

## C-ER2994/CT614

### Fast-Curing, Solvent-, Moisture-, and Heat-Resistant, 2-Part Potting Epoxy

APPLICATIONS	FEATURES	RECOMMENDED SUBSTRATES
<ul style="list-style-type: none"> <li>Electronic Encapsulation</li> <li>Electrical Component Sealing</li> <li>General Bonding</li> <li>Small Encapsulation and Potting</li> </ul>	<ul style="list-style-type: none"> <li>Fast Cures</li> <li>Excellent Solvent Resistance</li> <li>Excellent Moisture Resistance</li> <li>Excellent Heat Resistance</li> <li>Good Adhesion to Most Plastics</li> </ul>	<ul style="list-style-type: none"> <li>Polycarbonate</li> <li>Polycarbonate/ABS</li> <li>Polyetherimide</li> <li>PETG</li> </ul>

Crosslink® C-ER2994/CT614 is a 100% solids formulation for fast general bonding and small potting/encapsulation applications. The cured resin has excellent moisture, solvent, and heat resistance. This resin system provides high levels of toughness and adheres to most plastics with little or no surface preparation. Thin coatings of C-ER2994/CT614 can cure in 45 seconds at 65°C [150°F]. This epoxy system should not be used for curing large volumes due to excessive exotherm in mass. This product is in full compliance with the RoHS Directives 2002/95/EC and 2003/11EC.

TYPICAL UNCURED PROPERTIES (RESIN)*		
Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Epoxy	N/A
Appearance	Amber	N/A
Soluble in	Organic Solvents	N/A
Mixed Viscosity, cP (20 rpm)	25,000 (nominal)	ASTM 2556

CURED ELECTRICAL PROPERTIES (OPTIONAL)		
Property	Value	Test Method
Dielectric Constant (1MHz @ 25°C [77°F])	4.21	ASTM D150
Dielectric Strength kV/mm [V/mil]	21.2 [537]	ASTM D149
Volume Resistivity (ohm-cm)	8.8 E+13	ASTM D257

TYPICAL UNCURED PROPERTIES (CATALYST)*		
Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Epoxy	N/A
Appearance	Amber	N/A
Soluble in	Organic Solvents	N/A

OTHER CURED PROPERTIES		
Property	Value	Test Method
Boiling Water Absorption, % (2 hr)	0.8	ASTM D570
Water Absorption, % (25°C, 24 hr)	0.2	ASTM D570
Linear Shrinkage, %	0	ASTM D2566

CURED MECHANICAL PROPERTIES		
Property	Value	Test Method
Durometer Hardness	D90	ASTM D2240
Tensile at Break, MPa [psi]	54 [3,900]	ASTM D638
Elongation at Break, %	4.5	ASTM D638
Modulus of Elasticity, MPa [psi]	690 [100,000]	ASTM D638

\* Not Specifications

N/A Not Applicable



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HANDLING INSTRUCTIONS	
Recommended Mix Ratio, Resin:Catalyst	10:1
Pot Life, 15 grams	10 min

CURING GUIDELINES	
CURE SCHEDULE	
Time, min	Temperature, °C [°F]
60	25

CT614 should NOT be used for curing large volumes of C-ER2994 due to excessive exotherm in mass.

### INSTRUCTIONS FOR USE

Instructions for Use:

From bulk containers;

1. Prior to removing material from its shipping container, mix thoroughly.
2. Weigh out required amount of C-ER2994 resin and CT614 in the ratio 100 parts resin to 10 parts catalyst.
3. Mix thoroughly.
4. If entrapped air is a problem, the mixed material can be evacuated prior to use.
5. Pour into mold or cavity or apply to bond line.
6. Cure according to schedule with appropriate catalyst.

From ratio cartridges;

1. Dispense material until both the resin and the catalyst flow from the cartridge.
2. Attach a static mixer with at least 10 elements.
3. Dispense onto bond-line or into cavity.

### OPTIMIZING PERFORMANCE AND HANDLING

1. Parts should be allowed to cool after cure before testing and subjecting to any loads.
2. Parts should be free from oil and debris for best performance.

### DISPENSING THE ADHESIVE

This material may be dispensed with a variety of manual and automatic applicators or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred to DYMAX Applications Engineering.

### STORAGE AND SHELF LIFE

Keep covered when not in use. This material has a minimum 12-month shelf life from date of shipment, unless otherwise specified, when stored between 10°C [50°F] and 32°C [90°F] in the original, unopened container.

### CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Clean up of cured material may require mechanical methods of removal.

### GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Material Safety Data Sheet before use.

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