDAG 24639 SS E&C medical EKG coating is designed to provide controlled electrical properties on flexible substrates. This adhesive is compatible with EDAG E&C silver and carbon inks.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Solids Content by Weight, %	62
Viscosity, Brookfield -5 minutes paint shake, - RVT3, 25 °C, mPa·s (cP):	
Speed 20 rpm	600
Density, kg/l	1.92
VOC, g/l	720
Shelf Life @8 to 28°C, days (from date of qualification in original seal)	365
Flash Point, °C	14

TYPICAL DRYING CYCLE**Recommended Drying Cycle**

Recommended Application Thickness:

0.3 mil dried:

15 minutes @ 94°C

5 minutes @ 121°C

The curing time of LOCTITE EDAG 24639 SS E&C will vary depending upon the thickness of the film layer and the application.

Other factors decreasing curing time are air flow, infrared and bottom heating.

Force dry coated film with high velocity hot air or infrared systems. High temperatures for long duration improve performance. Design drying rates for the maximum the

substrate and production speeds can tolerate.

The above drying profile is a guideline recommendation. Conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer drying equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL**Physical Properties**

Theoretical Coverage @ 25µm:

sq ft/gal	301
m ² /l	7.4
m ² /kg	3.89

Electrical Properties

Sheet Resistance, ohms/sq/mil	<0.15
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GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. This product is supplied ready for use.
2. Should thinning become necessary, dilute 5% by weight with n-Propylacetate.
3. Recommended thickness: 0.05 to 0.3 mil dried.

Mixing/Dilution

1. LOCTITE EDAG 24639 SS E&C can be gently stirred or placed on a paint shaker prior to use.
2. Avoid rapid stirring, as this causes air entrapment.
3. Avoid contact with any metallic materials.
4. Use plastic spatulas, plastic containers.

CLEAN-UP

- To clean screen and equipment, use MEK, MIBK, Acetone or similar solvents.

STORAGE:

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage : 8 to 28 °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.

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.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb/F}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{psi} \times 145 = \text{N/mm}^2$
 $\text{MPa} = \text{N/mm}^2$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference 2

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