

# ThreeBond 2217L

One Component Epoxy Resin

ThreeBond **2217L** is a one component solvent free epoxy resin. It cures rapidly when heated in an oven, by an IR lamp or by induction. It provides good adhesion to most materials and has excellent mechanical, thermal and chemical resistance. It has been developed as an SMA (Surface Mount Adhesive) for wave soldering process.

## 1. Features

- One component solvent free epoxy
- No mixing required
- Heat curing
- Service temperature : -40 / +150°C
- Fast cure at low temperature
- SMA (Surface Mount Adhesive)

## 2. Properties

### Before curing

Test	Results	Unit
Colour	Pink	-
Viscosity at 25°C	154	Pa.s
Thixotropic index	3.0	-
Specific gravity at 25°C	1.24	-
Curing time at		
80°C	220	sec
100°C	90	
120°C	70	
150°C	50	

### After curing

Test	Results	Unit
Hardness	88	Shore D
Shear strength - Fe	22.6	MPa
Water absorption (100°Cx1h)	+ 0.60	%
Glass transition temperature	99	°C
Thermal expansion coef.	75	ppm/°C

Test	Results	Unit
Volume resistivity	$1.6 \times 10^{14}$	$\Omega \cdot m$
Surface resistivity	$9.4 \times 10^{13}$	$\Omega$
Dielectric constant at		
200Hz	3.40	-
1kHz	3.40	
1MHz	3.28	
Dielectric breakdown voltage	22	kV/mm

## 3. Handling

- Before use, please refer to the safety data sheet.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- The curing time may change depending on the quantity applied, the heat source and the part's material.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Excess product may be removed using TB2890D cleaner.
- Keep the product in its original container tightly sealed and store it in a dark, dry and well ventilated place at **-5 ~ 10°C**.