



EA6402M Data Sheet

UV & Thermal Adhesive

Product Description

EA6402M is one-component, UV & Thermal curing adhesive. This material features fast curing at 80°C, low shrinkage, high adhesive strength, and adhesion to a variety of substrates.

Features & Benefits

- One component; no mixing required
- Fast cure at 80°C or 3000mj ultraviolet light
- Use for CCD/CMOS adhesion
- Dual curing process

Cure Schedule

UV cure schedule: 3200mj +

Thermal cure schedule:

30 minutes at 80°C

EA6402M will cure faster with temperature increasing. The curing temperature and curing time should be adjusted according to the heating device and the material to be bonded.

Please contact an HB Fuller representative for additional curing recommendations and process parameters.

Typical Uncured Properties	
Property	Value
Chemistry	Epoxy
Color	Black
Viscosity at 25°C (cPs)	45,800
TI Value	3.1
Work life at 25°C / <60% RH	3 Days

Typical Physical Properties of Cured Material (material cured 30 minutes at 80°C)	
Property	Value
Shear Strength (MPa)	14
Glass transition, Tg (°C)	33
Coefficient of thermal expansion (ppm/°C)	$\alpha 1 = 48$ $\alpha 2 = 178$

Typical Electrical Properties of Cured Material	
Property	Value
Dielectric Strength (kV/mm)	26.3
Dielectric Loss	
1KHZ	3.2/0.02
100KHZ	3.3/0.03
Volume resistivity (ohm-cm)	5.2×10^{15}
Surface resistivity (ohm)	1.9×10^{16}

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Directions for use:

1. Prior to bonding, substrate surface must be free of any dust, oils, or other contaminants.
2. Bring material to room temperature (25°C) before using (typical thaw time for 10ml syringes is 2-4 hours). We do not recommend thawing the material more than 3 times.
3. EA6402M is sensitive to humidity; do not expose the material to air for an extended period of time. The recommended relative humidity during dispensing is <60%.
4. If the material is left idle in the syringe tip for an extended period of time, the tip should be purged or solvent cleaned.
5. Seal any remaining material and store immediately at -18°C.

Clean-Up

Equipment and any spillage can be cleaned promptly after use with a mixture of anhydrous isopropyl alcohol and acetone that should be discarded after each use.

Storage and Handling

EA6402M should be stored at -18°C. Shelf life is a 6 months from date of manufacture, in original unopened containers.

Health & Safety Precautions

Please see the Material Safety Data Sheet (MSDS) for proper handling and disposal instructions.

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