

## 330-GLUE4

### Description

330-GLUE-4 is a magnesium oxide based 2-component bond. It is ideal for connecting ceramic to metal, for heaters and for insulation purposes. The material is (after the curing procedure) suitable for UHV applications.

The bond cannot be used for creating leak-tight seals.

<i>Property</i>	<i>Value</i>
Pot Life	>1h
Colour	beige
Usable temperature	up to 1500°C
Expansion coefficient	12,6 10 <sup>-6</sup> /K
Resistivity	10 <sup>9</sup> Ohm/cm@RT, 10 <sup>5</sup> Ohm/cm@540°C
Tensile Shear Strength	up to 29Nm
Mixing Ratio	1,5:1 (powder : liquid)
Curing temperatures	20°C 4h / 100°C 3h minimal
Storage	5 - 30°C
Lifetime of unmixed glue	6 months

To receive high bonding strength, the surfaces must be free of grease, metals are ideally etched or treated with grinding paper grit size 400.

During the curing process, the solvent is completely removed. The curing has to be done in a fume hood.

### Application:

- The process has to be done in a fume hood
- Mix powder with liquid 1.5 : 1 by weight
- Apply the bond
- keep parts at room temperature for at least 4 hours
- heat up parts to 100°C for at least 3 hours

After this process, the item is solvent free and can now be used in UHV environment and as well in air up to 1500°C