

# Technical Data Sheet

## DB-1522



### Two Component Conductive Epoxy Adhesive

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**DESCRIPTION** **DB-1522** is a two component conductive epoxy adhesive designed for dot dispensing or stencil printing. The main uses of **DB-1522** are as an attachment adhesive on membrane switches, RFID antennas, and copper flex circuits. **DB-1522** adheres to a wide spectrum of substrates including polyester, paper, gold, and Kapton films. **DB-1522** uses unique solvents to give printers very long screen residence or syringe time for consistent deposit.

- ADVANTAGES**
- ✓ Excellent adhesion
  - ✓ Superior flexibility
  - ✓ Extended screen residence times
  - ✓ No dilution required
  - ✓ Good printability
  - ✓ Easy to use blending ratio

**TYPICAL UNCURED PROPERTIES**

Color	Silver
Viscosity	50,000 cp (CPE#51 @ 5.0 rpm)
Density	21.4 lbs/gallon
Flash Point	208°F (98°C) Tag Close Cup
Pot life (Mixed)	> 24 Hours

**TYPICAL CURED PROPERTIES**

Volume Resistivity	<1.0 x 10 <sup>-3</sup> ohm·cm
Glass Transition, DSC	35°C

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**APPLICATION  
INFORMATION**

- **DB-1522 is a two-component system.**
- **DB-1522 A must be mixed with DB-1522 B. The Mix ratio is 100:2 by Weight.**
- Stainless steel stencil or stainless steel screen can be used to deposit accurate thickness.
- Complete cure can be confirmed when additional curing does not decrease the electrical resistance.
- Typically, it is not possible to over-cure **DB-1522**. Added curing will improve the flexibility and conductivity properties.
- **DB-1522** can also be cured with infrared energy. This method often provides improved properties over conventional heat curing.

**CURE  
SCHEDULE**

Typical forced curing is for 10 minutes at 150°C. This will initiate the cross-linking. Additional curing will accelerate the cross linking and reduce the electrical resistance. Other cure schedules can also be used.

**CLEAN UP**

Uncured **DB-1522** can be cleaned up with M.E.K (Methyl Ethyl Ketone) or similar solvents. Screens and printing tools should be allowed to dry completely before reuse. To avoid possible squeegee swelling, a solvent resistant material such as polyurethane should be used. Typically a high durometer squeegee will provide the best results.

**STORAGE AND  
HANDLING**

- Shelf life is six (6) months in an unopened container, stored below 70°F.
- Store product below 70°F for maximum shelf life and minimal solvent loss. Avoid high temperature exposure.
- DB-1522-B may crystallize at lower temperatures. Exposure to low heat will return it to original.

**HEALTH AND  
SAFETY**

- Use with adequate ventilation.
- Avoid skin contact.
- If ingested, consult a physician immediately.
- Consult the product Material Safety Data Sheet for additional information.