

Date: Apr 2015 **Rev:** VI
No. of Components: Two
Mix Ratio by Weight: 10 : 1
Specific Gravity: Part A: 1.12 Part B: 1.02
Pot Life: 3 Hours
Shelf Life- Bulk: One year at room temperature

Recommended Cure: **150°C / 1 Hour**

Minimum Alternative Cure(s): <i>may not achieve performance properties below</i> 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) may vary from those stated below when syringe packaging and/or post-processing is required.
- Syringe packaging will impact initial viscosity and effective pot life, potentially beyond stated parameters.
- **TOTAL MASS SHOULD NOT EXCEED 25 GRAMS**

Product Description: EPO-TEK[®] 353ND-T is a two component, highly thixotropic, medical grade epoxy with non-flowing properties and high temperature resistance.

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

PHYSICAL PROPERTIES:

* Color (before cure):	Part A: Tan	Part B: Amber
* Consistency:	Smooth thixotropic paste	
* Viscosity (23°C) @ 20 rpm:	9,000 - 15,000 cPs	
Thixotropic Index:	3.8	
* 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:	1953 psi	
Die Shear @ 23°C:	≥ 15 Kg	5,100 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	
Ion Content:	Cl:	471 ppm
	NH₄⁺:	400 ppm
	NA⁺:	143 ppm
	K⁺:	15 ppm
* Particle Size:	99% ≤ 20 microns	

ELECTRICAL AND THERMAL PROPERTIES:

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

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