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121-09

SCREEN-PRINTABLE, B-STAGEABLE, EPOXY LAMINATING ADHESIVE

DESCRIPTION: 121-09 is a screen-printable, B-Stageable, one part epoxy coating and laminating adhesive. This system features excellent thermal stability, thermal cycle resistance and chemical resistance. Applications include adhesives, printed circuit board fabrication, advanced material composites, sealing, and high performance coatings. For applications where a lower temperature cure is required, use CMI curing agent 119-44 and follow the instructions below.

PROPERTIES:

Glass Transition Temp. (°C)	105
Lap Shear Strength (psi)	2100
Dielectric Strength (volts/mil.)	425
Volume Resistivity (ohm-cm.)	1×10^{16}
Dielectric Constant (100Hz)	4.0

SUGGESTED HANDLING AND CURING: Material is ready to use as received. Store frozen to maintain consistent flow properties. Allow material to warm up to room temperature before opening container. Prior to using mix container well. As a coating, cure for one (1) hour at 150°C, or 30 minutes at 175°C. 121-09 can be thinned with small amounts of CMI# 203 thinner.

STORAGE: Shelf Life: 2 months at 25°C or 6 months at -10°C.

INSTRUCTIONS FOR USE WITH CMI 119-44: Add 4 parts 119-44 to 100 parts 121-09 by weight and mix until uniform. Cure 4 hours at 80°C, or 2 hours at 100°C. Pot life: 2-4 days at room temperature.

B-STAGE PROCEDURE: Apply adhesive to substrate. Next apply heat to advance the curing to the non-tacky stage (when cooled to room temperature). A temperature of 125°C for 5 -10 minutes is required (B-Stage time is mass related)). User is encouraged to experiment for optimum drying time at a given temperature. Store on release liner to prevent contamination.

STORAGE B-STAGED FILM: Shelf Life - 2 month @ 25°C; or 6 months @ -10°C

BONDING PROCEDURE: Refer to above for storage information. To use, carefully align parts to be bonded, apply uniform pressure to maintain location. Cure for 30 minutes at 175°C, or 1 hour at 150°C. (Note cure times given are mass related. Timing should start after adhesive and substrates reach curing temperature.)

SAFETY AND HANDLING: Use with adequate ventilation. Keep away from sparks and open flames. Avoid prolonged contact with skin and breathing of vapors. Wash with soap and water to remove from skin.

All technical information is based on data obtained by CMI personnel and is believed to be reliable. No warranty is either expressed or implied with respect to results or possible infringements on patents.

REVISION DATE: 10/6/04 REVISION: B