ALPHA® HT-130DL

DESCRIPTION

ALPHA HT-130DL is a one component, intermediate temperature, fast heat curable surface mount adhesive designed for use on high-speed dispenser and screen print applications. Typically, it shows excellent productivity with wave-soldering processes.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES AND BENEFITS

- One component
- Excellent thermal resistance
- Excellent adhesion
- Excellent workability
- Non-sagging

PRODUCT INFORMATION

Chemical Type:	Epoxy
Appearance:	Red paste
Curing Method:	Heat cure
Typical Applications:	Surface mount adhesive
Packing:	ALPHA HT-130DL product can be filled in various specified syringes based on customer's request.

TECHNICAL DATA

Category	Results
Typical Properties of Uncured Material	
Viscosity (Malcom PC-10A, 30rpm, @ 25 °C, Poise)	500 to 600
Thixotropic Index	≥4.0
Specific Gravity	1.0 to 1.4
Pot Life @ 25 °C, days	7
Shelf Life @ 1 to 10 °C, months	6

Recommended Cure Condition

120 seconds @120 °C (Convection oven)

80 seconds @150 °C (Convection oven)

Optimal cure conditions will depend on curing equipment.

Cure conditions may be dissimilar based on customers working process and application requirements.

Use recommended cure condition as general guideline. Other cure conditions may yield satisfactory results.

Category	Results
Physical Properties of Cured Material	
Hardness (Shore D)	80 to 90
Glass Transition Temperature (Tg), DSC	≥80
Coefficient of Thermal Expansion, TMA α_1, < Tg, ppm α_2, > Tg, ppm	 65(±10) 180(±20)
Corrosion 95 hours @ 40 °C, 95% RH	None
Moisture Absorption, wt% 24 hours @ water / 40 °C	≤1.0
Insulation Resistance 96 hours @ 40 °C, 95% RH	≥1 x 10^{12}

SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

STORAGE

Optimal Storage: 1 to 10 °C

Store in unopened container, refrigerate at 1 to 10 °C.

Storage greater than 10 °C can adversely affect product properties.

Pot life of material is valid when stored at suggested storage condition. Inappropriate storage may degrade the performance of the product during dispensing and final cured properties.

Transfer the product from ice pack to fridge with **NO** delays.

DO NOT open the cap before the product is sufficiently thawed.

Material must be thawed at room temperature for 2hours.

Product should not be refrigerated again, once thawed to room temperature.

DO NOT return product to original container.

CONTACT INFORMATION

www.macdermidalpha.com

North America 140 Centennial Avenue Piscataway, NJ 08854 1.800.367.5460	**Europe** Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	**Asia** 8/F., Two Sky Parc 51 Hung To Road Kwun Tong, Kowloon, Hong Kong, SAR China 852.2500.5365

Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE . Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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