

LOCTITE ECCOBOND 931-1T1N1

September 2014

PRODUCT DESCRIPTION

LOCTITE ECCOBOND 931-1T1N1 provides the following product characteristics:

Technology	Epoxy
Appearance	clear
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> Low viscosity
Application	Die attach
Key Substrates	Glass, Alumina, Ferrite, Aluminum and Steel

LOCTITE ECCOBOND 931-1T1N1 adhesive is designed for medium die attach applications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index (0.5/5 rpm)	2.8
Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):	
Speed 5 rpm	2,400
Work Life @ 25°C, hours	4
Shelf Life @ 5°C (from date of manufacture), days	365
Shelf Life (from date of manufacture):	
@ 5 °C, two-part kits, days	365
@ -40 °C, premixed, days	365

TYPICAL CURING PERFORMANCE

Cure Schedule

2 hours @ 100°C

Alternative Cure Schedule

2 hours @ 60°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Hardness, Shore D 88
cured 2 hours @ 60°C

Electrical Properties

Volume Resistivity, ohms-cm 2×10^{14}

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength, psi:

Substrate	@25°C
Al to Al	3000

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

THAWING:

1. Allow container to reach room temperature before use.
2. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
3. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.

DIRECTIONS FOR USE

1. Thawed adhesive should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Adhesive must be completely used within the products recommended work life.
4. For 2-part kits, the mixing ratio is:
Part A = 63.1%
Part B = 36.9%.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{psi} \times 145 = \text{N/mm}^2$
 $\text{MPa} = \text{N/mm}^2$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

Reference 0.3

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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