

# LOCTITE ABLESTIK 789-6M

June 2020

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK 789-6M provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Cream
<b>Cure</b>	Heat cure
<b>Application</b>	Electronic Material, Component assembly
<b>Operating Temperature Range</b>	-60 to 150°C

LOCTITE ABLESTIK 789-6M die attach adhesive is designed for microelectronic applications.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, Brookfield CP52, 25 °C, mPa·s (cP):

Speed 10 rpm	45,700
Thixotropic Index (1/10 rpm)	1.9
Specific Gravity	1,200
Shelf Life:	
@ 5°C, days	360
@ 25°C, days	180

**TYPICAL CURING PERFORMANCE****Cure Schedule**

60 minutes @ 125°C

**Alternate Cure Schedule**

30 minutes @ 150°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties**

Hardness, Shore D	75
Glass Transition Temperature (T <sub>g</sub> ) by DSC, °C	113

**TYPICAL PERFORMANCE OF CURED MATERIAL****Miscellaneous**

Lap Shear Strength, Al to Al :

Cured 60 minutes @ 125°C	N/mm <sup>2</sup>	18
	(psi)	(2,600)
Cured 30 minutes @ 150°C	N/mm <sup>2</sup>	19
	(psi)	(2,850)

**GENERAL INFORMATION**

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

**THAWING:**

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
4. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.

**DIRECTIONS FOR USE**

1. Thawed material should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Apply adhesive as required.
4. Assemble bonds.
5. Cure at one of the recommended cure schedules.
6. Adhesive must be completely used within the product's recommended work life.

**AVAILABILITY**

This adhesive is available in a variety of package sizes, ranging from 1 cc to 1pound.

**Not for product specifications**

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

**STORAGE:**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage : 25 °C or 5°C**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb/F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{psi} \times 145 = \text{N/mm}^2$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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