



CUMING MICROWAVE

C-BOND 245

RoHS
Compliant

TECHNICAL BULLETIN 230-2

FLEXIBLE, ROOM TEMPERATURE CURING EPOXY ADHESIVE

C-BOND 245 is a flexible general purpose epoxy adhesive which can be cured at room temperature. Adhesion to metals, plastics, glass and ceramics is excellent.

The flexibility of C-BOND 245 may be adjusted by the amount of curing agent (Part B) which is used, as shown in the schedule below:

Flexible	70 parts A to 100 parts B
Semi-rigid	100 parts A to 100 parts B
Rigid	100 parts A to 50 parts B

However, for most purposes, the semi-rigid formulation is preferred, and this is the ratio in which the two parts are standardly supplied.

C-BOND 245 is ideal in applications where shock, shear and peel resistance is required.

TYPICAL PROPERTIES

(for semi-rigid formula, as applicable)

Color: Clear

Usage Temperature: -55 to +120 °C
(-70 to +250 °F)

Hardness, Shore A: 70

Lap Shear Strength: 20 MPa (3000 psi)

Dielectric Strength: 15 kV/mm (400 V/mil)

Volume Resistivity: 3×10^{13} Ohm-cm

Dielectric Constant (10^2 to 10^9 Hz): 5.0 to 3.5

Dissipation Factor (10^2 to 10^9 Hz): 0.03 to 0.04

INSTRUCTIONS FOR USE

Clean the surfaces to be bonded prior to application of the adhesive. Alcohol or acetone work well to remove grease, dirt, and fingerprints.

Weigh out the desired amounts of Parts A and B into a suitable container. Mix thoroughly. Pot life is approximately two hours at room temperature.

Apply the adhesive using a brush, roller or squeegee. Mate the surfaces and apply pressure to squeeze out the excess. Ideally, the pieces being bonded should be held together under pressure during cure.

Cure will take place within 8 hours, but bond strength will continue to increase during the following 24 hours. A rapid cure can be made at: 65°C (150°F) for 40 minutes, or at 95°C (200°F) for 15 minutes.

It is advisable to postcure a bond at a temperature equal to or above its intended usage temperature.

Handling of this product should present no health hazard if ordinary care is exercised to avoid breathing vapors, if skin and eyes are protected, and if material is not ingested. Consult the Material Safety Data Sheet for more information.

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AVAILABILITY

C-BOND 245 is available as a two-part kit comprising Part A and Part B, in the following sizes:

- 1 lb PINT (approx. 0.46 kg)
- 2 lb QUART (approx. 0.95 kg)
- 8 lb GALLON (approx. 3.60 kg)

The weights shown are the combined weights of Parts A and B.

Consult Cuming Microwave for bulk orders, or if special ratios of the two parts are required.

Unopened containers, if stored at room temperature, should have a shelf life of at least 6 months.

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