

Technical Datasheet

Elecolit® 3065



Product Description

Modified epoxy | 1 K | solvent-free | UV / Visible light curing | secondary heat cure | anisotropically conductive

- ▶ Bonding of flexible conductors
- ▶ LCD display contacting
- ▶ High flexibility
- ▶ Good adhesion to PET, Kapton and Mylar

Curing Properties

During the curing process, the pressure (1.2 - 1.7 N / mm²) must be applied with a stamp made of glass. For sufficient contact, an adhesive gap thickness of approx. 8 µm should be aimed for.

UV-A	LED 365nm	LED 405nm	Secondary heat cure
✓	✓	✓	✓

✓ suitable – not suitable

If applicable, heat may only be used as a secondary cure for shadowed areas after the product has been cured with UV.

UV-curing (Hoenle Discharge lamp, 320-390nm)

Intensity [mW/cm ²]*	Layer thickness [mm]	Time [sec]
70	0.01	10

*measured by Hoenle UV-Meter 3.0 / UV-A F0

LED-curing (Hoenle LED Spot 100, 365nm)

Intensity [mW/cm ² **]	Layer thickness [mm]	Time [sec]
300	0.01	3

LED-curing (Hoenle LED Spot 100, 405nm)

Intensity [mW/cm ² **]	Layer thickness [mm]	Time [sec]
500	0.01	3

**measured by Hoenle UV-Meter 3.0 / LED F2

Secondary heat cure	[min]
Time at 100°C	10

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed depends on the wavelength spectrum of the light source, the intensity of light, the distance to the light source, the component geometry and the amount of adhesive. The final strength is reached after 12 hours.

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Resin	Acrylate
Appearance	Transparent, brown
Filler	Gold coated particles
Filler - weight [%]	3
Particle size Ø [µm]	10

Uncured Material

Viscosity [mPas] (Kinexus Rheometer, 25 °C, 10s ⁻¹) <i>PE-Norm 064</i>	25,000 – 45,000
Thixotropic index [1/10] <i>PE-Norm 064</i>	4 – 6
Density [g/cm ³] <i>PE-Norm 004</i>	1.0 – 1.2
Flash point [°C] <i>PE-Norm 050</i>	>100

Cured Material

Hardness shore D <i>PE-Norm 006</i>	20 – 40
Temperature resistance [°C]	-40 – 120
Shrinkage [%] <i>PE-Norm 031</i>	<3
Water absorption [%] <i>PE-Norm 016</i>	<1

Glass transition temperature - DSC [°C] <i>PE-Norm 009</i>	30 – 40
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	<40
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	300 – 500

Volume resistivity [Ohm*cm] <i>PE-Norm 040</i>	1
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Young's modulus – Tensile test [MPa] <i>500mW/cm², 60sec, 405nm LED</i> <i>PE-Norm 056</i>	5 – 15
Tensile strength [MPa] <i>500mW/cm², 60sec, 405nm LED</i> <i>PE-Norm 014</i>	<2
Elongation at break [%] <i>500mW/cm², 60sec, 405nm LED</i> <i>PE-Norm 014</i>	240 – 340

Transport/Storage/Shelf Life

Package type	Transport	Storage	Shelf life*
Syringe/Cartridge	At room temperature max. 25°C	0°C – 10°C	At delivery min. 6 months max. 12 months
Other packages			

***Store in original, unopened containers!**

Instructions for use

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP[®] from Panacol, or a solution of Isopropyl Alcohol at 90% or higher concentration. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on the packaging, our adhesives may be dispensed by hand directly from the package, or they can be applied using dispensing systems and automation. Many commercially available valve and controller options are available to ensure accurate and consistent adhesive dispensing. For assistance with dispensing and curing questions, please contact our Applications Engineering department. Adhesive and substrate should not be cold for proper bonding. They must be allowed to warm to room temperature prior to processing. After curing, the adhesive must be allowed to cool to ambient temperature before testing the product's performance. For safety information refer to our Material Safety Data Sheet (MSDS).

Storage

Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Panacol cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

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Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

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