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124-07HV

STENCIL-PRINTABLE B-STAGEABLE EPOXY LAMINATING ADHESIVE

DESCRIPTION: 124-07HV is a high viscosity, B-Stageable, one-part epoxy coating and laminating adhesive optimized for stencil printing and automated dispense. This system features excellent thermal stability, thermal cycle resistance and chemical resistance. Applications include lid attach, die bonding, and high-performance coatings. 124-07HV is a version of 124-07 optimized for higher viscosity application methods.

PROPERTIES:

Viscosity (cps):	275,000
Glass Transition Temp. (°C)	105
Lap Shear Strength (psi.)	2,100
Dielectric Strength (volts/mil)	425
Volume Resistivity (ohm-cm)	1 x 10 ¹⁶
Dielectric Constant (100Hz)	4.0
Useful Temperature Range (°C)	-55 to +230
Thermal Stability (°C)	Good to 325
Coefficient of Thermal Expansion (in/in/°C) Below Tg:	29.5 x 10 ⁻⁶
Above Tg:	13.5 x 10 ⁻⁵

SUGGESTED HANDLING AND CURING: 124-07HV is a one component system and is ready to use as received. Store frozen to maintain consistent flow properties. **Allow material to warm up to room temperature before opening container.** Prior to using mix container well. As a coating, cure for one (1) hour at 150°C, or 30 minutes at 175°C. 124-07HV can be thinned with small amounts of CMI 102-03 or 113-12 thinners if needed. For hermetic sealing applications a ramped cure is recommended.

STORAGE OF CONTAINERS: Shelf Life – up to 3 months at 25°C or 6 months at -10°C.

B-STAGE PROCEDURE: Apply adhesive to substrate. Next apply heat to advance the curing to the non-tacky stage (when cooled to room temperature). A temperature of 80 – 100°C for 5 -10 minutes is suggested (B-Stage time is thickness related). User is encouraged to experiment for optimum drying time at a given temperature. Store on release liner to prevent contamination.

STORAGE B-STAGED FILM: Shelf Life – up to 2 months @ 25°C or 6 months @ -10°C

BONDING PROCEDURE: To use, carefully align parts to be bonded, apply uniform pressure to maintain location. Cure for 30 minutes at 175°C, or 1 hour at 150°C. (Note cure times given are mass related. Timing should start after adhesive and substrates reach curing temperature.) For hermetic sealing applications a ramped cure is recommended.

SAFETY AND HANDLING: Use with adequate ventilation. Keep away from sparks and open flames. Avoid prolonged contact with skin and breathing of vapors. Wash with soap and water to remove from skin.

All technical information is based on data obtained by CMI personnel and is believed to be reliable. No warranty is either expressed or implied with respect to results or possible infringements on patents.

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