

DESCRIPTION

The PERMACOL 2040-series are thermosetting single component adhesives especially developed for SMT purposes. These epoxy-based, solvent free smooth thixotropic adhesives are optimised for (jet) dispensing and screen printing applications.

BENEFITS

- Excellent adhesion and thermal resistance
- High green strength / non-sagging
- Fast cure
- RoHS and REACH compliant
- Halogen free

Type	Viscosity (D=30/s 23°C)	Green strength	Volume resistivity	Surface resistivity	Colour	Application
2040J	25 Pa·s	400 Pa	$>1 \cdot 10^{11} \Omega \cdot \text{cm}$	$>1 \cdot 10^{12} \Omega / \text{m}^2$	Red	Jet dispensing
2040D	45 Pa·s	900 Pa	$>1 \cdot 10^{11} \Omega \cdot \text{cm}$	$>1 \cdot 10^{12} \Omega / \text{m}^2$	Red	High speed dispensing
2040S/20	60 Pa·s	1300 Pa	$>1 \cdot 10^{11} \Omega \cdot \text{cm}$	$>1 \cdot 10^{12} \Omega / \text{m}^2$	Red	Stencil printing / high viscosity dispensing
2040S/40	100 Pa·s	1900 Pa	$>1 \cdot 10^{11} \Omega \cdot \text{cm}$	$>1 \cdot 10^{12} \Omega / \text{m}^2$	Red	Stencil printing

STORAGE

Store in its original packaging between 5°C to 10°C. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 9 months.

Curing recommendations

The standard curing conditions are 3 minutes @ 125°C or 2 minutes @ 150°C. In practice the oven time might need to be longer to allow the PCB to heat up.

Do not return used glue in the packaging to avoid contamination.

CLEANING

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

Cured adhesives must be removed mechanically. We advise to heat up the adhesive bond over 100°C. At this temperature, the adhesive dot will become softer and the component can easily be removed using torsion.

PACKAGING

The PERMACOL 2040-series can be supplied in all dispenser-specific syringes, tins, pots, and eurosyringes.

EN – Legal Disclaimer

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