

USE INSTRUCTIONS



SPI Supplies
206 Garfield Avenue,
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SPI Silver Epoxy 05062-AB

SPI Silver Epoxy Application and Mixing Instructions for #05062-AB

The "no problem" conductive epoxy for many varied applications

Follow these easy to use instructions for the best results:

- a) Carefully clean and dry all surfaces to be bonded. For the scanning electron microscopy application where the strength of the adhesive bond is not so much of an issue, this step is not as important as for other applications.
- b) Remove the clamp and thoroughly mix the SPI Two Part Silver Epoxy adhesive system components in the handy mixing dispenser package until color is uniform throughout.
- c) Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. For vacuum and high vacuum applications, the thoroughness of the mixing is perhaps even more important than applications generally. For strong reliable bonds, maintain good uniform contact pressure until the adhesive is cured. This is particularly important when using this conductive epoxy system to "glue" sputter coater targets to the sputter coater heads.

Other information and cure information

SPI #05062 AB has a 3 hour "pot life" after thorough mixing in the accurately proportioned two part system package with a very low magnitude exotherm during the curing cycle. This superior adhesive develops most of its major physical properties after 24 hours at room temperature (at 25° C); longer cures up to 72 hours at 25° C are required for fully matured bonds. For vacuum applications, one should really wait the full 72 hours (at room temperature) for the maximum vacuum characteristics. However that time frame can be shortened considerably (for maximum vacuum characteristics) via the application of temperature during the cure time, for example, 2-4 hours at 65° C. An 80% cure after 8 hours at 25° C can be achieved.

Revised: EER

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