Preliminary

TECHNICAL BULLETIN

alpha ASSEMBLY SOLUTIONS

HT-1331S

PRODUCT DESCRIPTION

HT-1331S product provides following features:

Chemical Type	Epoxy
Appearance	Red paste
Key Features	One component Excellent thermal resistance Excellent adhesion Excellent workability None sagging
Curing Method	Heat cure
Typical Applications	Surface mount adhesive

HT-1331S is one component, intermediate temperature, fast heat curable surface mount adhesive designed for use on high-speed dispenser and screen print application. Typically it shows excellent productivity on wave-soldering process.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity (Malcom PC-1TL, 30rpm, @25℃, Poise)	900-1,200
Thixotropic Index	≥3.0
Specific Gravity	1.0-1.4
Pot Life @25℃, days	7
Shelf Life @1-10℃, months	6

RECOMMENDED CURE CONDITION

80seconds @150℃ (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.

PHYSICAL PROPERTIES OF CURED MATERIAL

Hardness (Shore D)	80-90
Glass Transition Temperature (Tg), DSC	≥110
Coefficient of Thermal Expansion, TMA	
α_1, < Tg, ppm	65(±10)
α_2, > Tg, ppm	180(±20)
Corrosion 95hours @ 40℃, 95%RH	None
Moisture Absorption, wt% 24hours @ water/25℃	≤1.0
Insulation Resistance 95hours @ 40℃, 95%RH	≥1 x 10^{12}

STORAGE

Optimal storage: **1-10℃**

Store in unopened container, freezer at below 1-10℃.

Storage greater than 10℃ 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 product from dry ice to freezer with **NO** delays.

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

Material must be thawed on room temperature for **2hours.**

DO NOT re-freeze. Product should not be re-frozen, once thawed from room temperature.

DO NOT return product to original container.

PACKING

HT-1331S product can be filled in various specified syringes due to customer's demand.

GENERAL INFORMATION

Always read Material Safety Data Sheet (MSDS) for safe handling product.

Technical information contained herein is intended as reference only. If additional information is required, please contact your local Sales or Technical Service Center.