

## Product Description

Dycotec DM-ADH-I 100IS is a screen printable epoxy adhesive that is used for general printed electronics applications. The paste is also compatible with syringe application.

## Product Benefits

- Screen printable
- Long screen residence time > 8 hours
- Good adhesion (>8 Kg/cm<sup>2</sup>)
- Solvent free
- Use on substrates such as PET and glass

## Paste Preparation

DM-ADH-I 100IS is a single part adhesive system. Gently stir the paste before use to ensure the product is well mixed. Avoid rapid stirring to prevent air entrapment during the stirring process.

## Properties of Uncured Paste

Test	Properties
Viscosity after mixing (Pa.s) <i>(Lamy, cone and plate 50s<sup>-1</sup>, 20°C)</i>	4-10
Solids Content	100 %
Solvent	0%

## Paste Processing Conditions

The paste can be cured typically using a convection oven. Typical curing parameters used are pre-cure of the printed parts for 15 mins at 110°C. Assemble the pre-cured parts for final cure to create adhesion between the layers. Continue the curing at 120 for 30 mins followed by post curing at 140°C for 30 – 60 mins. Curing times may be optimised to achieve the desired adhesion depending on manufacturing process set-up.

Screen	325 mesh, SS, 13 µm emulsion
Squeegee hardness	80 Durometer Shore A
Squeegee print pressure	5 kg
Holding angle	45°
Blade Length	220 mm
Print gap	0.5 mm
Flood : Print speed	50 mm/s : 50 mm/s (1 print cycle)
Print-out thickness when cured	10 - 15 µm

## Properties of Cured Paste

Test	Typical Properties
Pull Strength (ASTMD4541-02)	>8 Kg/cm <sup>2</sup>
Pencil Hardness	6H

## Clean-Up

Equipment can be cleaned using isopropanol alcohol or acetone.

## Storage and shelf-life

Containers should be stored at room temperature (21°C) with lids tightly sealed. The paste shelf-life for an unopened container is 3 months from date of shipment. Avoid introduction of water into the paste. Dycotec Materials cannot assume responsibility for a paste that has not been stored in inappropriate conditions or where the pastes have been contaminated following use.

## Safety and Handling

For safe use of this product, please review relevant material safety and datasheet (MSDS).

For more information, please contact:

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All information reported in the datasheet is for experimental work undertaken in our laboratories and illustrates typical values only. Processing conditions may vary depending on customers' experience and their application requirements and manufacturing process equipment set-up.

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