



GPC-251/CA-414

ELECTRICALLY CONDUCTIVE EPOXY ADHESIVE

DESCRIPTION: GPC-251/CA-414 is a two-part, room temperature curing, silver filled epoxy adhesive. This system is designed 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. CA-414 allows for maximum tensile strength and offers longer pot life than the standard CA-401.

Appearance:	Silver
Consistency:	Paste
Mix Ratio (by weight):	100 / 5.9 (17 / 1)
Pot Life	1.5 hours

TYPICAL CURED PROPERTIES:

Volume Resistivity, max. (25°C)	0.005 Ω-cm
Volume Resistivity, max. (120°C)	0.0002 Ω-cm
Lap Shear Strength (psi)	>2,000*
Water Absorption (%)	<0.06
Tensile Shear Strength (psi)	11,200
Solvent Resistance	Excellent
Solderable	No
Specific Gravity	2.7
Thermal Conductivity (W/m-K)	6.74

MIXING INSTRUCTIONS: Premix Part A in original container prior to adding curing agent. Add Part B to Part A and mix until uniform.

CURING INSTRUCTIONS: Best results are obtained when product is cured at one of the following schedules:
24 hours @ 25°C, or
60 mins @ 65°C, or
30 mins @ 95°C, or
5 mins @ 120°C

End user is advised to experimentally determine temperature and time best suited for individual applications.

STORAGE: Shelf life Parts A and B: 12 months at 25°C in unopened, unmixed containers.

*Lap shear results obtained with 95°C cure schedule. Other cure schedules may have different results.

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: 01/29/19 REVISION: C