

PRODUCT DESCRIPTION

LOCTITE® PE 3144 Epoxy Resin is a potting compound resin that offers improved flame retardance when mixed with LOCTITE® PE 3163. This mixture forms a resilient, long work time, no blush potting compound with good surface finish and good bond strength to most thermoplastics.

PROPERTIES OF UNCURED MATERIAL (Resin)

	Typical Value
Chemical Type	Epoxy resin
Appearance	Black
Viscosity, Spindle #6 @ 20 RPM, 25°C, cP	18,000
Specific Gravity	1.68

PROPERTIES OF UNCURED MATERIAL (Hardener)

	Typical Value
Chemical Type	Epoxy hardener
Appearance (mixed)	Clear (black)
Viscosity, Spindle #2 @ 20 RPM, 25°C, cP	450
Specific Gravity	0.96

PROPERTIES OF CURED MATERIAL

	Typical Value
Vol. Mix Ratio, Resin:Hardener	3.5:1
Weight Mix Ratio, Resin:Hardener	100:16
Mixed Specific Gravity	1.53
Mixed Viscosity, Spindle 4 @ 20 rpm 25°C, cP	2,500
Work Time, 200g (25°C)	3 hours
Gel Time, 200g (25°C)	> 5 hours
Regular Cure Schedule (25°C)	24 hr & 2 hr (121°C)
Alternate Cure Schedule (66°C)	4 hrs 66°C & 2 hrs 121°C
CTE below Tg, ASTM E831 (mm/mm°C)	67.1 E-06
Tg, ASTM D3418-82, °C	20
CTE above Tg, ASTM E831 (mm/mm°C)	140 E-06
Hardness, ASTM D2240, Shore D	75

Electrical Properties

Dielectric Constant, ASTM D150	0.1 kHz	4.29
	1.0 kHz	4.03
	10 kHz	3.84
	100 kHz	3.70
Dissipation Factor, ASTM D150	0.1 kHz	0.04
	1.0 kHz	0.04
	10 kHz	0.03
	100 kHz	0.02
Insulation, ASTM D257, ohms		1.60 E12
Volume Resistivity, ASTM D257, Ω.cm		1.05 E14
Dielectric Strength, ASTM D149, V/mil		360

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).

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 0°C (32°F) or less. 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.

Properties of Uncured Material

	Specific Gravity	Viscosity, cP @ 25°C	Color	Mixed Color
LOCTITE PE 3144 Epoxy Resin	1.68	18,000	Black	
LOCTITE PE 3160 Epoxy Hardener	1.00	180	Clear	Black
LOCTITE PE 3162 Epoxy Hardener	0.99	120	Clear	Black
LOCTITE PE 3163 Epoxy Hardener	0.96	450	Clear	Black
LOCTITE PE 3164 Epoxy Hardener	0.97	105	Clear	Black
LOCTITE PE 3165 Epoxy Hardener	0.96	55	Clear	Black

Curing Properties of the Systems (All Properties in Conjunction with LOCTITE PE 3144 Epoxy Resin)

Hardener	Vol. Mix Ratio <i>Resin: Hardener</i>	Weight Mix Ratio <i>Resin: Hardener</i>	Mixed Specific Gravity	Mixed Viscosity, cP @ 25°C	Work Time 200g (25°C, 77°F) unless otherwise noted	Gel Time 200g (25°C, 77°F) unless otherwise noted	Regular Cure Schedule (25°C, 77°F)	Alternate Cure Schedule (66°C, 150°F)
Loctite PE 3160 Epoxy Hardener	3.4:1	100:17.5	1.54	6,000	80 – 100 min	2.5-3 hours	24 hr	2 hours
Loctite PE 3162 Epoxy Hardener	4.5:1	100:13	1.52	4,000	15 – 20 min	30-40 min	16 hr	2 hours
Loctite PE 3163 Epoxy Hardener	3.5:1	100:16	1.53	2,500	3 hours	> 5hours	24 hr (25°C) & 2 hr 121°C	4 hours (60°C) & 2 hr 121°C
Loctite PE 3164 Epoxy Hardener	2.8:1	100:21	1.50	3,000	30 – 40 min	60-90 min	24 hr	2 hours
Loctite PE 3165 Epoxy Hardener	9.3:1	100:6.1	1.62	7,000	3 hours/400g	6 hours/400g	24 hr (25°C) & 2 hr 93°C	4 hours (93°C)

Cured Properties of the System

Hardener	CTE below Tg (mm/mm°C)	Tg, °C	CTE above Tg, (mm/mm°C)	Hardness Shore D
Loctite PE 3160 Epoxy Hardener	48.2 E-06	12	138 E-06	75
Loctite PE 3162 Epoxy Hardener	39.0 E-06	25	138 E-06	80
Loctite PE 3163 Epoxy Hardener	67.1 E-06	20	140 E-06	75
Loctite PE 3164 Epoxy Hardener	93.4 E-06	15	147 E-06	55
Loctite PE 3165 Epoxy Hardener	42.1 E-06	28	109 E-06	85

Hardener	Dielectric Constant			
	Frequency			
	0.1 KHz	1.0 KHz	10 KHz	100 KHz
Loctite PE 3160 Epoxy Hardener	4.74	4.53	4.39	4.28
Loctite PE 3162 Epoxy Hardener	4.24	4.12	4.03	3.96
Loctite PE 3163 Epoxy Hardener	4.29	4.03	3.84	3.70
Loctite PE 3164 Epoxy Hardener	5.31	4.87	4.52	4.23
Loctite PE 3165 Epoxy Hardener	4.26	4.17	4.10	4.05

Hardener	Dissipation Factor			
	Frequency			
	0.1 KHz	1.0 KHz	10 KHz	100 KHz
Loctite PE 3160 Epoxy Hardener	0.03	0.03	0.02	0.02
Loctite PE 3162 Epoxy Hardener	0.02	0.02	0.01	0.01
Loctite PE 3163 Epoxy Hardener	0.04	0.04	0.03	0.02
Loctite PE 3164 Epoxy Hardener	0.06	0.06	0.05	0.04
Loctite PE 3165 Epoxy Hardener	0.01	0.01	0.01	0.01

Hardener	Insulation Resistance, ohms	Volume Resistivity, Ω.cm	Dielectric Strength, Volts/mil
Loctite PE 3160 Epoxy Hardener	5.52 E12	3.15 E14	375
Loctite PE 3162 Epoxy Hardener	1.79 E13	7.97 E14	375
Loctite PE 3163 Epoxy Hardener	1.60 E12	1.05 E14	360
Loctite PE 3164 Epoxy Hardener	4.23 E10	2.58 E12	365
Loctite PE 3165 Epoxy Hardener	3.14 E13	1.84 E15	340

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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