

## Properties

Polytec EP 660 is a 100% solid, two-component, low viscosity, high temperature and high  $T_g$  epoxy, impregnation and coating material.

Polytec EP 660 has an excellent chemical and moisture resistance and can withstand operating temperatures up to 300°C.

It is recommended as sealant and impregnation for all soaking surfaces like ceramics, woods, plastics, High-Temp fabric and powders as well as fiber bundles. A typical application is the impregnation and sealing of the magnesium oxide filler in tubular heaters / heating elements.

The material can be applied via dispensing, jet-dispensing and manual application.



## Processing

- For two-component products the components A and B should be mixed carefully within the specified mixing ratio.
- For filled products both components should be homogenized carefully prior mixing, in order to prevent a possible settling of the filler.
- Processing should be carried out rapidly after mixing the components; as an indication the pot life can be used.
- Surfaces should be clean, thus free of dirt, grease, oil, dust or process chemicals.
- One-component products can be applied directly and are not subject to a pot life (except pre-mixed/frozen products).
- Please take notice of respective minimum curing temperature and time.
- For Safety information please refer to the respective Material Safety Data Sheet.

# Polytec EP 660

## Unfilled Epoxy Adhesive

### Technical Data

# Polytec EP 660

Properties in uncured state	Method	Unit	Technical Data
Chemical basis	-	-	Epoxy
No. of components	-	-	2
Mixing ratio (weight)	-	-	100:17
Mixing ratio (volume)	-	-	100:20
Pot life at 23°C	TM 702	min	45
Storage Stability at 23°C	TM 701	Months	12
Consistency	TM 101	-	Flowable liquid
Density Mix	TM 201.2	g/cm <sup>3</sup>	1.12
Density A-Part	TM 201.2	g/cm <sup>3</sup>	1.18
Density B-Part	TM 201.2	g/cm <sup>3</sup>	0.96
Viscosity Mix 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	2 500
Viscosity A-Part 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	13 000
Viscosity B-Part 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	30

Properties in cured* state	Method	Unit	Technical Data
Color	TM 101	-	Light yellow
Hardness (Shore D)	DIN EN ISO 868	-	85
Temperature resistance continuous	TM 302	°C	-55 / +240
Temperature resistance short term	TM 302	°C	-55 / +300
Degradation Temperature	TM 302	°C	+350
Glass Transition Temperature (T <sub>g</sub> )	TM 501	°C	120
Coefficient of thermal expansion (<T <sub>g</sub> )	ISO 11359-2	ppm	27
Coefficient of thermal expansion (>T <sub>g</sub> )	ISO 11359-2	ppm	142
Thermal conductivity	-	W/m·K	-
Elasticity modulus	TM 605	N/mm <sup>2</sup>	3 800
Tensile Strength	TM 605	N/mm <sup>2</sup>	87
Lap shear strength (Al/Al)	TM 604	N/mm <sup>2</sup>	19
Elongation at break	TM 605	%	5.6
Water absorption 24 h, 23°C	TM 301	%	0.18
Refractive index	-	-	-

\*The above data has been determined with samples cured at 150°C. Please notice, by varying the curing temperature these properties can be influenced to some extent.

# Polytec EP 660

Curing*	Method	Unit	Technical Data
Minimum curing temperature		°C	15
Curing time at 23°C		h	16
Curing time at 80°C		min	-
Curing time at 120°C		min	30
Curing time at 150°C		min	15
Curing time at 180°C		s	-

\*Curing temperatures refer to the temperature in the respective bond line. When choosing the respective curing conditions, the time needed to heat the substrate has to be considered. Depending on the type of heat source (convection oven, hot stamp, heating plate) the heat input may vary.

## Standard pack sizes:

250 g, 500 g

1 kg

Customized packaging

**This adhesive reacts exothermically after mixing. Do not mix more than 15g at once!**  
**For larger volumes, the adhesive can be processed in a two-component mixing and dosing system with dynamic mixers. On request, we are pleased to send you information about suitable systems.**

## Please note:

The information listed above is typical data based on tests and is believed to be accurate. Polytec PT makes no warranties (expressed or implied) as to their accuracy. The data listed above does not constitute specifications. The processing (particularly the curing conditions) of the material, the process control, and the variety of different applications at various customers are not under Polytec PT's control. Therefore, Polytec PT will not be liable for concrete results in any specific application or in any connection with the use of this product. The curing conditions have a major effect on the properties of the cured material. Therefore, it is highly recommended to keep the curing schedule – once established - under tight control. With the release of this data sheet all former data sheets will be null and void.

Subject to alteration.

**Polytec PT GmbH**  
**Polymere Technologien**

**Ettlinger Straße 30**  
**76307 Karlsbad**  
**Germany**  
**Phone +49 (0)7202 706-3500**

**info-pt@bostik.com**  
**www.polytec-pt.de**

**Polytec PT GmbH**  
**Polymere Technologien**  
**plant Maxdorf**

**Bahnhofstraße 1**  
**67133 Maxdorf**  
**Germany**

**info-pt@bostik.com**  
**www.polytec-pt.de**