

HIGH TEMPERATURE & CONDUCTIVE EPOXIES

PREPARATION

1. Clean (and roughen) surfaces of all grease, oil, dirt, old coatings, rust, etc.

For best results use **Resbond 105RS Solvent** or **Resbond Surface Prep 105RP**

2. Re-stir all Resins and Hardeners to insure a uniform, homogeneous product.

Warming resins to 100°F - 120°F (35°C -50°C) will reduce the viscosity and ease mixing.

MIX RATIO

3. **NOTE: All measurements are by weight.**

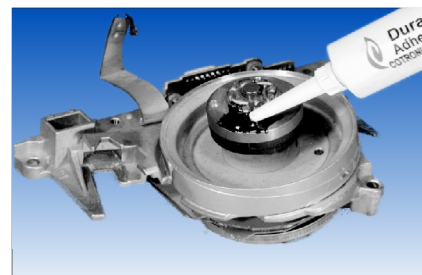
Follow instructions supplied on the product label for the exact mix ratios.

4. a. Weigh out the resin and/or hardener into a clean mixing container. Mix slowly and thoroughly.

Make sure to scrape the sides and walls of the container to insure a complete mix. Do not whip air into the mix.

NOTE: Weight = (total weight) - (weight of container)

- b. For single component systems **re-mix**, apply and heat cure as directed.



VACUUM DEGASSING

5. Special additives have been incorporated into COTRONICS' Epoxy systems to eliminate the need for vacuum degassing.

Warming resin and letting the mixture stand several minutes before use will normally remove most of the re-remaining entrapped air.

Vacuum degassing should be employed for critical applications.

NOTE: The use of warmed resin may reduce working time.

ADHESIVE APPLICATIONS

6. Apply with a trowel or with a dispensing syringe. Use Bond Lines from 0.005" - 0.010".

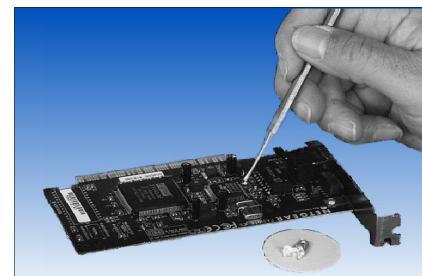
Disposable syringes are available from Cotronics.

POTTING AND CASTING APPLICATIONS

7. Pour slowly, in a thin stream, to allow the air to escape.

The material should be allowed to flow around and under the components.

NOTE: A fast pour may trap air pockets.



CURING

8. Follow the curing procedures listed on product labels for these systems.

Optimum high temperature properties are only obtained when following the recommended cure cycles.

POST CURE

9. Post cure for 4 hours at 200°F - 250°F (90°C -120°C) to enhance any room temp. curing system's properties.

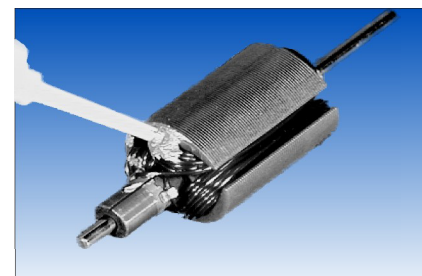
CLEAN UP

10. Uncured epoxies can be cleaned with biodegradable RESBOND 105RS.

CAUTION

Consult the appropriate MSDS for safety instructions.

Mixing batches over 50-100 grams can create excessive heat in some systems.



COTRONICS CORPORATION

www.cotronics.com 131 47th St. Brooklyn, New York 11232 (718) 788-5533 Fax (718) 788-5538