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TECHNICAL DATA SHEET

SEC 1233

TWO PART ELECTRICALLY CONDUCTIVE FLEXIBLE EPOXY ADHESIVE

DESCRIPTION:

*Resinlab*TM SEC 1233 is a silver filled, two component, room temperature curing epoxy adhesive. It is designed to cure completely at room temperature. SEC 1233 provides excellent electrical conductivity useful in many electronic applications. It is a soft 100% solids thixotropic paste provided in a 1:1 ratio. It is recommended to mix by weight but extrusion of equal length beads from syringes is commonly used as a method of measurement as small quantities are commonly used. It also can be packaged in small side-by-side dispensing cartridges for use with static mixers. This system is also available in a pre-mix and frozen format.

SEC 1233 provides exceptionally high conductivity starting immediately after mixing and improves as the curing process proceeds. It also has the additional benefit of very high thermal conductivity due to its high silver loading. It gives good environmental protection while having tenacious adhesion to various metals and other common assembly materials.

TYPICAL PROPERTIES:

All properties given are at 25C unless otherwise noted.

| | | |
|--------------------|--------|-------------|
| Color | | Silver |
| Viscosity | Part A | Light Paste |
| | Part B | Light Paste |
| | Mixed | Light Paste |
| Specific Gravity | Part A | 3.9 |
| | Part B | 3.9 |
| | Mixed | 3.9 |
| Pot Life | | 1 hour |
| Mass | | 2 - 5 grams |
| Hardness Shore - D | | 50 |
| Lap Shear Al/Al | | 700 psi |

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| | |
|------------------------|------------------------------------|
| Volume Resistivity | |
| Cured: 24 hours @ 25°C | 0.0016 ohm-cm |
| 96 hours @ 25°C | 0.0009 ohm-cm |
| 1 hour @ 60°C | 0.0003 ohm-cm |
| Water Absorption | |
| 24 hrs @ 25°C | < 0.2% |
| Thermal Conductivity | 11.1 * BTU/in/ft ² hr°F |

MIX RATIO:

| | |
|--------------------------|------------|
| Mix Ratio (Part A to B): | |
| by weight | 100 to 100 |
| by volume | 100 to 100 |

CURE SCHEDULE:

24 – 72 hours at 25°C
or 1 hour @ 60°C

SHELF LIFE:

6 Months as a two part system.
180 days at -40C as pre-mix frozen.

It is best to store part A between 60° and 95°F to prevent crystallization or separation. In the event of crystallization, warm part A to 110 to 120F and stir until uniform.

INSTRUCTIONS:

- 1) Bring to room temperature before use. Allow frozen syringes (<10cc) to warm for at least 10 minutes in air.
- 2) Weigh and mix parts A and B accurately and thoroughly, scraping sides of container often.
- 3) Allow to cure undisturbed.

* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

Notes:

Values presented above are considered to be typical properties, not to be used for specification purposes. Contact our Technical Department for further information.

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