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124-10A/B

ELECTRICALLY CONDUCTIVE EPOXY ADHESIVE

DESCRIPTION: 124-10A/B is a two part, carbon filled, electrically conductive epoxy adhesive. 124-10A/B has good thermal conductivity and adhesion to a variety of substrates and can be used for making electrical and mechanical attachments on electrical components and devices. Unlike typical room temperature curing systems, this product always results in excellent conductivity and is less sensitive to handling and ambient conditions.

	Part A	Part B
Appearance:	Black	Black
Consistency:	Thixotropic paste	Thixotropic paste
Mix Ratio (by weight or volume):	100	25
Density (g/cc):	1.40	1.37
Pot Life (mixed):	-----	60 minutes

MIXING INSTRUCTIONS: Premix Part A and Part B in original containers prior to using if any separation has occurred. Carefully weigh Part A into clean container at recommended ratio. Carefully weigh and add Part B to Part A in proper ratio and mix until uniform (several minutes). Be sure to scrape the bottom and sides of the mixing vessel. Surfaces to be bonded should be clean and free of oil, grease, dust or other contaminants. Apply well mixed material to all surfaces and join using contact pressure.

CURING INSTRUCTIONS: Best results are obtained when product is cured at one of the following schedules:
24 hours @ 25°C, or
60 mins @ 66°C, or
30 mins @ 95°C, or
5 mins @ 120°C

If product will be used at elevated temperatures, follow one of the cure schedules above followed by a post cure of 2 hours minimum at the highest expected use temperature.

TYPICAL CURED PROPERTIES:

Volume Resistivity, max. (cured 30 mins @ 66°C)	50 Ω-cm
Tensile Lap Shear (psi)	>1500
Water Absorption (%)	< 0.06
Tensile Strength (psi)	11,200
Solvent Resistance	Excellent
Thermal Conductivity (BTU-in/ft ² hr°F)	8.8

STORAGE: Shelf life Parts A and B: 6 months in unopened, unmixed containers at 25°C.

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: 12/29/05 REVISION: A