

Number of Components:	Two	Minimum Bond Line Cure Schedule*:	
Mix Ratio By Weight:	10:1	150°C	15 Minutes
Specific Gravity:		120°C	30 Minutes
Part A	1.23	100°C	90 Minutes
Part B	1.02	80°C	3 Hours
Pot Life:	< 2 Hours		
Shelf Life:	Six months at room temperature		

Note: Container(s) should be kept closed when not in use. *Please see Applications Note available on our website.
- TOTAL MASS SHOULD NOT EXCEED 25 GRAMS -

Product Description:

EPO-TEK[®] 353ND-4 is a two component, high Tg epoxy designed for fiber optic applications, medical, and hybrid packaging.

EPO-TEK[®] 353ND-4 Advantages & Application Notes:

- USP Class VI Bio-Compatible epoxy, suggested for medical implants or devices.
- This epoxy may be considered a higher Tg version of EPO-TEK[®] 353ND. Higher Tg may allow for better autoclave resistance.
- Lower modulus version of EPO-TEK[®] 353ND.
- Amber color change upon cure for quick and easy visual identification.
- Suggested for fiber optic application:
 - Fiber optic termination into ferrules such as glass, ceramic, LCP, kovar, silicon, quartz, stainless steel.
 - Fiber seal into feed through boot of package.
 - Mounting optics inside hermetic package.

Typical Properties: (To be used as a guide only, not as a specification. Data below is not guaranteed. Different batches, conditions and applications yield differing results; Cure condition: 150°C/1 hour; * denotes test on lot acceptance basis)

Physical Properties:	
*Color: Part A: Clear Yellow Part B: Amber	Die Shear Strength @ 23°C: ≥ 15 Kg / 5,100 psi
*Consistency: Viscous liquid	Degradation Temp. (TGA): 395°C
*Viscosity (5 @ RPM/23°C): 36,000 – 66,000cPs	Weight Loss:
Thixotropic Index: N/A	@ 200°C: 0.52%
*Glass Transition Temp.(Tg): ≥ 125°C (Dynamic Cure	@ 250°C:
20—200°C /ISO 25 Min; Ramp -10—200°C @ 20°C/Min)	@ 300°C: 1.29%
Coefficient of Thermal Expansion (CTE):	Operating Temp:
Below Tg: 48 x 10 ⁻⁶ in/in/°C	Continuous: - 55°C to 200°C
Above Tg: 186 x 10 ⁻⁶ in/in/°C	Intermittent: - 55°C to 300°C
Shore D Hardness: 87	Storage Modulus @ 23°C: 191,740 psi
Lap Shear Strength @ 23°C: 1,472 psi	Particle Size: N/A
Optical Properties @ 23°C:	
Refractive Index @ 23°C (uncured): 1.5901 @ 589 nm	Spectral Transmission @ 23°C: > 97% @ 900 nm
	> 96% @ 800 nm
	> 88% @ 700 nm
Electrical & Thermal Properties:	
Thermal Conductivity: N/A	Volume Resistivity @ 23°C: ≥ 1.7 x 10 ¹³ Ohm-cm
Dielectric Constant (1KHz): 3.85	Dissipation Factor (1KHz): 0.0103

EPOXY TECHNOLOGY, INC.
14 Fortune Drive, Billerica, MA 01821-3972 Phone: 978.667.3805 Fax: 978.663.9782
www.EPOTEK.com

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