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# 127-21C

## HIGH RELIABILITY ELECTRICALLY CONDUCTIVE EPOXY ADHESIVE

**DESCRIPTION**: 127-21C is a one-component low stress silver–filled epoxy adhesive optimized for syringe dispensing. 127-21C is useful for applications requiring long life and high reliability such as aerospace, medical, and automotive applications as well as in applications including making electrical and mechanical attachments on electrical components and devices. 127-21C is less hygroscopic than typical adhesives and is highly stable in high humidity heat. 127-21C can be used on a variety of substrates including but not limited to transparent conductive oxide films, thin ceramics, and sputtered metals such as gold.

**TYPICAL PROPERTIES**:

| Property | Value | Units |
|---|---|---|
| Viscosity, HB CP-51, 10/s @ 25°C | ~60,000 | cps |
| Volume Resistivity | < 0.00015 | Ω-cm |
| Thermal Conductivity | > 2.5 | W/m-K |
| Glass Transition Temperature (Tg) | > 70 | °C |
| Tensile Shear Strength, min. | 1,200 | psi |
| Useful Temperature Range | -55 to +200 | ºC |
| Thermal Stability | Good to +300 | ºC |
| Solvent Resistance | Excellent | - |
| Hydrolytic Stability | Excellent | - |
| Specific Gravity | 2.88 | g/cc |

**SUGGESTED HANDLING AND CURING INSTRUCTIONS**: Material is ready to use as received. Remove product from freezer and allow material to warm to room temperature before opening container. Best results are obtained when product is cured at one of the following schedules:

| Temp. (°C) | Time (min.) |
|---|---|
| 125 | 120 |
| 150 | 60 |
| 175 | 30 |
| 200 | 15 |

**STORAGE:** Shelf life: Up to 4 days at 25°C; or 2 months at -10°C; or 6 months at -40°C.

**SAFETY & 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.



**REVISION DATE: 12/18/18 REVISION: B**