



ISO-9001-2015 Certified

718 Park East Drive, Woonsocket, RI 02895, USA

Phone: (401) 726-4500

Email: info@epoxyset.com ■ Web: www.epoxysetinc.com

TECHNICAL BULLETIN

EPOXICAST™ M22T

ONE COMPONENT GLOB TOP ADHESIVE

EC-M22T is non-sag, thixotropic, highly filled heat-curing epoxy system designed for glob-top and damming application for microelectronics. It has very long pot life at room temperature. The cured system has a low coefficient of thermal expansion, high glass transition temperature, good dielectric properties and excellent chemical or solvent resistance.

TYPICAL HANDLING PROPERTIES:

Epoxicast	EC-M22T
Viscosity at 25°C, cp	200,000-300,000
Pot life (500 gram) at 25°C, hrs	2 days
Gel time (25 gram) at 125°C, min	10-12

Shelf Life @ -40°C or below 12 months

Recommended Cure 1 hr/100°C + 2 hr/165°C

Alternate Cure 4 hr/150°C

TYPICAL CURED PROPERTIES:

(Tested @ 25°C unless otherwise indicated)

Color	Black
Specific Gravity	1.82
Hardness, Shore D	92
Linear Shrinkage (%)	0.1
Water Absorption (24 hr at RT), %	0.02
Glass Transition Temperature, (°C)	146
Coefficient of Thermal Expansion, 10 ⁻⁶ /°C	
From -55°C to 25°C	25
From 25°C to 120°C	35
Flexural Strength, psi	12,000
Flexural Modulus, psi	1.7x10 ⁶
Dielectric Constant (1 kHz)	3.6
Dissipation Factor (1 kHz)	0.003
Volume Resistivity, ohm-cm	2.0x10 ¹⁶

INSTRUCTIONS FOR USE:

1. Frozen packages must be completely thawed before use.
2. Do not remove the cover of the syringe and let it thaw at room temperature for 30 to 60 minutes depend on quantity.
3. Wipe any condensed moisture from the container and open the cover.
4. Proceed with the potting or encapsulating application and cure as recommended.
5. Some difference in properties may occur with the alternate or other cure schedule.

AVAILABILITY:

Premixed and frozen - Packaged in 10cc and 30cc disposable syringes and ship in dry ice at -80°C.

FOR INDUSTRIAL USE ONLY:

Practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

WARNING!

Adequate ventilation of workplace and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. In case of skin contact, wash thoroughly with soap and water. For eyes, flush immediately with plenty of water for at least 10 minutes and seek medical attention. Refer to Material Safety Data Sheet (**MSDS**) for additional health and safety information.

STORAGE:

Store syringes at -40°C freezer or below for assure full shelf life.

DISCLAIMER:

All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.