

## 330-GLUE2

### Description

330 GLUE2 is a 2-component glue used for vacuum applications. It offers:

- temperature resistance up to 250°C
- media resistance against many solvents

The glue is solvent-free and hot-curing, and its medium viscosity allows for good cohesion on high performance thermoplastics. 330-GLUE2 can also be used like a varnish to protect in-vacuum surfaces. As the glue becomes brittle after curing, it is not suitable for moving surfaces.

### Specifications

Colour	A: white opaque, B: yellow
Viscosity (23°C)	Medium, brushable
Pot Life (23°C, 10g)	6h
Mix Ratio A:B	2g:1g
Peak Temp at Curing	130°C
Storage Temp	2-15°C (do not freeze)
Shelf Life	6 months after manufacture

### Application

#### Preparing the surfaces

First, surfaces must be cleaned of any residual fats. Preparation should be planned to suit the materials being used. With plastics we suggest using ethylacetat. The glue works best on rough surfaces.

#### Preparing the mix

Mix components A and B together in a 2:1 ratio according to their weight. The mixed glue has a pot life of 6 hours at 23°C.

#### Applying the glue

The glue should be applied on both sides of the surfaces, which must then be pressed together.

#### Cleaning the tools

Uncured glue can be easily removed with solvents such as acetone, ethylacetat or methyl ethyl ketone. Please read the safety notes before using these solvents.

#### Curing

Curing is best done in a two step process, at 80°C for 1 hour and 130°C for 2 hours. Time spent at each temperature depends on the thermal conductivity of the joined surfaces, and can be flexible. Minimum curing time is 20 minutes for each step. Alternatively, the glue can also be cured at 150°C for 30 minutes.