# ALPHA® HT-130DM

## DESCRIPTION

**ALPHA HT-130DM** 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-130DM 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) | 550 to 650 |
| 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**

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 | ≥100 |
| Coefficient of Thermal Expansion, TMA<br>$\alpha_1$, < Tg, ppm<br>$\alpha_2$, > Tg, ppm | <br>65(±10)<br>180(±20) |
| Corrosion<br>95hours @ 40 °C, 95% RH | None |
| Moisture Absorption, wt%<br>24 hours @ water / 25 °C | ≤1.0 |
| Insulation Resistance<br>95hours @ 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**


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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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