

123-22**SYRINGE DISPENSABLE, B-STAGEABLE, ELECTRICALLY CONDUCTIVE, EPOXY ADHESIVE**

DESCRIPTION: 123-22 is a B-Stageable, electrically conductive, one part epoxy adhesive, suitable for application by syringe dispensing, dipping, and screen-printing. 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. 123-22 is a faster curing version of 118-34.

PROPERTIES:

Viscosity (cps)	20,000-25,000
Filler	Silver
Percent Silver, cured	> 74
Glass Trans. Temp. (°C)	100
Volume Resistivity, max. (Ω -cm)	0.0005
Solderable	No
Hydrolytic Stability	Excellent
Useful Temperature Range (°C)	-55 to +230
Thermal Stability (°C)	Good to 325
T-Shear Strength (psi)	2100

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 123-22 to one or both parts, then mate the parts. Product will gel in 30 seconds at 200 °C. For full cure properties, allow one (1) hour at 150°C, or 30 minutes at 175°C, or 15 minutes at 200°C while maintaining pressure. 123-22 can be thinned, if needed, with small amounts of CMI# 113-12 (fast drying), or #203 (slow drying) thinners.

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 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 15 minutes at 200°C, or 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.

REVISION DATE: 7/7/03 REVISION: A