

LINQBOND EO-322PL



One-component epoxy-based adhesive

- Strong adhesion on different materials, especially plastics
- Suitable for memory cards, CMOS assembly, and heat-sensitive components
- High reliability and durability

LINQBOND EO-322PL is a one-component epoxy adhesive, suitable for bonding and potting electronic components. It cures at medium to high temperatures. The cured product has a low-gloss surface with no oiliness and offers high bonding strength, particularly on plastic substrates.

LINQBOND EO-322PL offers excellent chemical resistance, shock resistance, providing effective protection for electronic components. It retains its electrical properties even under high humidity and exhibits dimensional stability across a wide temperature range. This adhesive is RoHS 2011/65/EU compliant, halogen-free according to IEC 61249-2-21 standards, and meets various environmental testing requirements. Overall, **LINQBOND EO-322PL** is an ideal choice for bonding memory cards, C-MOS assemblies, and heat-sensitive components.

Uncured Properties

Property	Value	Unit
Appearance	Liquid, Black	–
Viscosity (25 °C) Spindle 14, 50 rpm	19000–25000	cps
Thixotropic Index	2–3	–

Recommended Curing Conditions

Property	Value	Unit
Pot Life (25 °C)	3	day
Recommended Cure Time at 80 °C at 100 °C at 120 °C	60 40 30	min

Instructions for Use

1. Thaw the refrigerated product (–20 to –5 °C) to room temperature. First, let the package be at 2 °C to 13 °C for 1 hour, then warm it up to 14 °C to 34 °C for another 1 to 1.5 hours. Do not open the container until it reaches the correct temperature.
2. Make sure that the bonding surfaces are clean, dry, and properly prepared according to best practices.
3. Apply the adhesive to one or both surfaces to be bonded. Maintain contact between the parts until the adhesive fully cures.
4. The actual cure time will vary depending on factors, including part geometry, materials, bondline thickness, and oven efficiency. Confirm the optimal cure schedule using production parts and equipment.

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Cured Properties

Property	Value	Unit
Hardness	86	Shore D
Specific Heat at 25 °C at 75 °C	1.21 1.40	J/g · °C
Weight Loss Ratio at 100 °C at 150 °C at 300 °C	<0.5 <0.5 <0.5	%
Glass Transition Temperature (DSC)	40	°C
Coefficient of Thermal Expansion (CTE) α_1 α_2	66 178	ppm/°C
Water Absorption Ratio at 25 °C for 24 h at 97 °C for 1.5 h	0.23 0.66	%
Specific Gravity	1.22	–
Surface Resistivity	8.37×10^{14}	Ω
Volume Resistivity	8.41×10^{13}	$\Omega \cdot \text{cm}$
Degradation Temperature (TGA 10°C /min)	418	°C

Note: Sample was cured at 120 °C for 30 minutes.

Caution for Use

While the risk of carcinogenicity from skin contact is considered low, mild skin redness may occur. In the event of skin contact, immediately wash thoroughly with soap and water, avoid the use of solvents. Ingestion of this product is moderately toxic and requires immediate medical attention. If the product is accidentally swallowed, do not induce vomiting unless directed by medical personnel. In case of eye contact, immediately flush the affected eye(s) thoroughly with clean water for a minimum of 15 minutes and seek medical attention promptly. For comprehensive safety information, please consult the Material Safety Data Sheet (MSDS).

Storage and Handling

Store the sealed container at –20 °C to –5°C, away from moisture and heat. When unopened and stored properly, the shelf life is 181 days (about 6 months). Avoid keeping the product at 14 °C to 34 °C for too long, as this may affect its performance.

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