

LINQBOND™ PM-WD310



Two-part black epoxy potting material

- High resistance against moisture and aging
- Low outgassing properties
- Solvent-free and non-volatile

LINQBOND™ PM-WD310 is a two-component potting epoxy designed for casting, bonding, and sealing automotive lighting and electronic devices. This high-performance product is designed to meet the rigorous demands of modern applications, offering unparalleled reliability and durability.

LINQBOND™ PM-WD310 ensures good protection of sensitive electronic in application environments, enhancing the longevity and reliability of your devices and offers strong high hardness and durability, ensuring lasting protection and structural integrity.

Premixed properties

Property	Part A	Part B
Appearance	Black Liquid	Light Yellow Liquid
Viscosity ¹	5500 ±1100 cP	900 ±300 cP
Specific Gravity	1.165	0.95
Shelf life	12 months	12 months

Mixed properties

Property	Value	Unit
Mixing ratio by Weight	2:1	–
Pot Life at 25 °C	30	mins
Initial Curing Time (25°C/50°C)	3–4/2–3	h
Full Curing Time at 25°C	5–7	day

Cured properties ²

Property	Value	Unit
Shore Hardness	65–70	Shore D
Glass Transition Temperature ²	40	°C
Glass Transition Temperature ³	51	°C
Thermal Conductivity	0.3	W/m · K
Thermal Resistance	0.1	K/W
Volume Resistivity	5×10^{15}	$\Omega \cdot \text{cm}$
Surface Resistivity	5×10^{14}	Ω
Dielectric Constant at 100Hz	4.1	-

¹ Spindle 14,10 RPM

² Cure Condition: 25°C at 7 days

³ Cure Condition: 80°C at 1 day

Europe

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Cured properties ²

Property	Value	Unit
Tensile Strength	2.2	MPa
Tensile Modulus	2.6	MPa
Lap Strength	6.3	MPa
Elongation	5	%
Shear Strength¹		
Al vs Al	392	MPa
Al vs Glass	1578	
Glass vs Glass	1382	
Shear Strength²		
Al vs Al	509	MPa
Al vs Glass	2177	
Glass vs Glass	1814	
Water Absorption		
25 °C at 24 h	0.41	%
80 °C at 24 h	4.3	
97 °C at 1.5 h	2.74	
Weight Loss Ratio		
100 °C/150 °C/200 °C	0.45/1.3/1.98	%
150 °C/300 °C/350 °C	2.96/5.1/11.6	
Degradation Temperature	280	°C

Processing Instructions

1. Before potting, make sure the surface is clean. Remove any grease or dust and mold release.
2. Mix component A and B according to specified ratio. Stir thoroughly to ensure uniformity and stir 15 seconds more once uniform color is achieved.
3. Defoam mixture for 5 minutes.
4. Use the mixture within 30 minutes.
5. Package cure times will vary depending on a number of variables, including package size, materials composition, potting thickness, and oven efficiency. The cure schedule needs to be verified using actual production tools and parts. Additionally, curing process is influenced by temperature variations; generally, higher temperatures result in faster curing, while lower temperatures lead to slower curing.

Please note that the provided information is based on available data and typical conditions. For specific applications and detailed test results, refer to the actual test data and conduct appropriate certifications.

Storage and Handling

Store in a ventilated, cold, and dark environment at 14–34 °C. Keep away from direct sunlight. It is advised to replace the lid immediately after use. At proper storage conditions, unopened Part A and Part B has a shelf life of 12 months.

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