

Silver Conductive Epoxy Adhesive

Description

8330 is an electrically conductive, silver-filled two-part epoxy adhesive. It is smooth, non-sagging, thixotropic, and bonds well to a wide variety of substrates.

This product allows for quick, cold-soldering repairs. It can also be used as a solder replacement for bonding heat-sensitive electronic components, or for making conductive connections where soldering is not an option, such as when bonding to glass, soft metals, or plastics.

8330 is highly filled to maximize electrical conductivity. For a more economical version, use 8331. For a longer working life, use 8330S.

Features and Benefits

- Resistivity of $0.001 \Omega \cdot \text{cm}$
- Thermal conductivity of $1.8 \text{ W}/(\text{m} \cdot \text{K})$
- 1:1 mix ratio
- Working life: 10 minutes
- Cure time: 24 hours at room temperature or 20 minutes at $65 \text{ }^\circ\text{C}$ ($149 \text{ }^\circ\text{F}$)
- Hardness of 83 Shore D
- Strong resistance to humidity, salt water, mild bases, and aliphatic hydrocarbons
- Shelf life: 3 years at room temperature
- RoHS 3 compliant

Usage Parameters

Properties	Value
Working life @22 °C [72 °F] ^{a)}	10 min
Shelf life @22 °C [72 °F]	3 y
Service cure @22 °C [72 °F]	5 h
Full cure @22 °C [72 °F]	24 h
Full cure @65 °C [149 °F]	20 min

a) Working life assumes 5 g at room temperature.

Temperature Ranges

Properties	Value
Constant service temperature	-55 to 150 °C [-67 to 302 °F]
Storage temperature	16 to 27 °C [61 to 81 °F]

Cured Properties

Physical Properties	Method	Value ^{a)}
Color	Visual	Silver grey
Density @26 °C [79 °F]	ASTM D 1475	3.3 g/mL
Hardness	Shore D Durometer	83D
Tensile strength	ASTM D 638-08	13 N/mm ² [1 900 lb/in ²]
Compressive strength	ASTM D 695-10	36 N/mm ² [5 200 lb/in ²]
Lap shear strength (stainless steel)	ASTM D 1002	6.5 N/mm ² [940 lb/in ²]
Lap shear strength (aluminum)	ASTM D 1002	5.4 N/mm ² [780 lb/in ²]
Water absorption (relative mass change)	ASTM D 570	1.34%
Outgassing (total mass loss) @125 °C [257 °F] for 24 h	ASTM E 595	2.87%
Water vapor regain	ASTM E 595	0.13%
Collected volatile condensable materials	ASTM E 595	0.54%
Electrical Properties	Method	Value
Volume resistivity	Method 5011.5 in MIL-STD-883H	0.0010 Ω·cm
Volume conductivity	Method 5011.5 in MIL-STD-883H	1 000 S/cm

Note: Specifications are for epoxy samples cured at 65 °C for 20 minutes and conditioned at ambient temperature and humidity.

a) N/mm² = mPa; lb/in² = psi

Cured Properties

Thermal Properties	Method	Value
Glass transition temperature (T _g)	ASTM E 3418	53 °C [127 °F]
CTE ^{a)} prior T _g after T _g	ASTM E 831 ASTM E 831	89 ppm/°C [192 ppm/°F] 224 ppm/°C [435 ppm/°F]
Thermal conductivity @25 °C [77 °F]	ASTM E 1461 92	1.8 W/(m·K)
Thermal diffusivity @25 °C [77 °F]	ASTM E 1461 92	1.0 mm ² /s
Specific heat capacity @25 °C [77 °F]	ASTM E 1461 92	0.6 J/(g·K)

Note: Specifications are for epoxy samples cured at 65 °C for 20 minutes and conditioned at ambient temperature and humidity.

a) Coefficient of Thermal Expansion (CTE) units are in ppm/°C = in/in/°C × 10⁻⁶ = unit/unit/°C × 10⁻⁶

Uncured Properties

Physical Properties	Mixture (A:B)
Color	Silver grey
Density	3.3 g/mL
Mix ratio by volume	1:1
Mix ratio by weight	1.16:1
Solids content (w/w)	100%

Physical Properties	Part A	Part B
Color	Silver grey	Silver grey
Viscosity @25 °C [77 °F]	8 300 000 cP [8 300 Pa·s] ^{a)}	Thixotropic paste
Density	3.40 g/mL	2.92 g/mL
Odor	Mild	Amine

a) Brookfield viscometer at 1 rpm with spindle RV S96

Compatibility

Adhesion—8330 epoxy adheres to most plastics and metals used to house printed circuit assemblies; however, it is not compatible with contaminants like water, oil, or greasy flux residues, which may affect adhesion. In case of contamination, first clean the surface to be coated with MG Chemicals 824 Isopropyl Alcohol.

For substrate substances with weak adhesion strengths, surface preparation such as sanding or pre-coating with a suitable primer may improve adhesion.

Chemical resistance—Once cured, the epoxy adhesive is inert under normal conditions. It will resist water and salt exposure.

It is expected to resist short term exposures to fuels or similar non-polar organic solvents, but it is not suitable for prolonged exposures. Avoid use with strong acids, strong bases, or strong oxidizers.

Storage

Store between 16 and 27 °C [61 and 81 °F] in a dry area, away from sunlight. Some of the components are sensitive to air, always recap firmly when not in use to maximize shelf life.

Substrate Adhesion (In Decreasing Order)

Physical Properties	Adhesion
Steel	Stronger
Aluminum	↑ ↓
Fiberglass	
Wood	
Paper, Fiber	
Glass	
Rubber	↓
Polycarbonate	
Acrylic	Weaker
Polypropylene	Does not bond

Health and Safety

Please see the 8330 Safety Data Sheet (SDS) parts A and B for further details on transportation, storage, handling, safety guidelines, and regulatory compliance.

Application Instructions

For best results, follow the procedure below. For quantities less than 1 mL or for stricter stoichiometry control, mix by weight with a high-precision balance. Heat cure to achieve optimal conductivity.

Syringe:

1. Twist and remove the cap from the syringe. Do not discard cap.
2. Measure 1 part by volume of A.
3. Measure 1 part by volume of B.
4. Dispense material on a mixing surface or container, and thoroughly mix parts A and B together.
5. To stop the flow, pull back on the plunger.
6. Clean nozzle to prevent contamination and material buildup.
7. Replace the cap on the syringe.

Can or jar:

1. Stir each part individually to re-incorporate material that may have separated during storage.
2. Measure 1.16 part by weight of A.
3. Measure 1 part by weight of B.
4. Thoroughly mix parts A and B together.
5. Apply adhesive to the application area.

Cure Instructions

Room temperature cure:

- Let cure at room temperature for 24 h.

Heat cure:

- Put in oven at 65 °C [149 °F] for 20 min.

Packaging and Supporting Products

Cat. No.	Packaging	Net Weight	Packaged Weight
8330-19G	2 Syringe kit	18.9 g [0.67 oz]	40 g [1.4 oz]
8330-50ML	2 Jar kit	157 g [5.57 oz]	170 g [0.4 lb]
8330-200ML	2 Can kit	631 g [1.39 lb]	820 g [1.8 lb]

Technical Support

Please contact us regarding any questions, suggestions for improvements, or problems with this product. Application notes, instructions and FAQs are located at www.mgchemicals.com.

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