



# Polytec EP 642-T-frozen

## Properties

Polytec EP 642-T-frozen is a single-component, pre-mixed frozen, high  $T_g$ , high temperature resistant epoxy with non-flowing properties.

Polytec EP 642-T-frozen has an excellent chemical and moisture resistance and can withstand operating temperature up to 350°C (intermittent). Suitable for fiber optic, medical, sensor and electronic assembly applications. Compatible with STERAD® sterilization systems.

Polytec EP 642-T-frozen has excellent adhesion to glass, ceramic, ferrous and non-ferrous metals and most plastics.

The material can be applied via dispensing, jet-dispensing, potting and manual application.



## Processing

- The cooling during transport is assured by dry ice (-78 °C) and a temperature indicator.
- Use insulated gloves when touching any component of the packaging.
- The storage temperature of frozen adhesives should not exceed -40 °C.
- The cartridges should be opened only when they have been brought to room temperature (thawing curve see page 3).
- Store cartridges in vertical position while thawing (top down).
- Do not accelerate the thawing by hand heat or warm water (risk of air inclusions)
- Please remove condensed water before opening.
- Surfaces should be clean, thus free of dirt, grease, oil, dust or process chemicals.
- Please notice respective minimum curing temperature and time.
- For Safety information please refer to the respective Material Safety Data Sheet.

## Polytec EP 642-T-frozen Unfilled Epoxy Adhesive Technical Data

# Polytec EP 642-T-frozen

Properties in uncured state	Method	Unit	Technical Data
Chemical basis	-	-	Epoxy
No. of components	-	-	1
Mixing ratio (weight)	-	-	-
Mixing ratio (volume)	-	-	-
Pot life at 23°C after thawing	TM 702	h	24 - 36
Storage Stability at -40°C	TM 701	months	12
Consistency	TM 101	-	Non-flowing paste
Density Mix	TM 201.2	g/cm <sup>3</sup>	1.24
Density A-Part	TM 201.2	g/cm <sup>3</sup>	-
Density B-Part	TM 201.2	g/cm <sup>3</sup>	-
Viscosity Mix 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	35 000
Viscosity A-Part 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	-
Viscosity B-Part 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	-

Properties in cured* state	Method	Unit	Technical Data
Color	TM 101	-	Milky white/ amber
Hardness (Shore A)	DIN EN ISO 868	-	85
Temperature resistance continuous	TM 302	°C	-55 / +250
Temperature resistance short term	TM 302	°C	-55 / +350
Degradation Temperature	TM 302	°C	+410
Glass Transition Temperature (T <sub>g</sub> )	TM 501	°C	150
Coefficient of thermal expansion (<T <sub>g</sub> )	ISO 11359-2	ppm	-
Coefficient of thermal expansion (>T <sub>g</sub> )	ISO 11359-2	ppm	-
Thermal conductivity	-	W/m·K	-
Elasticity modulus	TM 605	N/mm <sup>2</sup>	1 600
Tensile Strength	TM 605	N/mm <sup>2</sup>	51
Lap shear strength (Al/Al)	TM 604	N/mm <sup>2</sup>	14
Elongation at break	TM 605	%	4.2
Water absorption 24 h, 23°C	TM 301	%	0.3
Refractive index	-	-	-

\*The above data has been determined with samples cured at 150°C. Please notice, by varying the curing temperature these properties can be influenced to some extend.



## Polytec EP 642-T-frozen

Curing*	Method	Unit	Technical Data
Minimum curing temperature		°C	-
Curing time at 100°C		min	-
Curing time at 120°C		min	-
Curing time at 150°C		min	-
Curing time at 180°C		min	15

\*Curing temperatures refer to the temperature in the respective bond line. When choosing the respective curing conditions, the time needed to heat the substrate has to be considered. Depending on the type of heat source (convection oven, hot stamp, heating plate) the heat input may vary.

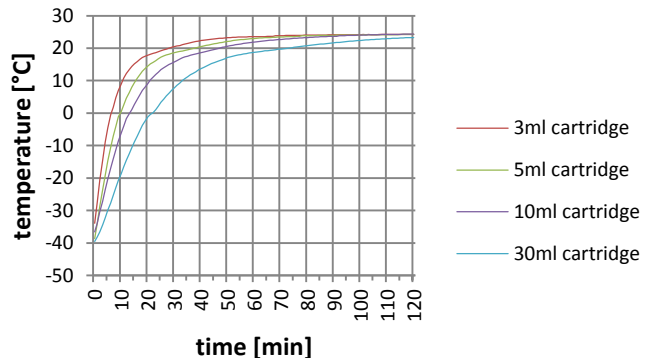
### Standard pack sizes:

3cc\* / 3 g, 5 cc\* / 5 g  
10 cc\* / 10 g, 30 cc\* / 30 g

### Customized packaging

\*:EFD-Cartridges

Thawing curve -40°C



### Please note:

The above listed information are typical data based on tests and are believed to be accurate. Polytec PT makes no warranties (expressed or implied) as to their accuracy. The above listed data do not constitute specifications. The processing (in particular the cure conditions) of the material, the process control and the variety of different applications at various customers are not under Polytec PT's control. Therefore Polytec PT will not be liable for concrete results in any specific application or in any connection with the use of this product. In particular the cure conditions do have a major effect on the properties of the cured material. Therefore it is highly recommended to keep the cure schedule – once established - under tight control. With the release of this data sheet all former data sheets will be null and void.

Subject to alteration.

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