FH8620

Epoxy Adhesive

Product Description

FH8620 is a one-component, low temperature curing epoxy adhesive. This material features fast cure at low temperature, low shrinkage, high adhesive strength, and adhesion to a variety of substrates.

Features & Benefits

- One component; no mixing required
- Fast cure at 80°C
- Low modulus to prevent warpage
- Non-conductive; non-corrosive
- Halogen free; REACH and Rohs compliant
- High and low temperature resistance

Cure Schedule

Cure schedule:

10-20 minutes at 80°C
20-30 minutes at 70°C

FH8620 will cure faster with increased temperature. 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.

Storage and Handling

FH8620 should be stored at -18°C.
Shelf life is a 6 months from date of manufacture, in original unopened containers.

Typical Uncured Properties	
Property	**Value**
Chemistry	Epoxy
Color	Black
Specific Gravity	1.30
Viscosity at 25°C (cPs)	35,000
TI Value	4.2
Work life at 25°C / <60% RH	14 Days

Typical Physical Properties of Cured Material (material cured 30 minutes at 80°C)	
Property	**Value**
Hardness, Shore D	80
Elongation at break (%)	1.8
Shear Strength (MPa)	14
Glass transition, Tg (°C)	33
Coefficient of thermal expansion (ppm/°C)	α 1 = 65 α 2 = 195
Water absorption after 24hrs at 25°C (%)	0.16

Typical Electrical Properties of Cured Material	
Property	**Value**
Dielectric Strength (kV/mm)	26.3
Dielectric Loss 1KHZ 100KHZ	 3.2/0.02 3.3/0.03
Volume resistivity (ohm-cm)	5.2×10^{15}
Surface resistivity (ohm)	2.0×10^{16}

Our Focus is Clear. **Perfecting Adhesives.**

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Directions for use:

1. Prior to bonding, surfaces must be free of any dust, oils, or other contaminants.
2. Bring material to room temperature (25°C) before using (typical thaw time for 30mL syringes is 2-4 hours). We do not recommend thawing the material more than 3 times.
3. FH8620 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.

Health & Safety Precautions

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

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