



**128-38**

**SCREEN-PRINTABLE, B-STAGEABLE, HERMETIC LID ATTACH**

**DESCRIPTION**

128-38 is a screen-printable, B-Stageable, one-part epoxy coating and laminating adhesive that maintains hermetic properties up to 170°C. This system features excellent thermal stability, thermal cycle resistance and chemical resistance. Applications include lid attach adhesives, printed circuit board fabrication, advanced material composites, sealing, and high-performance coatings.

**UNIQUE FEATURES**

- \* Hermetic properties
- \* B-Stageable
- \* Long Screen Life
- \* High Tg

**TYPICAL UNCURED PROPERTIES**

Property	Value	Units
Viscosity – Brookfield HAT Viscometer, 10 rpm @ 25°C	65,000	cps
Specific Gravity (water = 1)	1.34	g/cc
Theoretical Coverage @ 0.001” Thickness <sup>1</sup>	38	in <sup>2</sup>
Screen Life	> 6	hrs

<sup>1</sup> Dependent on screen mesh and material

**TYPICAL CURED PROPERTIES**

Property	Value	Units
Volume Resistivity	1 x 10 <sup>16</sup>	Ω - cm
Useful Temperature Range	-55 to 170	° C
Die Shear Strength, 2 mm x 2 mm Si die	35	Lb-f
Dielectric Constant (100Hz)	4.0	-
Hermetic Stability	Good to 170	°C
Glass Transition Temperature – Tg	285	°C

**B-STAGE PROCEDURE**

Apply adhesive to substrate. Next apply heat to advance the curing to the slightly tacky stage (when cooled to room temperature). A temperature of 65°C for 15 -30 minutes is required (B-Stage time is mass related). User is encouraged to experiment for optimum drying time at a given temperature. Store on release liner to prevent contamination.

## CURING GUIDELINES

128-38 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. For hermetic lid attach applications, B-stage the material for 30 minutes at 65°C and bond the parts applying uniform pressure. Then cure for 90 minutes at 80°C. As a coating, cure for one (1) hour at 150°C, or 30 minutes at 175°C. 128-38 can be thinned with small amounts of CMI# 113-12 thinner if needed.

<u>Temperature (°C)</u>	<u>Time (min.)</u>	These temperature and times are presented as a guide only. The end-user is encouraged to experiment to determine optimum curing schedule.
80	90	
150	60	
175	30	

<b>SHELF LIFE</b>		
<b>Storage Temperature</b>	<b>Containers</b>	<b>B-Staged Film</b>
25°C	4 days	2 days
-20°C	3 months	1 month

## HEALTH AND SAFETY

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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