



ISO-9001-2015 Certified

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# TECHNICAL BULLETIN

## EPOXIBOND™ EB-350-4T-FL

### ONE COMPONENT, HIGH STRENGTH FLEXIBLE ADHESIVE

**EB-350-4T-FL** is one component, flexible, thixotropic, thermally conductive epoxy adhesive recommended for staking transistors, diodes, resistors, integrated circuits and other heat sensitive components to printed circuit boards. This adhesive develops strong, durable, high impact bonds at room temperature which improve heat transfer while maintaining electrical insulation.

**EB-350-4T-FL** bonds readily to itself and to metals, silica, alumina, sapphire and other ceramics, glass, plastics and many other materials, because its coefficient of thermal expansion provides a good match for those materials over a wide temperature range.

#### TYPICAL HANDLING PROPERTIES:

Consistency	Non-Sag Paste
Pot life at 80°C, minutes	20
Recommended Cure	1 hr/100°C+1 hr/150°C
Alternate Cure	2 hr/125°C
	Or 30 min/150°C
	Or 20 min/175°C

#### TYPICAL CURED PROPERTIES AFTER RECOMMENDED CURE:

(Tested @ 25°C unless otherwise indicated)

Color	Black
Specific Gravity	1.56
Hardness, Shore D	62
Water Absorption (24 hrs at 25°C), %	0.09
Lap Shear Strength to Aluminum, psi	
At 25°C	2300
At 100°C	1400
Thermal Conductivity, W/m°K	0.8
Flexural Strength, psi	11,200
Flexural Modulus, psi	5x10 <sup>5</sup>
Service Temperature range, °C	-55 to 230
Glass Transition Temperature, °C	110
Coefficient of Linear Thermal Expansion, 10 <sup>-6</sup> /°C	
Below Tg	58
Above Tg	185
Dielectric Constant at 1 kHz	4.5
Dissipation Factor at 1 kHz	0.01
Volume Resistivity, ohm-cm	1x10 <sup>15</sup>

#### INSTRUCTIONS FOR USE:

1. Use dispensing equipment for best results.
2. For small applications, apply the product using a syringe or clean spatula.
3. Avoid air entrapment to obtain optimum cured properties.
4. Proceed with the bonding application and cure as recommended.
5. Typical cured properties were determined using recommended cure schedule. Some difference in properties may occur with the alternate or other cure schedules.

#### AVAILABILITY:

Packaged in Pint, Quart and Gallon size  
30cc syringe & 8 OZ Semco Cartridge

#### SHELF LIFE (STORAGE TEMPERATURE):

Average 25°C	3 months
below 10°C	6 months
below -40°C	12 months

#### 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.

**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.