

Number of Components:	Two	Minimum Bond Line Cure Schedule*:	
Mix Ratio By Weight:	10:1	150°C	1 Minute
Specific Gravity:		120°C	5 Minutes
Part A	1.20	100°C	10 Minutes
Part B	1.02	80°C	30 Minutes
Pot Life:	3 – 4 Hours		
Shelf Life:	One year at room temperature		

Note: Container(s) should be kept closed when not in use. \*Please see Applications Note available on our website.  
- TOTAL MASS SHOULD NOT EXCEED 25 GRAMS -

### Product Description:

EPO-TEK<sup>®</sup> 353ND is a two component, high temperature epoxy designed for semiconductor, hybrid, fiber optic, and medical applications. It is one of the most popular EPO-TEK<sup>®</sup> brand products, and is known throughout the world for its performance and reliability.

### EPO-TEK<sup>®</sup> 353ND Advantages & Application Notes:

- Reasonable pot-life that allows for low temperature curing to be realized. It has an amber color change upon cure.
- NASA approved, low outgassing epoxy - <http://outgassing.nasa.gov/>
- Semiconductor suggested applications: wafer-wafer bonding of CSP; fabrication of MEMs devices; flip chip underfill.
- Hybrid suggested applications: providing near hermetic seals in sensor devices, resisting high temperature packaging
  - Down-Hole petrochemical fiber optic sensors, resisting >200°C field conditions
- Fiber optic adhesive designed to meet Telecordia 1221 - suggested applications:
  - Sealing fiber into ferrules, transmitting light in the optical pathway from 800- 1550 nm range
  - Fiber component packaging; adhesive for active alignment of optics, environmental seal of opto-package, V-groove arrays
- Medical suggested applications:
  - Potting Fiber Optic bundles into SST ferrules for light guides and endoscopes, resisting sterilization cycles of autoclave, ETO, gamma, H<sub>2</sub>O<sub>2</sub> plasma
  - Certified to USP Class VI Biocompatibility Standards for medical implants; adhesive for catheter devices including stents and guide wires
- Electronics Assembly suggested applications:
  - Used as dielectric layer in the fabrication of capacitors; laminating PZT ferroelectrics found in ultrasound or ink-jetting devices
  - Impregnating and insulating copper coil windings in motors and inductor coils. Bonding ferrite cores and magnets.
  - Structural grade epoxy found in hard-disk drive devices; bonding of SST metals, kapton, and magnets

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

Physical Properties:	
*Color: Part A: Clear/Colorless Part B: Amber	Weight Loss:
*Consistency: Pourable liquid	@ 200°C:
*Viscosity (@ 50 RPM/23°C): 3,000 – 5,000 cPs	@ 250°C:
Thixotropic Index: N/A	@ 300°C: 0.07%
*Glass Transition Temp.(Tg): ≥ 90°C (Dynamic Cure 20—200°C /ISO 25 Min; Ramp -10—200°C @ 20°C/Min)	Operating Temp:
Coefficient of Thermal Expansion (CTE):	Continuous: - 55°C to 250°C
Below Tg: 54 x 10 <sup>-6</sup> in/in/°C	Intermittent: - 55°C to 350°C
Above Tg: 206 x 10 <sup>-6</sup> in/in/°C	Storage Modulus @ 23°C: 516,912 psi
Shore D Hardness: 85	Ions: Cl <sup>-</sup> 329 ppm
Lap Shear Strength @ 23°C: > 2,000 psi	Na <sup>+</sup>
Die Shear Strength @ 23°C: ≥ 15 Kg / 5,100 psi	NH <sub>4</sub> <sup>+</sup> 409 ppm
Degradation Temp. (TGA): 494°C	K <sup>+</sup> 5 ppm
	Particle Size: N/A
Optical Properties @ 23°C:	
Index of Refraction: 1.5694 @ 589 nm	Spectral Transmission: > 50% @ 550 nm; > 98% @ 700-1000 nm > 95% @ 1100 - 1600 nm
Electrical & Thermal Properties:	
Thermal Conductivity: N/A	Volume Resistivity @ 23°C: ≥ 1.8 x 10 <sup>13</sup> Ohm-cm
Dielectric Constant @ 23°C (1 KHz): 3.17	Dissipation Factor @ 23°C (1 KHz): 0.005

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