## Fiber to Ferrule Bonding

### What is Fiber to Ferrule Bonding?

Fiber optic cables require proper termination for optimum transmission efficiency and minimal data loss. Selecting the right adhesives assures limited fiber displacement and mitigates interference from mechanical and thermal factors. Epoxies are used to maintain fiber alignment within the ferrule, as well as allowing light to be transmitted.



### Where Can Fiber to Ferrule Bonding Materials Be Used?

Epoxies bond well to most substrates; notably glass, stainless steel, zirconia, and ceramic. A small amount of epoxy can be used to pot (fill-in) the void between the outer diameter of the fiber and the inner diameter of the ferrule. This ensures the epoxy holds the fiber within the ferrule, which is then polished to help sustain the fibers' optical properties.

### Which EPO-TEK® Products Are Best Suited For Fiber to Ferrule Bonding?

Epoxy Technology manufactures a variety of optical adhesives, listed below by cure type:

- Low Viscosity:
  - Room Temp Cure: 301, 301-2, 302-3M, OM125
  - Thermal Cure: 323LP, 353ND, 354, 377, 383ND
  - UV Cure: OG142-87, OG198-54, OG603
- Low/Non-Flow:
  - Room Temp Cure: OJ2116
  - Thermal Cure: 323LP-T, 353ND-T, 354-T
  - UV Cure: OG116-31, OG198-55

### Characteristics To Help Choose the Correct EPO-TEK® Product

EPO-TEK	Key advantages/ Characteristics
301	Low viscosity, RT cure, highly wicking, commonly used in fiber optic catheters
301-2	Low viscosity, long pot life, RT cure, highly wicking ISO-10993, USP Class VI approved
302-3M	Medium viscosity, RT cure, strong moisture and chemical resistance
323LP	Medium viscosity, heat cure, long pot life version of 353ND
323LP-T	Non-flowing version of 323LP
353ND	Well known (Industry standard) in fiber optics, high performance and reliability
353ND-T	Non-flowing version of 353ND
354	Long pot life (3 days) version of 353ND, high strength and reliability USP Class VI approved
354-T	Thixotropic version of 354
377	Low viscosity, heat cure, low stress and strong chemical resistance, ideally suited for fiber optic bundles
383ND	8 hour pot life version of 353ND
OG116-31	Higher viscosity, UV cure, low flow material with high strength and low stress
OG142-87	Low viscosity, UV cure, high strength epoxy
OG198-54	Low viscosity, UV cure, allows for some shadow cure through heat
OG198-55	Non-flowing version of OG198-54, allows for some shadow cure through heat
OG603	Low viscosity, very fast UV cure, acrylate type, for fiber optic pigtails
OJ2116	Medium viscosity, very fast cure for field assembly and repairs
OM125	Medium viscosity, RT cure, low shrinkage and low stress, blue color





## How Do The EPO-TEK Properties Compare?

0M125	0J2116	06603		06198-55	0G198-54 0G198-55	0G142-87 0G198-54 0G198-55	0G116-31 0G142-87 0G198-54 0G198-55	383ND 0G116-31 0G142-87 0G198-54	383ND 0G116-31 0G142-87 0G198-54	354-T 377 383ND 0G116-31 0G198-54 0G198-55	354-T 354-T 377 383ND 0G116-31 0G198-54	353ND-T 354 354-T 354-T 377 383ND 0G116-31 0G198-54 0G198-54	353ND-T 353ND-T 354 354-T 377 377 383ND 0G116-31 0G198-54	323LP-T 353ND-T 353ND-T 354-T 354-T 377 383ND 06116-31 06198-54 06198-54	323LP-T 323LP-T 353ND-T 353ND-T 354-T 354-T 354-T 377 383ND 0G116-31 0G198-54 0G198-54	302-3M 323LP-T 353ND 353ND-T 353ND-T 354-T 354-T 377 383ND 0G116-31 0G198-54	301-2 302-3M 323LP-T 353ND-T 353ND-T 354-T 354-T 354-T 36116-31 06116-31 06198-54	301-2 301-2 302-3M 302-3M 323LP-T 353ND-T 353ND-T 353ND-T 354-T 354-T 354-T 36116-31 0G198-54
Two	Two	0ne		One														
Blue/Blue	Clear/ Colorless	Clear/ Colorless		Cloudy	Clear/ Colorless Cloudy	Clear/ Colorless Clear/ Colorless Cloudy	White/White Clear/ Colorless Clear/ Colorless Cloudy	Amber/ Dark Red  White/White  Clear/ Colorless  Clear/ Colorless  Cloudy	Amber/ Dark Amber Amber/ Dark Red  White/White  Clear/ Colorless  Clear/ Colorless  Cloudy	Amber/ Amber/ Dark Amber/ Amber/ Dark Red Dark Red Clear/ Colorless Clear/ Colorless	Amber Amber/ Amber/ ark Amber/ Dark Red Unite/White Clear/ Colorless Clear/ Colorless	Tan/ Dark Red Amber Amber/ Amber/ Amber/ Dark Amber/ Dark Red Clear/ Colorless Cloudy	Amber/ Dark Red Tan/ Dark Red Amber Amber Amber/ Ark Amber/ Dark Amber/ Colorless Clear/ Colorless Clear/ Colorless	Amber/ Dark Amber  Amber/ Dark Red  Tan/ Dark Red  Amber  Amber  Amber/ Dark Amber  Amber/ Dark Red  White/White  Clear/ Colorless  Clear/ Cloudy	Amber/ Dark Amber Amber/ Dark Amber/ Dark Red Tan/ Dark Red Amber Amber Amber Amber Amber/ Dark Amber Amber/ Dark Red White/White Clear/ Colorless Clear/ Cloudy	Clear/ Colorless Amber/ Dark Amber Amber/ Dark Red Tan/ Dark Red Amber Amber Dark Red Amber Clear/ Colorless Clear/ Colorless Clear/ Colorless	Clear/ Colorless Clear/ Colorless Amber/ Dark Amber/ Amber/ Dark Red Tan/ Dark Red Tan/ Dark Red Amber Clear/ Colorless Clear/ Colorless Clear/ Colorless	Clear/ Colorless Clear/ Colorless Clear/ Colorless Clear/ Colorless Amber/ Amber/ Dark Amber Dark Red Amber Amber Dark Red Amber Dark Red Amber Clear/ Colorless Clear/ Colorless Clear/ Colorless Clear/ Colorless
80°C – 1 hour 23°C – 24 hours	23°C – 30 min	100mW/cm² for >5 sec @ 240-365nm		100mW/cm² for >2 min @ 240-365nm	100mW/cm² for >2 min @ 240-365nm 100mW/cm² for >2 min @ 240-365nm	100mW/cm² for >2 min @ 240-365nm 100mW/cm² for >2 min @ 240-365nm 100mW/cm² for >2 min @ 240-365nm												
2,400 - 5,400 cPs @ 50 rpm	N/A	150 - 250 cPs @ 100 rpm	210	1,200 - 2,000 cPs @ 100 rpm	200 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	250 - 600 cPs @ 100 rpm 200 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 200 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 200 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	150 - 300 cPs @ 100 rpm 3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 200 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	11,000 - 20,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 250 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	4,000 - 6,000 cPs @ 50 rpm 11,000 - 2,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 250 - 600 cPs @ 100 rpm 250 - 600 cPs @ 100 rpm 250 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	9,000 - 15,000 cPs @ 20 rpm 4,000 - 6,000 cPs @ 50 rpm 11,000 - 20,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 10 rpm 250 - 600 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm 250 - 450 cPs @ 100 rpm 1,200 - 2,000 cPs @ 100 rpm	3,000 - 5,000 cPs @ 50 rpm 9,000 - 15,000 cPs @ 20 rpm 4,000 - 6,000 cPs @ 50 rpm 11,000 - 20,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 3,500 - 6,000 cPs @ 50 rpm 20,000 - 30,000 cPs @ 60 rpm 20,000 - 30,000 cPs @ 100 rpm 20,000 - 450 cPs @ 100 rpm 200 - 450 cPs @ 100 rpm 21,200 - 2,000 cPs @ 100 rpm	22,451 cPs @ 10 rpm  3,000 - 5,000 cPs @ 50 rpm  9,000 - 15,000 cPs @ 20 rpm  4,000 - 6,000 cPs @ 20 rpm  11,000 - 20,000 cPs @ 20 rpm  150 - 300 cPs @ 100 rpm  3,500 - 6,000 cPs @ 10 rpm  20,000 - 30,000 cPs @ 10 rpm  20,000 - 450 cPs @ 100 rpm  2000 - 450 cPs @ 100 rpm  1,200 - 2,000 cPs @ 100 rpm	3,500 - 5,000 cPs @ 50 rpm 22,451 cPs @ 10 rpm 3,000 - 5,000 cPs @ 50 rpm 9,000 - 15,000 cPs @ 20 rpm 4,000 - 6,000 cPs @ 50 rpm 11,000 - 20,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 250 - 6,000 cPs @ 10 rpm 250 - 600 cPs @ 10 rpm 250 - 600 cPs @ 10 rpm 250 - 600 cPs @ 100 rpm	800 - 1,600 cPs @ 100 rpm 3,500 - 5,000 cPs @ 50 rpm 22,451 cPs @ 10 rpm 3,000 - 5,000 cPs @ 50 rpm 9,000 - 15,000 cPs @ 20 rpm 4,000 - 6,000 cPs @ 20 rpm 11,000 - 20,000 cPs @ 100 rpm 20,000 cPs @ 100 rpm 250 - 6,000 cPs @ 100 rpm 250 - 6,000 cPs @ 100 rpm 250 - 6,000 cPs @ 100 rpm 2,000 - 30,000 cPs @ 100 rpm 2,000 - 30,000 cPs @ 100 rpm 2,000 - 2,000 cPs @ 100 rpm 2,000 - 2,000 cPs @ 100 rpm	225 - 425 cPs @ 100 pm  800 - 1,600 cPs @ 100 pm 3,500 - 5,000 cPs @ 50 rpm 22,451 cPs @ 10 rpm 3,000 - 5,000 cPs @ 10 rpm 9,000 - 15,000 cPs @ 20 rpm 1,000 - 20,000 cPs @ 20 rpm 150 - 300 cPs @ 100 rpm 20,000 - 6,000 cPs @ 100 rpm 250 - 600 cPs @ 100 rpm	225 - 425 cPs @ 100 rpm  225 - 425 cPs @ 100 rpm  800 - 1,600 cPs @ 100 rpm  3,500 - 5,000 cPs @ 10 rpm  22,451 cPs @ 10 rpm  22,451 cPs @ 10 rpm  3,000 - 5,000 cPs @ 20 rpm  4,000 - 6,000 cPs @ 20 rpm  11,000 - 20,000 cPs @ 20 rpm  150 - 300 cPs @ 100 rpm  250 - 6,000 cPs @ 100 rpm  250 - 600 cPs @ 10 rpm  250 - 600 cPs @ 10 rpm  250 - 600 cPs @ 100 rpm
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≥20 kg/6,800 psi	17 kg/5,780 psi	≥3 kg/1,020 psi		>20 kg/6,800 psi	>10 kg/3,400 psi	>20 kg/6,800 psi >10 kg/3,400 psi >20 kg/6,800 psi	≥10 kg/3,400 psi >20 kg/6,800 psi >10 kg/3,400 psi >20 kg/6,800 psi	>20 kg/6,800 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >10 kg/3,400 psi >20 kg/6,800 psi	≥10 kg/3,400 psi >20 kg/6,800 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >10 kg/3,400 psi >20 kg/6,800 psi	≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥15 kg/5,100 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥15 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	>20 kg/6,800 psi ≥15 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	>20 kg/6,800 psi >20 kg/6,800 psi ≥15 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi ≥15 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥15 kg/5,100 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi ≥215 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi ≥20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi	≥10 kg/3,400 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi ≥15 kg/5,100 psi ≥15 kg/5,100 psi ≥10 kg/3,400 psi >20 kg/6,800 psi >20 kg/6,800 psi >20 kg/6,800 psi
N/A	1.5459 (uncured)	1.5037		1.5023 (uncured) 1.5196 (cured)	1.5046 (uncured) 1.5256 (cured) 1.5023 (uncured) 1.5196 (cured)	1.4925 1.5046 (uncured) 1.5256 (cured) 1.5023 (uncured) 1.5196 (cured)	1.5665 1.4925 1.5046 (uncured) 1.5256 (cured) 1.5023 (uncured) 1.5196 (cured)	1.5715 (uncured) 1.5665 1.4925 1.5046 (uncured) 1.5256 (cured) 1.5023 (uncured) 1.5196 (cured)	1.5195 (uncured) 1.5715 (uncured) 1.5665 1.4925 1.5046 (uncured) 1.5256 (cured) 1.5023 (uncured) 1.5196 (cured)	N/A 1.5195 (uncured) 1.5715 (uncured) 1.5765 1.5665 1.4925 1.5046 (uncured) 1.5256 (cured) 1.5196 (cured)	1.5734 (uncured) N/A 1.5195 (uncured) 1.5715 (uncured) 1.5665 1.4925 1.5046 (uncured) 1.5256 (cured) 1.5196 (cured)	N/A 1.5734 (uncured) N/A 1.5195 (uncured) 1.5715 (uncured) 1.5765 1.4925 1.4925 1.5046 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5023 (uncured) 1.5196	1.5694 (uncured) N/A 1.5734 (uncured) N/A 1.5195 (uncured) 1.5715 (uncured) 1.5665 1.4925 1.5046 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5266 (uncured)	N/A  1.5694 (uncured)  N/A  1.5734 (uncured)  N/A  1.5195 (uncured)  1.5715 (uncured)  1.5046 (uncured)  1.5256 (uncured)  1.5256 (cured)  1.5196 (cured)  1.5196 (cured)	1.5704 (uncured)  N/A  1.5694 (uncured)  N/A  1.5734 (uncured)  N/A  1.5715 (uncured)  1.5715 (uncured)  1.5046 (uncured)  1.5046 (uncured)  1.5023 (uncured)  1.5196 (cured)  1.5196 (cured)	1.5446 (uncured) 1.5704 (uncured) N/A 1.5694 (uncured) N/A 1.5734 (uncured) N/A 1.5715 (uncured) 1.5715 (uncured) 1.5765 1.4925 1.5046 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5196 (uncured)	1.5318 (uncured) 1.5446 (uncured) 1.5704 (uncured) N/A 1.5694 (uncured) N/A 1.5734 (uncured) N/A 1.5715 (uncured) 1.5715 (uncured) 1.5046 (uncured) 1.5046 (uncured) 1.5023 (uncured) 1.5196 (cured) 1.5196 (cured)	1.5190 (uncured) 1.5318 (uncured) 1.5446 (uncured) 1.5704 (uncured) N/A 1.5694 (uncured) N/A 1.5734 (uncured) N/A 1.5715 (uncured) 1.5715 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5256 (uncured) 1.5265 1.4925 1.5023 (uncured) 1.5196 (cured)
>96% @ 1500nm >98% @ 1000nm	>97% @ 460-1620nm	>98% @ 420-1600nm		>97% @ 560-1680nm	>97% @ 460-1680nm >97% @ 560-1680nm	>97% @ 580-1660nm >97% @ 460-1680nm >97% @ 560-1680nm	>96% @ 660-1640nm >92% @ 500nm >97% @ 580-1660nm >97% @ 460-1680nm >97% @ 560-1680nm	>90% @ 520-1660nm >96% @ 660-1640nm >92% @ 500nm >97% @ 580-1660nm >97% @ 460-1680nm >97% @ 560-1680nm	>90% @ 600-1000nm ≥98% @ 1000-6800nm >90% @ 520-1660nm >96% @ 660-1640nm >92% @ 500nm >97% @ 580-1660nm >97% @ 460-1680nm >97% @ 560-1680nm	N/A  ≥90% @ 600-1000nm  ≥98% @ 1000-6800nm  >90% @ 520-1660nm  >96% @ 660-1640nm  >92% @ 500nm  >97% @ 580-1680nm  >97% @ 460-1680nm	≥96% @ 600nm ≥99% @ 800nm ≥99% @ 600-1000nm ≥98% @ 1000-6800nm >90% @ 520-1660nm >96% @ 660-1640nm >92% @ 500nm >97% @ 580-1660nm >97% @ 560-1680nm	N/A  296% @ 600nm  299% @ 800nm  N/A  290% @ 600-1000nm  298% @ 1000-6800nm  >90% @ 520-1660nm  >92% @ 560-1640nm  >97% @ 580-1660nm  >97% @ 580-1660nm  >97% @ 560-1680nm	>50% © 550nm >98% © 800-1000nm >95% © 600nm 299% © 600-1000nm ≥99% © 600-1000nm ≥99% © 1000-6800nm >90% © 520-1660nm >92% © 500-1660nm >97% © 580-1660nm >97% © 560-1680nm	N/A  50% © 550nm  98% © 800-1000nm  985% © 1100-1600nm  N/A  296% © 600-1000nm  299% © 800-1000nm  298% © 1000-6800nm  >90% © 520-1660nm  >92% © 560-1640nm  >97% © 580-1660nm  >97% © 580-1660nm	≥94% @ 820-1620nm ≥90% @ 640-800nm N/A >50% @ 550nm >98% @ 800-1000nm >95% @ 1100-1600nm N/A ≥96% @ 600-1000nm ≥99% @ 800nm ≥99% @ 600-1000nm ≥99% @ 520-1660nm >92% @ 520-1660nm >92% @ 560-1680nm >97% @ 580-1680nm >97% @ 560-1680nm	>95% @ 460-1620nm  ≥94% @ 820-1620nm  ≥90% @ 640-800nm  N/A  >50% @ 550nm  >98% @ 800-1000nm  >95% @ 1100-1600nm  N/A  ≥96% @ 600-1000nm  ≥99% @ 600-1000nm  ≥99% @ 600-16800nm  >90% @ 520-1660nm  >92% @ 500nm  >97% @ 580-1680nm  >97% @ 580-1680nm  >97% @ 580-1680nm	>94% @ 320nm >99% @ 400-1200nm >98% @ 1200-1600nm >98% @ 1200-1620nm ≥94% @ 820-1620nm ≥94% @ 820-1620nm ≥98% @ 800-1000nm >95% @ 1100-1600nm N/A 296% @ 600-1000nm ≥99% @ 8000nm ≥99% @ 8000nm ≥99% @ 600-1660nm ≥99% @ 520-1660nm >99% @ 520-1660nm >99% @ 520-1660nm >99% @ 580-1640nm >99% @ 580-1640nm >99% @ 580-1640nm >99% @ 580-1640nm >97% @ 580-1660nm	>99% @ 380-980nm >95% @ 1640-2040nm >99% @ 1640-1200nm >99% @ 1200-1600nm >95% @ 460-1620nm >95% @ 460-1620nm ≥90% @ 640-800nm ≥90% @ 640-800nm >95% @ 1100-1600nm >95% @ 1000-6800nm >90% @ 600-1000nm ≥99% @ 600-1000nm ≥99% @ 600-1000nm >90% @ 520-1660nm >90% @ 520-1660nm >97% @ 580-1680nm >97% @ 580-1680nm
367°C	347°C	385°C		354°C	369°C 354°C	384°C 369°C 354°C	384°C 369°C 354°C	415°C 409°C 384°C 369°C	375°C 415°C 409°C 384°C 369°C	485°C 375°C 415°C 409°C 384°C 369°C	487°C 485°C 375°C 415°C 409°C 384°C 384°C	409°C 485°C 485°C 475°C 415°C 409°C 384°C 384°C	412°C 409°C 485°C 375°C 415°C 409°C 384°C 384°C	419°C 412°C 409°C 485°C 485°C 475°C 415°C 409°C 375°C 384°C 384°C	413°C 419°C 412°C 409°C 485°C 485°C 415°C 415°C 375°C 384°C 354°C	351°C 413°C 419°C 419°C 409°C 485°C 485°C 415°C 409°C 375°C 375°C 375°C	360°C  351°C  413°C  419°C  409°C  485°C  485°C  375°C  384°C  384°C	430°C 360°C 351°C 413°C 419°C 449°C 485°C 485°C 499°C 499°C 375°C 384°C 384°C
	N/A	69 x 10 <sup>-6</sup> 170 x 10 <sup>-6</sup>	120 x 10°	72 x 10 <sup>-6</sup>	74 × 10-6 145 × 10-6 72 × 10-6	50 × 10° 162 × 10° 74 × 10° 145 × 10° 12 × 10° 72 × 10°	41 × 10° 170 × 10° 50 × 10° 162 × 10° 74 × 10° 145 × 10° 72 × 10° 72 × 10°	34 × 10° 129 × 10° 41 × 10° 170 × 10° 50 × 10° 162 × 10° 145 × 10° 145 × 10° 172 × 10°	57 × 10° 210 × 10° 34 × 10° 129 × 10° 41 × 10° 170 × 10° 162 × 10° 145 × 10° 145 × 10°	51 x 10° 179 x 10° 210 x 10° 210 x 10° 34 x 10° 129 x 10° 41 x 10° 41 x 10° 50 x 10° 162 x 10° 145 x 10° 172 x 10° 172 x 10° 173 x 10° 174 x 10° 175 x	96 × 10° 175 × 10° 57 × 10° 57 × 10° 57 × 10° 210 × 10° 210 × 10° 41 × 10° 129 × 10° 162 × 10° 145 × 10° 145 × 10° 170 × 10° 145 × 10°	43 × 10° 231 × 10° 96 × 10° 175 × 10° 57 × 10° 57 × 10° 210 × 10° 210 × 10° 129 × 10° 129 × 10° 170 × 10° 170 × 10° 170 × 10° 162 × 10° 145 × 10°	54 × 10° 206 × 10° 43 × 10° 43 × 10° 96 × 10° 96 × 10° 175 × 10° 51 × 10° 179 × 10° 210 × 10° 210 × 10° 129 × 10° 170 × 10° 162 × 10° 145 × 10° 172 × 10°	N/A  54 × 10-6  206 × 10-6  43 × 10-6  43 × 10-6  96 × 10-6  175 × 10-6  179 × 10-6  57 × 10-6  210 × 10-6  41 × 10-6  129 × 10-6  162 × 10-6  145 × 10-6  172 × 10-6  172 × 10-6  172 × 10-6  174 × 10-6  175 × 10-6  170 × 10-6  170 × 10-6  170 × 10-6  171 × 10-6  172 × 10-6  173 × 10-6  174 × 10-6  175 × 10-6  175 × 10-6  176 × 10-6  177 × 10-6  178 × 10-6  179 × 10-6  170 × 10-6  170 × 10-6  170 × 10-6  170 × 10-6	31 × 10° 132 × 10° 132 × 10° 132 × 10° 54 × 10° 206 × 10° 43 × 10° 231 × 10° 26 × 10° 175 × 10° 179 × 10° 210 × 10° 170	56 × 10° 193 × 10° 31 × 10° 132 × 10° 54 × 10° 206 × 10° 206 × 10° 207 × 10° 208 × 10° 208 × 10° 209 × 10° 209 × 10° 209 × 10° 200	61 × 10° 180 × 10° 180 × 10° 193 × 10° 193 × 10° 132 × 10° 132 × 10° 132 × 10° 132 × 10° 132 × 10° 132 × 10° 10° 175 × 10° 175 × 10° 175 × 10° 175 × 10° 179 × 10° 170	39 × 10° 98 × 10° 61 × 10° 180 × 10° 56 × 10° 193 × 10° 31 × 10° 31 × 10° 32 × 10° 206 × 10° 43 × 10° 206 × 10° 57 × 10° 57 × 10° 210
	<5 min	N/A		N/A	N/A	N/A N/A	N/A N/A	N/A N/A N/A	24 hours 8 hours N/A N/A	3 days 24 hours 8 hours N/A N/A N/A	3 days 24 hours 8 hours N/A N/A	3 hours 3 days 24 hours 8 hours N/A N/A	≤3 hours 3 hours 3 days 24 hours 8 hours N/A N/A	24 hours  3 hours  3 days  3 days  24 hours  N/A  N/A  N/A	24 hours 24 hours 3 hours 3 days 24 hours 8 hours N/A N/A	1 hour 24 hours 24 hours ≤3 hours 3 hours 3 days 3 days 14 hours 8 hours 8 hours 8 hours	8 hours  1 hour  24 hours  24 hours  3 hours  3 days  3 days  3 days  N/A  N/A  N/A	1-2 hours 8 hours 1 hour 24 hours 24 hours 3 hours 3 days 3 days 4 hours 8 hours 8 hours N/A N/A
1 year	1 year	1 year	9	1 year refrigerated	1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year refrigerated 1 year	1 year 1 year refrigerated 1 year refrigerated 1 year refrigerated	1 year 1 year 1 year 1 year refrigerated 1 year refrigerated 1 year refrigerated	1 year 1 year 1 year 1 year 1 year refrigerated 1 year refrigerated 1 year	1 year 1 year 1 year 1 year 1 year 1 year refrigerated 1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year	6 months  1 year  refrigerated  1 year  refrigerated  1 year	1 year refrigerated 1 year refrigerated 1 year	1 year 1 year 6 months 1 year refrigerated 1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year	1 year refrigerated 1 year refrigerated 1 year

N/A - not available/applicable

# at: techserv@epotek.com. Please consult our Application Experts to find the most suitable adhesives for specific technical challenges



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