



Technical Data Bulletin No.
 Mereco 350 FC
 Rev 0 9/16/13

PRODUCT INFORMATION

High Technology Materials for Electronics and Industry

PRODUCT NUMBER: Mereco 350 FC DESIGNATION: High Temperature Adhesive
 350°C Service Temperature

INTENDED APPLICATION: High temperature PEM fuel cell devices. Bonding single cells together to create stack (>300C)

DESCRIPTIVE DATA:

	<u>MIXTURE</u>
FORM	Viscous liquid
COLOR	Amber
SP. GR.:	1.21
*VISCOSITY:	14000-20000 cps

INSTRUCTIONS FOR USE:

MIX RATIO:	N/A	One Component Mixture
POT LIFE:	(MASS) 100g	(WORKING LIFE OF MIXTURE) 1 week after container opened AT 25°C
CURE TIMES:	1 hour at 175°C + 1 hour at 230°C	

SPECIAL INSTRUCTIONS: Mix thoroughly before application to parts
 Store in a closed container at room temperature for up to six months

CHARACTERISTICS OF CURED COMPONENTS:

	<u>TEST METHOD</u>	<u>AVERAGE VALUES**</u>	<u>PHYSICAL UNIT</u>
IMPACT RESISTANCE	IZOD		ft-lbs/in notch
EXPANSION COEFFICIENT	ASTM D 696	60-65	µm/m°C
THERMAL SHOCK RESIST.	MIL-I-16923C		
OPERATING TEMP. RANGE		-55 to + 350	°C
GLASS TRANSITION		255	°C
HARDNESS TESTS	ASTM D 2240	86	Shore D
MOISTURE TESTS		0.08%	2hr@100°C water
FLEXURAL STRENGTH	ASTM D 790		psi
MODULUS OF ELASTICITY		530000	psi
TENSILE STRENGTH	ASTM D 638	11,000	psi
OUTGASSING		0.12 @ 300C	%
TENSILE LAP SHEAR (A1-A1)	ASTM D 1002	2500	psi
DIELECTRIC STRENGTH	ASTM D 149		volts/mil
VOLUME RESISTIVITY	ASTM D 257	10 ¹⁴	ohm-cm
DISSIPATION FACTOR	ASTM D 150		
DIELECTRIC CONSTANT	ASTM D 150		

* Thixotropic materials list viscosity obtained by Helipath test method.

** Test values are average values obtained by standard laboratory tests. These are not intended as final specification limits and are not to be used for the preparation of specifications.

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