



K-303

Two Component Epoxy Adhesives

Features

- K-303/K-303L is a two component epoxy adhesives.
- This product is used for various substrates (plastic, wood, metal, glass, carbon fiber, ceramic, etc.) bonding.
- Excellent toughness and good chemical resistance after cured
- RoHS compliant.

Specifications

		<u>K-303L</u>		<u>K-303</u>	
		Part A	Part B	Part A	Part B
Color	:	Beige white	Light amber	Beige white	Light amber
Thixotropic Index	:	>2	>1.5	>3.5	>2.5
Specific Gravity	:	1.16	0.98	1.16	0.98
Mix Ratio	:	By weight, A : B		100	45
Viscosity of Mixture	:	Paste		Non-sag	
Pot Life	:	@25°C		1.5 hrs	1.5 hrs
Surface Dry Time	:	25°C x 8 hrs		25°C x 8 hrs	
Full Cure Time	:	25°C x 5 ~ 7 days		25°C x 5 ~ 7 days	
		or 80°C x 1 hr		or 80°C x 1 hr	
Hardness	:	Shore D		80 ~ 86	79 ~ 85
Working Temperature Range	:	-20 ~ +120°C		-20 ~ +120°C	
Glass Transition temperature(Tg)	:	TMA		80°C	80°C
Coefficient of Thermal Expansion	:	<Tg, $\mu\text{m}/\text{m}^\circ\text{C}$		68	59
		>Tg, $\mu\text{m}/\text{m}^\circ\text{C}$		194	192
Degradation Temperature	:	TGA 10°C/min		338°C	342°C
Bond Strength	:	Al & Al		220 kgf	220 kgf
Dielectric Strength	:			25 KV/mm	25 KV/mm
Volume Resistivity	:			2.1×10^{16} ohm-cm	2.1×10^{16} ohm-cm
Surface Resistivity	:			9×10^{13} ohm-cm	9×10^{13} ohm-cm
Dielectric Constant	:			4.1	4.1
Shelf Life	:	@25°C, Unopened		1 year	1 year

Handling & Storage

- For high strength bonding, clean the contact surface to remove dust, grease and all other contaminants before applying the adhesive.
- Mix thoroughly by weight 100 : 45 Mix approximately until uniform color is obtained.
- Please try to evenly apply K-303/K-303L sides to bond. When bonding, applying a proper force is suggested to ensure both sides bond to each other.
- This product is amine content, reseal the lid immediately after use. Keep without any possibility of wet and sunlight when not using.
- After opened, if the product is not used up or will not be used again soon, reseal the product and storage at the recommended shelf life temperature(s).

