

OPTOLINQ LE-EP246D



Optically Transparent Epoxy Resin for Casting

- Long working time and low viscosity
- Perfect surface gloss
- Good chemical resistance

OPTOLINQ LE-EP246D is a two-component, low viscosity epoxy with excellent handling properties, chemical resistance, and high-gloss finish. It is ideal for potting, casting, sealing, encapsulation, and adhesive applications in electronic components, as well as for general industrial uses requiring extended work life.

The hardener of **OPTOLINQ LE-EP246D** does not form insoluble, whitish solids, even after being exposed to air. The cured surface remains oil-free while maintaining excellent gloss retention. Additionally, **OPTOLINQ LE-EP246D** offers excellent electrical insulation properties under high humidity conditions, withstands exposure to a wide range of chemicals and solvents, and complies to RoHS 2011/65/EU Directive.

Uncured Properties

Property	Part A	Part B	Unit
Appearance	Liquid, Colorless	Liquid, Colorless	–
Viscosity (25 °C)	3000–5000 (*)	≤ 50 (**)	cP
Specific Gravity	1.16	0.98	–
Mixed Liquid Properties			
Appearance	Liquid, Colorless		–
Viscosity (25 °C)	262.5 (*)		cP
Refractive Index nD (25.6 °C)	1.532		–

*Spindle 14, 100 rpm, **Spindle 21, 100 rpm

Recommended Curing Conditions

Property	Value	Unit
Mixing Ratio (A:B)	100:33	by weight
Pot Life (25 °C)	8	h
Through Cure Time		
at 25 °C	5–7	day
at 80 °C	3	h

Instructions for Use

1. Thoroughly mix the A and B components at a 100:33 weight ratio. Continue mixing for approximately 15 seconds after a uniform color is achieved.
2. For large-scale castings, perform a pre-cure at a lower temperature followed by a full cure at a higher temperature to minimize heat generation
3. The actual cure time will vary based on part geometry, materials, bond line thickness, and oven efficiency. Verify the cure schedule using production parts and equipment.

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Cured Properties

Property	Value	Unit
Hardness	82	Shore D
Spectral Transmission		
at 1,200–4,000 nm	80	%
at 900–1200 nm	80	
at 550–900 nm	>96	
Shear Strength (Al vs. Al)	17.6	MPa
Tensile Strength	50	MPa
Tensile Modulus	900	MPa
Elongation	10	%
Toughness	5	Pa
Notched Izod Impact Strength	5.9	N
Weight Loss Ratio (100 °C)	0	%
Weight Loss Ratio (300 °C)	2.7	%
Glass Transition Temperature (TMA)	90	°C
Coefficient of Thermal Expansion (CTE), α_1	38	ppm/°C
Coefficient of Thermal Expansion (CTE), α_2	230	ppm/°C
Degradation Temperature (TGA, 10 °C /min)	324	°C
Surface Resistivity	5×10^{14}	Ω
Volume Resistivity	4.5×10^{15}	$\Omega \cdot \text{cm}$
Dielectric Constant (100 Hz)	4.1	–
Water Absorption Ratio (25 °C/24 h)	1.59	%

Note: Sample was cured at 80 °C for 3 hours.

Caution for Use

While this product shows low carcinogenicity risk from skin contact, mild redness may occur; wash with soap and water, avoiding solvents. It is moderately toxic if ingested, requiring immediate medical attention. Flush eyes with water for 15 minutes and seek medical help if contact occurs. Consult the MSDS for comprehensive safety details.

Storage and Handling

Store the container in a cool, dark place, away from direct sunlight. Exposure to sunlight may cause the resin and hardener to yellow. Shelf life when stored at room temperature between 14 and 34 °C is 365 days (12 months). Keep the container sealed and prevent moisture contamination when not in use. This product contains mercaptan; be sure to replace the lid immediately after each use.

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