

# **DATA** SHEET

## MEG - 165 Epoxy

#### **CHEMICAL PRODUCT**

PRODUCT NAME: MEG-165

COLOR: White

CHEMICAL FAMILY: Mixture
MOLECULAR FORMULA: Mixture
MOLECULAR WGT: Mixture
GLASS TRANSITION TEMP: 50 °C

THICKNESS: 0.001" or 0.003"  $\pm 0.0005$ " (25  $\mu$ m or 76  $\mu$ m)

CURE TEMP: 177 °C for I hour

C.T.E.: 13 X 10<sup>-6</sup> /°C

**ELECTRICAL INSULATOR** 

#### **PRODUCT FEATURES**

- Excellent adhesion to metal, glass and ceramics.
- No primer required.
- ▶ At temperatures ≤ 25 °C, epoxy has little tackiness.
- Low flow upon curing; optimal for flat sealing surfaces.

### **STORAGE**

Store in a refrigerator at 32°F to 35°F (0°C to 2°C) or in a freezer between 15°F and 32°F (-9 to 0°C). Allow the epoxy to regain room temperature just prior to use. Stored under these conditions, the shelf life of the epoxy is approximately 6-10 months.

#### **CURING SCHEDULE**

Allow epoxy to warm up to room temperature before placing on the surface to be sealed. Curing time is a function of temperature, but a cycle of 60 minutes at  $177^{\circ}$ C under 20 - 30 psi (0.14 to 0.21 MPa) can be used as a reference. An alternative curing cycle is 204 C for 15 minutes at the same pressure. However, bonding conditions can vary considerably with satisfactory results, using heat-up interval of 1 - 30 minutes (depending on size) and curing temperatures from  $177^{\circ}$ C to  $204^{\circ}$ C. Preheated convections ovens are recommended. Cure Atmosphere: air, nitrogen or vacuum.

Bonding conditions are optimized when the epoxy is fresh. The sealing surface should be dry and free of large particles, debris, oils and other foreign material.



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MATERION CORPORATION

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