



Creative Materials, Inc.
12 Willow Road
Ayer, MA 01432

T 978.391.4700
F 978.391.4705

127-04

SCREEN-PRINTABLE, B-STAGEABLE, EPOXY LAMINATING ADHESIVE

DESCRIPTION: 127-04 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.

PROPERTIES:

Viscosity (cps):	8,000
Glass Transition Temp. (°C)	105
Lap Shear Strength (psi.)	1800
Dielectric Strength (volts/mil)	425
Volume Resistivity (ohm-cm)	1×10^{16}
Dielectric Constant (100Hz)	4.0
Useful Temperature Range (°C)	-55 to +230
Thermal Stability (°C)	Good to 325
Coefficient of Thermal Expansion (in/in/°C) Below Tg:	29.5×10^{-6}
Above Tg:	13.5×10^{-5}

SUGGESTED HANDLING AND CURING: 127-04 is a one component system and 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. 127-04 can be thinned with small amounts of CMI# 102-03 thinner if needed.

STORAGE OF CONTAINERS: Shelf Life is 3 months 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). The user is encouraged to experiment for optimum drying times at a given temperatures. Store on release liner to prevent contamination.

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

BONDING PROCEDURE: 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.

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