

## EUROBOND Elecolit 336

### Product Description

Elecolit adhesives are solvent free single or two-component adhesives. They are mostly based on epoxy resin and can be cured at room temperature or by exposure of heat. Elecolit ® adhesives are electrically and / or thermally conductive adhesives which are designed for potting, bonding or contacting of conductors.

Elecolit 336 can be processed with a dispenser, a stamp or screen printing. Curing is carried out at room temperature. Very short curing times are possible at elevated temperatures. Elecolit 336 is a silver-filled, solvent-free two component epoxy resin adhesive. Elecolit ® 336 is characterized by good conductivity values in "cold hardening" and good gap filling capacity.

### Curing Properties

This product is a two-component adhesive. The adhesive can be cured at room temperature or thermally under exposure to heat after mixing the two components in the ratio indicated. Possible curing temperatures are listed in the table below.

Thermal curing	
Time at 25°C	16 h
Time at 50°C	2 h
Time at 100°C	30 min
Time at 120°C	15 min
Time at 150°C	5 min

The adhesive can be applied after mixing the components within the pot life. To determine the pot life, the time it takes to double the increase in viscosity after mixing of the two components is used.

Curing	
Pot life	2 h
Mixing ratio	1:1

The curing times given are guidelines. They refer to the curing of 2 g of adhesive. The heating up of the joining members are not taken into account.

The final strength of the adhesive is reached at the earliest after 24 h.

### Technical Data

Resin	epoxy
Appearance	grey
Filler	silver
Filler – weight [%]	81
Particle size D95 [µm]	26

### Uncured material

Viscosity mix [mPas]	paste-like
Dichte [g/cm <sup>3</sup> ]	2,8
PE-Norm 004	

### Cured material

Hardness shore D	75
PE-Norm 006	
Temperature resistance [°C]	-40 - 150
Water absorption [mass %]	<1
PE-Norm 016	

### Contact Details

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Glass transition temperature DSC [°C] PE-Norm 009	18 – 38
Coefficient of thermal expansion [ppm/K] below Tg PE-Norm 017	16
Coefficient of thermal expansion [ppm/K] above Tg PE-Norm 017	223

Thermal conductivity [W/m*K] PE-Norm 062	3
Volume resistivity [Ohm*cm] PE-Norm 040	0,001

Lap shear strength (steel/steel) [MPa] Curing 15 min at 120°C PE-Norm 013	2
Lap shear strength (steel/steel) [MPa] Curing 24h at room temperature PE-Norm 013	8

**Transport/Storage/Shelf Life**

Trading unit	Transport	Storage	Shelf-life*
Other packages	at room temperature max. 25°C	0°C - 10°C	at delivery min. 6 months

\*Store in original, unopened containers!

**Instructions for Use**

**Surface preparation**

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IPA. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

**Application**

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our technical department.

Adhesive and substrate should not be cold and must be warmed up to room temperature prior to processing.

For safety information refer to our safety data sheet.

**DISCLAIMER**

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any other process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability of such information for their particular use.

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