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## 121-18

### SCREEN-PRINTABLE, B-STAGEABLE, SNAP CURE, ELECTRICALLY CONDUCTIVE, EPOXY ADHESIVE

**DESCRIPTION:** 121-18 is a screen-printable, fast curing, B-Stageable, electrically conductive, one part epoxy adhesive, suitable for application by dipping and syringe dispensing. This product is designed for bonding capacitors to lead frames; other applications include, but are not limited to the assembling electrical and electronic components. This system features excellent thermal stability and high temperature properties. 121-18 is a screen-printable version of the pad-printable 120-23.

**PROPERTIES:**

Viscosity (cps)	25,000 - 30,000
Filler	Silver
Percent Silver, cured	> 74
Glass Trans. Temp. (°C)	155
Volume Resistivity, max. (ohm-cm)	0.0001
Solderable	No
Hydrolytic Stability	Excellent
Useful Temperature Range (°C)	-55 to +230
Thermal Stability (°C)	Good to 325
T-Shear Strength (psi)	1500

**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. As an adhesive, apply the 121-18 to one or both parts, then mate the parts and cure for 1-2 minutes at 200°C, or 2-3 minutes at 185°C. 121-18 can be thinned with small amounts of CMI# 102-03 (#203) Thinner.

**STORAGE:** Shelf Life -2 months at 25°C or 6 months at -10°C. 121-18 packaged in syringes should be stored at -10°.

**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 1-2 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 - 1 month @ 25°C; or 3 months @ -10°C

**BONDING PROCEDURE:** To use, carefully align parts to be bonded, apply uniform pressure to maintain location. Cure for 1- 2 minutes at 200°C, or 2-3 minutes at 185°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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