

Elecolit ® 3025 is a silver-filled, solvent-free 2K epoxy resin adhesive with a potlife of 2 hours. This adhesive may be processed with dispensers, stamps or through screen printing. Curing occurs at room temperature already, increased heat yields very short curing times.

Elecolit ® 3025 provides optimum solutions for cold curing applications thanks to excellent conductivity and gap filling attributes.

Mixing ration of that prodcut is 1:1 by weight.

## Shelf life:

6 months at 5°C

## Technical Data

Color	silver
Resin	epoxy
Filler	silver

## UNCURED PROPERTIES

Viscosity		paste-like
Flash point		-
Pot-Life [min.]	PE-Norm P019	approx. 120
Thixotropy Index { }	PE-Norm P061	9.98

## Curing

16	hours at	25 °C	
2	hours at	50 °C	
30	minutes at	100 °C	
15	minutes at	120 °C	0.05 Ohm x cm
5	minutes at	150 °C	

## CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 150
Hardness [Shore D]	PE-Norm P052	70 to 80
Volume resistivity [Ohm x cm]	ASTM-D-257-93	0.05
Water Absorption [mass-%]	PE-Norm P053	< 0.5
Tg [°C] (DSC)	PE-Norm P009	45 to 75
CTE [ppm/K]	PE-Norm P017	31
Thermal conductivity [W/m·K]	ASTM 1530	2.1

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## Mechanical Data

Lap Shear Strength (Steel/Steel (RT Curing)) [MPa]	[PE-Norm P013]	approx. 11.6
Lap Shear Strength (Stahl/Stahl (20' bei 120°C)) [MPa]	[PE-Norm P013]	approx. 14.8
Lap Shear Strength (Alu/Alu (20' bei 120°C)) [MPa]	[PE-Norm P013]	approx. 10.3

## Instructions for Use

### Surface Preparation

The surfaces to be bonded should be free of dust, oil, fat or any other dirt in order to optimise reproducible results. Lightly soiled surfaces can be cleaned with cleaner IP to create a suitable working surface.

### Application

Our Elecolit 2-C products are delivered in separate packing units. Resins can crystallize at deep temperature storage- this process will be reversible by heating for 1 hour at 40°C.

The components A and B have to be homogenised well, weigh out in mixing ration and homogenised with each other for min. 2 minutes.

From now, the pot life time starts and the adhesive has to be applied rapidly.

You can dispense or use them for screen printing processes.

### Curing

For curing heat must be applied. In some cases they will cure even at room temperature. But higher temperature will reduce the curing time. For detailed curing information, please look into the technical data sheet. Higher curing temperature will lead to better electrical conductivity and less volume resistivity.

If help is required, please contact our engineering department.

Please read the corresponding **Safety Data Sheet** for this product.