



Product Information Sheet

EPO-TEK® 353ND-T1

Date: July 2019
Rev: VI
No. of Components: Two
Mix Ratio by Weight: 10 : 1
Specific Gravity: Part A: 1.18 Part B: 1.02
Pot Life: 3 Hours
Shelf Life- Bulk: Six months at room temperature
Shelf Life- Syringe: Six months at -40°C

Recommended Cure: 150°C / 1 Hour

Minimum Alternative Cure(s):
May not achieve performance properties listed below
150°C / 1 Minute
120°C / 5 Minutes
100°C / 10 Minutes
80°C / 30 Minutes

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.

Product Description: A two component, thixotropic and high temperature epoxy designed for fiber optic, electronics and medical applications. It is a more viscous alternative to EPO-TEK® 353ND-T.

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: Tan	Part B: Amber
* Consistency:	Smooth thixotropic paste	
* Viscosity (23°C) @ 20 rpm:	12,000-20,000	cPs
Thixotropic Index:	2.6	
* Glass Transition Temp:	≥ 90 °C (Dynamic Cure: 20-200°C/ISO 25 Min; Ramp -10-200°C @20°C/Min)	
Coefficient of Thermal Expansion (CTE):		
Below Tg:	43	x 10 ⁻⁶ in/in°C
Above Tg:	231	x 10 ⁻⁶ in/in°C
Shore D Hardness:	80	
Lap Shear @ 23°C:	1,953	psi
Die Shear @ 23°C:	≥ 15	Kg 5,334 psi
Degradation Temp:	409 °C	
Weight Loss:		
@ 200°C:	0.53	%
@ 250°C:	1.22	%
@ 300°C:	2.37	%
Suggested Operating Temperature:	< 325 °C (Intermittent)	
Storage Modulus:	559,120	psi
* Particle Size:	≤ 20	microns

ELECTRICAL AND THERMAL PROPERTIES:

Thermal Conductivity:	N/A	
Volume Resistivity @ 23°C:	≥ 4 x 10 ¹²	Ohm-cm
Dielectric Constant (1KHz):	3.21	
Dissipation Factor (1KHz):	0.003	

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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