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## 123-08

### PAD-PRINTABLE, B-STAGEABLE, EPOXY LAMINATING ADHESIVE

**DESCRIPTION:** 123-08 is a pad-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.

**PROPERTIES:**

Glass Transition Temp. (°C)	105
Lap Shear Strength (psi.)	2100
Dielectric Strength (volts/mil.)	425
Volume Resistivity (ohm-cm.)	$1 \times 10^{16}$
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. 123-08 can be thinned with small amounts of CMI# 113-39 thinner (fast drying), or CMI#114-20 thinner (slow drying).

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

**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.