



ESD EPOXY

Technical Data Sheet

Product description

ESD Epoxy is a two-component, electrically conductive adhesive designed to provide static dissipation and strong mechanical bonding. It is formulated for use in electronics assembly where electrostatic discharge protection is critical. The cured system offers controlled conductivity, chemical resistance, and excellent adhesion to a variety of substrates.

Advantages

- Electrostatic dissipative (ESD-safe)
- Controlled surface resistivity
- Adhesion to metals, plastics, and composites
- Elevated temperature cure
- Low shrinkage upon curing
- Good thermal and chemical resistance
- 100% solids

Uses

- PCB assembly and repair
- Grounding and shielding applications
- Semiconductor packaging
- EMI/RFI shielding
- Bonding of ESD-sensitive components
- Static dissipative coatings and encapsulation

Part A	
Temperature	77° F
Viscosity	2000 cpi
Density	9.4 wt/g

Part B	
Temperature	77° F
Viscosity	350 cpi
Density	7.6 wt/g

Technical Properties		
Viscosity	ASTM D7867	800 cpi
Density	ASTM D145	8.9 wt/g
Gel Time	ASTM D3532	100 min
Quadracycle	ASTM D1640	10 hour
Color		Black
Gloss	ASTM D523	95-100
Shore D	ASTM D2440	77-80
Adhesion	ASTM C1583	2000 psi
Surface Resistance	ASTM D257-	3*10 ⁸ Ω - Test Voltage 100V
Surface Resistance Direct to Concrete	ANSI/ESD S7.1	3*10 ⁷ Ω - Test Voltage 100V

Cure Time	
Working Time	70-90 min
Tack Free	18-24 hours
Recoat Time	18-24 hours
Full Cure	7 days
Foot Traffic	24 hours
Light Traffic	48 hours

Surface Preparation All bonding surfaces must be thoroughly cleaned prior to application to ensure optimal adhesion. Remove any dust, grease, moisture, or other contaminants using an appropriate solvent or cleaning method. Surfaces should be dry and free of residues before applying the epoxy.

Mixing: Part A and Part B should be mixed in the recommended ratio until a uniform color and consistency are achieved. Thorough mixing is essential to ensure proper curing and performance. Avoid introducing excessive air during mixing, as this may affect the final properties of the cured material.

Application: Once mixed, apply the epoxy evenly onto the prepared bonding surfaces. Assemble the components promptly and maintain appropriate, uniform pressure to ensure proper contact and adhesive wet-out. Allow the material to cure according to the recommended curing schedule to achieve optimal mechanical and electrical properties.

Clean-up/Storage: The product should be stored in a cool, dry environment at temperatures between 41°F and 77°F. Containers must be kept tightly closed when not in use to prevent contamination and moisture ingress. Under these conditions, the material has a shelf life of approximately 6 to 12 months when stored in its original, unopened packaging.

Handling Precautions Appropriate care should be taken when handling this product to avoid contact with skin and eyes. It is recommended to use suitable personal protective equipment, including gloves and safety glasses, during handling and application. The material should be used in a well-ventilated area to minimize exposure to vapors. For detailed safety information, including hazard identification and first-aid measures, please refer to the Safety Data Sheet (SDS).

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