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TK PASTE CR-2800　INSTRUCTION MANUAL

● Be sure to read this INSRUCTION MANUAL and SDS before use and use product properly for your safety.
● Be sure to keep this Manual in easily referable place at any time.

[FEATURES]

One-liquid, easily-handled, and low temp.(@ 90℃) curing Ag paste.
Best solution for electric conductive bonding of low heat resistivity parts.

[CHARACTERISTIC VALUES & USE CONDITIONS]

Item	Characteristics	Note
Resistivity	6×10-3Ω·cm	Cured at 90℃ for 60min.
Store Condition	-10℃ or below	
Viscosity	30 Pa·s	E type viscometer @25°C 5rpm
Thixotropic ratio	6~8	0.5rpm/5rpm
Pencil hardness	4H	
Recommended curing condition	90℃×60min	With constant-temp. oven with airflow

[FOR SAFETY]

- The product is consisted of reactive epoxy.
  Do NOT mix the product with materials containing active hydrogen such as aliphatic amine and mercaptan, which may cause drastic heat-up or smoke.
- Epoxy resin has skin sensitization and may cause skin/eye irritation.
  Wear protective tools when using and pay attention not to touch the product with your skin or eyes.
- To prevent water contamination, leave the product tightly sealed at room temperature of 15℃ to 25℃ for 30 min. for thawing.
  Avoid forced heating including hot/warm water, oven and hot plate, or container may explode.
- Be sure to read Safety Data Sheet (SDS) before use for detailed description of the product, including its toxicity and emergency procedures.

[FOR BEST PERFORMANCE]

- Store the product at -10 ℃ or below.
- Before application, use cleaning solvent such as alcohol and acetone to clean adherend surface.
  If not clean, the product may not perform at its best.
- Conductivity can be obtained by heating this product. If the heating temperature or time is insufficient, conductivity may not be obtained.
  The time for conductivity to stabilize depends on the temperature and the amount of application.
  Please use the product after careful consideration with the actual equipment and the

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[USE METHOD]

I. Store

- Freeze the product at -10°C or below.
  If stored at above -10°C, components deteriorate to affect characteristic values.
- Use the product from the oldest lot.
  Lot# is put on the label on syringe.

II. Use

- Read SDS thoroughly before use and follow below instructions.
  If not properly handled, the product performance may deteriorate.

Procedure	Remarks
1 Take the product from freezer, leave it tightly sealed at room temperature for more than 30 min., and bring it back to normal temperature. Wipe waterdrop off before open.	✔ Avoid forced heating including hot/warm water, oven and hot plate, or container may explode. ✔ Wipe off any waterdrops that may appear on the container. Water contaminated product cannot be used.
2 Use cleaning solvent such as alcohol and acetone and clean adhered surface.	✔ If flux or oil is present in the area where the adhesive is applied, adequate performance may not be obtained. ✔ Dry thoroughly after cleaning. Residual cleaning agent may prevent adequate adhesion.
3 Use dispenser to apply. Recommended internal diameter of needle is 0.25mm or larger.	✔ Needle with smaller internal diameter may clog the product.
4 This product cures by heating and provides adhesive strength and conductivity. (Recommended curing condition is 90℃×60min.) The curing time until conductivity stabilizes varies depending on the amount or location of application. Please check with the actual equipment and materials to be adhered before use.	✔ When curing, use equipment that can maintain a constant temperature (such as a constant temperature oven with airflow). Dryers and hot plates do not provide uniform heating and may not provide sufficient performance. ✔ Depending on the ambient environment, such as under high temperatures, the characteristics may deteriorate even within the pot life. Please manage the product in accordance with actual usage conditions.

III. Disposal

- Separate the product and anything exposed to it (such as used container with its residue and cloth to wipe it off at use) from other materials, and dispose.
- Use professional waste treatment service to dispose the product.