

# DA 620

## Die Attach Epoxy

### Description

DA 620 is a translucent liquid epoxy system suitable for die attach of high performance optoelectronic components like indicator lamps. This is a one part heat curable system. It is recommended for bonding of electronic parts, most plastics, ceramics and metals. It has been designed for excellent performances in temperature cycling, high temperature storage, humidity storage, light output degradation, and outdoor weathering performances and superior UV resistance.

### Properties

Properties	Test Method	Unit	Typical Value
Chemical type			Epoxy
Appearance	Pen 10		Translucent liquid
Mix ratio, by weight			One component
Shelf life, -20°C	Pen 26	Month	6
Pot life, 25 °C	Pen 57	Day	2
Viscosity, Brookfield RVT, 25°C	Pen 11	cps	7500
Thixotropic Index	Pen 37		3.2
Adhesion strength	Pen 116	kgf	10
Hardness, cured 150°C/1hour	Pen 29	Shore D	90

### Applications

1. Epoxy adhesive for electronic die attach applications
2. Die Attach for high performance LED indicators / applications

### Guidelines for Use

1. Thaw the epoxy to room temperature (25°C) before use.
2. Dispense the epoxy by using a syringe.
3. 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).
4. Cure the epoxy by heating at 150°C for 1 hour.

### Recommended Cure

T(°C)	Gel time	Cure time
120°C	13 min	2 hr
150°C	2 min	1 hr

### 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
- 10ml 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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