



Manufacturer:
Epoxy Technology

Product Name:
EPO-TEK® 353NDT Thixotropic High Temperature Epoxy, Heat Cure (4g)

Manufacturer Part Number:
ET353NDT-4G

▶ [Click here for more details on the EPO-TEK® 353NDT Thixotropic High Temperature Epoxy, Heat Cure \(4g\)](#)



EPO-TEK® 353ND-T
Technical Data Sheet
For Reference Only
High Temperature Thixotropic Epoxy

Date: June 2022
Rev: XI
No. of Components: Two
Mix Ratio by Weight: 10 : 1
Specific Gravity: Part A: 1.12 Part B: 1.02
Pot Life: 3 Hours
Shelf Life- Bulk: One year at room temperature
Shelf Life- Syringe: Six months at -40°C

Recommended Cure: 150°C / 1 Hour

Minimum Alternative Cure(s):
May not achieve performance properties listed below
 150°C / 1 Minute
 120°C / 5 Minutes
 100°C / 10 Minutes

- NOTES:**
- Container(s) should be kept closed when not in use.
 - Filled systems should be stirred thoroughly before mixing and prior to use.
 - Performance properties (rheology, conductivity, others) of the product may vary from those stated on the data sheet when bi-pak/syringe packaging or post-processing of any kind is performed. Epoxy's warranties shall not apply to any products that have been reprocessed or repackaged from Epoxy's delivered status/container into any other containers of any kind, including but not limited to syringes, bi-paks, cartridges, pouches, tubes, capsules, films or other packages.
 - Syringe packaging will impact initial viscosity and effective pot life, potentially beyond stated parameters.
 - **TOTAL MASS SHOULD NOT EXCEED 25 GRAMS**

Product Description: EPO-TEK® 353ND-T is a two component, highly thixotropic epoxy with non-flowing properties and high temperature resistance.

Typical Properties: Cure condition: 150°C / 1 Hour Different batches, conditions & applications yield differing results.
 Data below is not guaranteed. To be used as a guide only, not as a specification. * denotes test on lot acceptance basis

PHYSICAL PROPERTIES:			
* Color (before cure):	Part A: Tan	Part B: Amber	
* Consistency:	Smooth thixotropic paste		
* Viscosity (23°C) @ 20 rpm:	9,000 - 15,000 cPs		
Thixotropic Index:	3.8		
* Glass Transition Temp:	≥ 90 °C (Dynamic Cure: 20-200°C/ISO 25 Min; Ramp -10-200°C @20°C/Min)		
Coefficient of Thermal Expansion (CTE):			
Below Tg:	43	x 10 ⁻⁶ in/in°C	
Above Tg:	231	x 10 ⁻⁶ in/in°C	
Shore D Hardness:	80		
Lap Shear @ 23°C:	1,953	psi	
Die Shear @ 23°C:	≥ 15	Kg	5,334 psi
Degradation Temp:	409 °C		
Weight Loss:			
@ 200°C:	0.53	%	
@ 250°C:	1.22	%	
@ 300°C:	2.37	%	
Suggested Operating Temperature:	< 325 °C (Intermittent)		
Storage Modulus:	559,120 psi		
Ion Content:	Cl ⁻ :	471 ppm	Na ⁺ : 143 ppm
	NH ₄ ⁺ :	400 ppm	K ⁺ : 15 ppm
* Particle Size:	99% ≤ 20 microns		

ELECTRICAL AND THERMAL PROPERTIES:		
Thermal Conductivity:	N/A	
Volume Resistivity @ 23°C:	≥ 4 x 10 ¹²	Ohm-cm
Dielectric Constant (1KHz):	3.21	
Dissipation Factor (1KHz):	0.003	

Epoxies and Adhesives for Demanding Applications™
 This information is based on data and tests believed to be accurate. Epoxy Technology, Inc. makes no warranties (expressed or implied) as to its accuracy and assumes no liability in connection with any use of this product.

Contact the professionals at Fiber Optic Center for a quote or to get more details.

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Product specifications and data are subject to change without notice.



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EPO-TEK® 353ND-T Advantages & Suggested Application Notes:
<ul style="list-style-type: none">• Suitable for fiber optic and circuit assembly applications.• Recommended for bonding metals, glass, ceramics and many types of plastic.• High temperature adhesive for hybrids and medical devices; it can resist within the 300°C range for long periods of time.• Circuit assembly applications; staking SMD's to PCB, bonding ferrite cores together in copper coil windings, inductor coils and power devices; suitable for COB glob top DAM material.• Alternative product versions available with distinct viscosity ranges• Can be applied by screen printing, spatula, hand held or automatic dispensing equipment.• Amber color change when properly cured for easy visual ID and inspection.

Epoxy Technology, Inc. makes no warranties (expressed or implied) as to its accuracy and assumes no liability in connection with any use of this product.

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