

**LOCTITE OPL 6E**

December 2016

**PRODUCT DESCRIPTION**

LOCTITE OPL 6E provides the following product characteristics:

<b>Technology</b>	Photopolymer
Color	Hazy white
Color (Cured)	Light Yellow
<b>Cure</b>	Ultraviolet (UV) light
<b>Application</b>	Non-conductive adhesive

LOCTITE OPL 6E is a single component optical adhesive.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Brookfield Viscosity SSA, #15/7R, mPa·s (cP):  
Speed 100 rpm 60

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties :**

Hardness, Shore D 85  
Glass Transition Temperature (T<sub>g</sub>), °C 45

**GENERAL INFORMATION**

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

**DIRECTIONS FOR USE**

1. Carefully clean and dry all surfaces to be bonded.
2. If packaged in BIPAX, remove clamp and thoroughly mix the LOCTITE OPL 6E epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout.
3. If pre-mixed and frozen, thaw adhesive to room temperature. A 25°C water bath is recommended.
4. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
5. Cure at recommended cure schedules.

**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:**

The expiration date is based upon dry storage conditions at or below 27°C, unless specified otherwise on the packaging, in the original, sealed and unopened containers for BIPAX, TRA-PAX and bulk packaged materials. The expiration date for pre-mixed and frozen materials is based upon dry storage conditions at or below the temperature indicated on each package. Contents may separate during storage. Resin or hardener in bulk containers (e.g., quarts, gallons) should be thoroughly mixed prior to combining them to obtain all the benefits of the properties designed into the formulation. Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage : 27 °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/mm<sup>2</sup>  
MPa = N/mm<sup>2</sup>  
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:**

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 1

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