

## DESCRIPTION

The PERMACOL 2369 series are electrically conductive epoxy adhesives for applications in which an electrical conductive bond is to be established. These adhesives cure at elevated temperatures and result in high electrical conductivity and great adhesive properties.

Type	Viscosity (D=30/s 23°C)	Green strength
2369-2 A/B	30.000 mPa·s	400 Pa
2369-10 A/B	100.000 mPa·s	1800 Pa

Technical details	
Basis	Epoxy
Colour	Silver
Filling degree	60-80%
Volume resistance	$<3 \times 10^{-3} \Omega \cdot \text{cm}$
Hardness	80 shore D
Temperature resistance	-30°C up to +150°C
Curing time	3 min at 150°C
	6 min at 125°C
	10 min at 110°C
	15 min at 100°C
	60 min at 80°C

## Curing recommendations

The standard curing conditions are 3 minutes at 150°C or 6 minutes at 125°C. In practice the oven time might need to be longer to allow the PCB to heat up. Curing below 125°C results in a higher volume resistance.

Do not return used glue in the packaging to avoid contamination.

## BENEFITS

- Electric conductive
- Very low volume resistance
- Moisture resistant
- Resistant to higher temperatures
- Fast curing
- RoHS und REACH compatible

## CLEANING

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

Cured adhesives must be removed mechanically. We advise to heat up the adhesive bond over 100°C. At this temperature, the adhesive dot will become softer and the component can easily be removed using torsion.

## STORAGE

Store in its original packaging between -18°C to 4°C. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 6 months at -18°C or 3 months at 4°C.

## SAFETY

Use protective gloves to avoid direct contact with the skin. Check the Material Safety Data Sheet for specific safety information.

## PACKAGING

The PERMACOL 2369-series can be supplied in all dispenser-specific syringes, tins and pots.

## Legal Disclaimer

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