

**Date:** June 2022  
**Rev:** VIII  
**No. of Components:** Two  
**Mix Ratio by Weight:** 10 : 1  
**Specific Gravity:** Part A: 3.10 Part B: 0.96  
**Pot Life:** 6 Hours  
**Shelf Life- Bulk:** One year at room temperature

**Recommended Cure: 150°C / 1 Hour**

Minimum Alternative Cure(s):

*May not achieve performance properties listed below*

150°C / 15 Minutes

80°C / 3 Hours

23°C / 3 Days

### NOTES:

- Container(s) should be kept closed when not in use.
- Filled systems should be stirred thoroughly before mixing and prior to use.
- Performance properties (rheology, conductivity, others) of the product may vary from those stated on the data sheet when bi-pak/syringe packaging or post-processing of any kind is performed. Epoxy's warranties shall not apply to any products that have been reprocessed or repackaged from Epoxy's delivered status/container into any other containers of any kind, including but not limited to syringes, bi-paks, cartridges, pouches, tubes, capsules, films or other packages.
- Syringe packaging will impact initial viscosity and effective pot life, potentially beyond stated parameters.

**Typical Properties:** Cure condition: 150°C / 1 Hour Different batches, conditions & applications yield differing results.

Data below is not guaranteed. To be used as a guide only, not as a specification. \* denotes test on lot acceptance basis

PHYSICAL PROPERTIES:				
* Color (before cure):	Part A: Silver	Part B: Clear		
* Consistency:	Smooth flowing paste			
* Viscosity (23°C) @ 100 rpm:	350 - 850	cPs		
Thixotropic Index:	1.9			
* Glass Transition Temp:	≥ 40	°C (Dynamic Cure: 20-200°C/ISO 25 Min; Ramp -10-200°C @20°C/Min)		
Coefficient of Thermal Expansion (CTE):				
	Below Tg:	50	x 10 <sup>-6</sup> in/in°C	
	Above Tg:	283	x 10 <sup>-6</sup> in/in°C	
Shore D Hardness:	60			
Lap Shear @ 23°C:	1,080	psi		
Die Shear @ 23°C:	≥ 5	Kg	1,778	psi
Degradation Temp:	365	°C		
Weight Loss:				
	@ 200°C:	0.33	%	
	@ 250°C:	0.65	%	
	@ 300°C:	1.19	%	
Suggested Operating Temperature:	< 250	°C (Intermittent)		
Storage Modulus:	788,340	psi		
Ion Content:	Cl <sup>-</sup> :	332 ppm	Na <sup>+</sup> :	0 ppm
	NH <sub>4</sub> <sup>+</sup> :	27 ppm	K <sup>+</sup> :	0 ppm
* Particle Size:	≤ 45	microns		

ELECTRICAL AND THERMAL PROPERTIES:				
Thermal Conductivity:	1.8	W/mK		
* Volume Resistivity @ 23°C (150°C/1 Hour):	≤ 0.0005	Ohm-cm		
Volume Resistivity @ 23°C (25°C 40-60%RH/3 Day Cure):	≤ 0.009	Ohm-cm		

**Epoxyes and Adhesives for Demanding Applications™**

**This information is based on data and tests believed to be accurate. Epoxy Technology, Inc. makes no warranties (expressed or implied) as to its accuracy and assumes no liability in connection with any use of this product.**

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