

LOCTITE® ECCOBOND DP 1025

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PRODUCT DESCRIPTION

LOCTITE® ECCOBOND DP 1025 provides the following product characteristics:

Technology	Epoxy
Appearance	Light yellow
Cure	Heat cure and Room temperature cure
Product Benefits	<ul style="list-style-type: none">• One component• Non-conductive• Good adhesion• Fast cure
Application	Electronic Adhesives & Solder and Digital Print Assembly
Typical Package Application(s)	Digital printing applications

LOCTITE® ECCOBOND DP 1025 epoxy adhesive is designed for applications requiring outstanding thermal shock properties. LOCTITE® ECCOBOND DP 1025 adhesive may be used to bond semi-porous materials such as ferrites, where a physical rather than a chemical bond is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield CPA-51Z, 25 °C, mPa·s (cP):	
@ Speed 5 rpm	23,000
Thixotropic Index @ 25°C, (0.5/5 rpm)	5.3
Specific Gravity	1.14
Shelf Life @ -40°C, days	365

TYPICAL CURING PERFORMANCE**Cure Schedule**

2 hours @ 65°C

Alternate Cure Schedule

48 hours @ 25°C

The above cure profile(s) are guideline recommendation(s). These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

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

Glass Transition Temperature (Tg), Tan δ, °C	64
Hardness, Shore D	86
Modulus @ 25°C	N/mm ² 3,500 (psi) (508,000)

Adhesion Properties:

Lap Shear Strength @ 25°C:	
Al to Al	N/mm ² 19.4 (psi) (2,820)

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

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 25°C, the adhesive should not be re-frozen.

Directions for Use

1. Thawed adhesive 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 contaminations and/or air into the adhesive.
3. Adhesive must be completely used within the products recommended work life.
4. Alternate dispense amounts may be used depending on the application requirements.
5. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.

Storage

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

Optimal Storage : -40 °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 Henkel Representative.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local Henkel representative for assistance and recommendations on the specifications of this product.

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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