



ISO-9001-2015 Certified

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TECHNICAL BULLETIN

EPOXIOHM™ EO-21

ELECTRICALLY CONDUCTIVE EPOXY ADHESIVE

EO-21 is two parts, silver filled high electrical conductivity epoxy adhesive. It is designed to cure at room temperature or rapidly at elevated temperature and exhibits very excellent adhesion and bond strength to a wide variety of substrates.

TYPICAL HANDLING PROPERTIES:

EPOXIOHM	EO-21
Hardener	EH-9
Mix ratio by wt. (Resin/Hardener)	100/4
Mix Viscosity @ 25°C, cps	30,000-40,000
(Cone & Plate, spindle-51, 5 rpm)	
Work Life (25 grams), hour	1
Shelf life:	
Two Parts Kit @ 25°C	1 year
Frozen @ -40°C	1 year
Recommended Cure	1 hr @ 100°C
Alternate Cure	24-48 hrs @ 25°C

TYPICAL CURED PROPERTIES:

(Tested at 25°C unless otherwise indicated)

Color	Silver
Specific Gravity	3.0
Hardness, Shore D	84
Lap Shear Strength to Aluminum, psi	1700
Thermal Conductivity, W/mK	2.2
Volume Resistivity, ohm-cm	0.0004
After 100 hrs @ 150°C	0.0005
Glass Transition Temperature, °C	68
Service Temperature, °C	-55 to 150
Coefficient of Thermal Expansion, ppm/°C	
Below Tg	42
Above Tg	180

INSTRUCTIONS FOR USE:

1. Mix each component thoroughly before use.
2. Weigh each 100 grams of EO-21 to 4 grams of Hardener EH-9.
3. Mix until uniform. Scrape the sides and bottom of container repeatedly during mixing.
4. Apply to clean bonding surfaces and cure as recommended to achieve the desired properties. Typical cured properties were determined using recommended cure schedule. Some difference in properties may occur with the alternate or other cure schedules.

Thaw premixed frozen adhesive at room temperature for 5-10 minutes. Dispense adhesive and cure at recommended schedules.

AVAILABILITY:

2 parts Kit - Packaged in 4 OZ, 8 OZ and 1 lb. container.
Premixed and frozen - Packaged in 3cc, 5cc and 10cc disposable syringes.

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.