



## EA6405

### UV + Thermal Liquid Adhesive

#### Material Description

EA6405 is a one-component adhesive that can be cured by UV irradiation followed by thermal cure. It has fast UV curing and low-temperature heat curing with outstanding bond strength to PC substrates.

This material is designed for structural bonding and has superior adhesion to a wide range of substrates, including plastics and metals such as PC, PMMA, aluminum, stainless steel, and other polar substrates.

#### Features & Benefits

- One component; requires no mixing
- High thixo index for high aspect ratio dispensing
- Fast curing by UV irradiation
- Low-temperature thermal cure
- High Tg for high temp. reliability
- Excellent adhesion to plastics and metals
- Excellent thermal stability

#### Recommended Cure

UV cure: 2 to 5 sec at 200 - 400 mW/cm<sup>2</sup> (365 nm)

Thermal cure: 60 °C for 3 hours

Please contact H.B. Fuller for additional cure profiles

#### Packaging Sizes

3cc, 5cc, 10cc and 30cc amber or black syringes

#### Health & Safety Precautions

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

Typical Uncured Properties	
Property	Value
Color	White/Beige (Black version available)
Chemistry	Acrylate
Consistency	Thixotropic Paste
Viscosity (cP, 25 °C, 2 s <sup>-1</sup> )	520,000
Viscosity (cP, 25 °C, 20 s <sup>-1</sup> )	48,000
Thixotropic Index (TI)	10.8
Dispense aspect ratio	0.9 – 1.0
Work Life @ 25°C	48 hrs

Typical Performance Properties		
Property	Method/ Condition	Value
Glass Transition Tg, °C	DMA	90
Alpha 1, ppm/°C Alpha 2, ppm/°C	TMA	41 124
Storage Modulus, GPa (25°C, 1 Hz)	DMA	3.2
Die Shear Strength, MPa (PC die on PBT substrate)	Room Temp.	10.2
Cure shrinkage (linear), %	TMA	0.5

#### Storage & Shelf Life

EA6405 should be sealed and stored in the original container at -40 °C.

Shelf life of material is 6 months from date of manufacture.

### Our Focus is Clear. Perfecting Adhesives.

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