

LOCTITE[®] ECCOBOND DP 1024

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PRODUCT DESCRIPTION

LOCTITE[®] ECCOBOND DP 1024 provides the following product characteristics:

Technology	Epoxy
Appearance	Beige paste
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • One component • Sag resistant • Fast and low temperature cure • Long work life • Excellent chemical resistance • Non-conductive • Dispensable
Application	Electronic Material and Digital print head assembly
Key Substrates	Silicon, Copper, Gold, Polyimide, Polyphenylene oxide, Polybutylene terephthalate (PBT), Polysulfone

LOCTITE[®] ECCOBOND DP 1024 is a one part, heat curable epoxy adhesive designed for digital printing applications. This material does not contain cyclosiloxanes for minimized outgassing during cure.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP):	
Speed 2.5 rpm	80,000
Thixotropic Index (0.5/5 rpm)	2.3
Specific Gravity, g/ml	1.2
Work Life @ 25°C, hours	48
Shelf Life @ -30 to -18°C, days	120

TYPICAL CURING PERFORMANCE

Recommended Cure Schedule

3 minutes @ 120°C

The above cure profile are guideline recommendations. 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 :

Hardness, Shore D	≥60
Modulus, Tension Mode @ 25°C	N/mm ² 1,000 (psi) (145,000)

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 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 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.

Storage

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

Optimal Storage: -30 to -18°C. Storage below -30°C or above -18°C can adversely affect product properties.

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 quality department for assistance and recommendations on specifications for 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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