

**TYPICAL PROPERTIES**

(To be used as a guideline only)

NUMBER OF COMPONENTS ..... Two

MIXING RATIO                      PARTS BY WEIGHT  
Part "A" ..... 10 gms.  
Part "B" (hardener) ..... 5.5 gms.  
Keep containers closed when not in use.  
Maximum recommended mixed quantity  
should not exceed ..... 25 grams

CURE SCHEDULE (minimum)  
65°C ..... 2 hours  
Room Temperature ..... 24 hours

PHYSICAL PROPERTIES  
Color (before and after cure) ..... Clear  
Consistency ..... Pourable liquid  
Specific Gravity  
Part "A" ..... 1.11  
Part "B" ..... 1.09  
Viscosity (mixed)  
@ 100 rpm/23°C ..... 450 - 850 cPs  
Glass Transition Temp. (Tg) ..... Approx. 0°C  
Coefficient of Thermal Expansion (CTE)  
Below Tg ..... N/A  
Above Tg ..... 180 x 10<sup>-6</sup> in/in/°C  
Shore D Hardness ..... 22 (Flexible)  
Degradation Temperature ..... 326°C  
Lap Shear Strength (Al to Al) ..... 570 psi  
Storage Modulus ..... 50,000 psi

OPTICAL PROPERTIES  
Index of Refraction ..... 1.507  
Spectral Transmission: (0.003" film thickness  
between two quartz plates)  
Greater than 96% transmission ... 340 to 900 nm

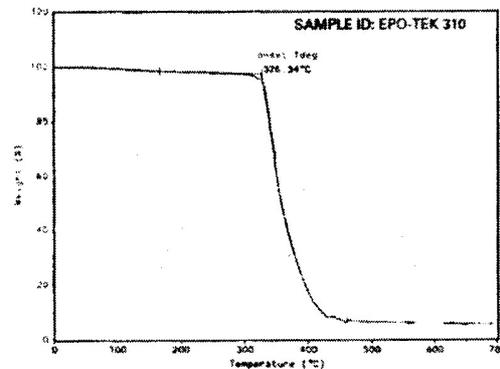
VACUUM CHARACTERISTICS  
When sealing metal to metal under a vacuum of  
10<sup>-5</sup> Torr, the leak rate is approximately 5 x 10<sup>-9</sup> cc/sec  
He at 25°C and atmospheric pressure.

POT LIFE ..... 1 1/2 to 2 hours

SHELF LIFE  
One year when stored at room temperature.

• DO NOT REFRIGERATE •  
USP CLASS VI APPROVED •

TGA



EPO-TEK 310 is a two component, 100% solids, flexible, optically clear epoxy adhesive designed for bonding glass to glass, glass to metal and metal to metal. The soft, flexible nature makes it an excellent material for potting applications. EPO-TEK 310 has a low viscosity and a long pot life. It can be cured at room temperature or with heat. In addition to its excellent adhesion and optical properties, EPO-TEK 310 has very good vacuum characteristics and will withstand temperature cycling.

EPO-TEK 310 can be applied by spatula, brush, hypodermic needle and commercial dispensing equipment.

EPO-TEK 310 is also approved for various medical applications and complies with USP Class VI biocompatibility standards.

**Polytec GmbH**

Polymer Technologien Polytec-Platz 1-7 76337 Waldbronn Germany  
Tel. ++49 (0) 7243 604-175 Fax ++49 (0) 7243 604-382  
E-mail: [pt@polytec.de](mailto:pt@polytec.de) <http://www.polytec.de>