

GL 614-4 Electronics Epoxy

Description

GL 614-4 is a one-part off white adhesive based on epoxy resins. It cures fast at elevated temperatures and has excellent adhesion to most pc boards and electronic components. It can be cured at 150°C or higher. It has no sagging. It has a stable pot life and long shelf life at room temperature of 25°C. It has been designed especially for bonding electronic components. It has high thixotropic which can control the flow of the adhesive.

Applications

1. Epoxy adhesive for attaching to ceramic, metals, and most plastics in electronics.

Guidelines for Use

1. Dispense the epoxy by using a syringe.
2. Wipe off any excess uncured adhesive with a piece of dry cloth or tissue. Further cleaning may be achieved with tissue dabbed with isopropanol.alcohol (IPA).
3. Cure the epoxy by heating at 150°C for 15 minutes in a convection oven.

Properties

Property	Test Method	Unit	Typical Value
Chemical type			Epoxy
Appearance	Pen 10		Off white paste
Mix ratio, by weight			One component
Shelf life, -20°C	Pen 26	Month	6
Pot life, 25°C	Pen 26	Week	1
Viscosity, CAP 2000+ viscometer, 25°C Cap-06@100rpm	Pen 44	cps	42,000
Thixotropic Index	Pen 37		2.4
Hardness, cured 150°C for 15 min	Pen 29	Shore D	83
Shear Strength	Pen 36	kgcm ⁻²	55
Tg, DSC, cured 150°C for 15 min	Pen 19	°C	121
Specific gravity	Pen 14		1.3
CTE, alpha-1	Pen 64	ppm/°C	59
, alpha-2	Pen 64	ppm/°C	151
Ionic Content, Cl	-	ppm	< 50
, K	-	ppm	< 50
, Na	-	ppm	< 20

Recommended Cure

T(°C)	Gel time	Cure time
150	5 min	15 min
160	2 min	5 min

Storage

Tightly close original container of unused product. Store below -20°C. Storing at lower temperatures down to -40°C may prolong shelf life beyond 6 months. However it may take longer time to thaw the product.

Packaging

- 5 ml EFD syringe
- 10 ml EFD syringe
- 30 ml EFD syringe

Environment, Health & Safety

This product is RoHS compliant. It does not contain any known carcinogenic, mutagenic or teratogenic components.

Contact Information

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