

DELO DUALBOND® LT354

modified polycarbamin acid derivate | 1C | light-fixable / heat-curing

free of solvents | filled | light-fixable, low-temperature-curing

Special features of product

- compliant with RoHS Directive 2015/863/EU
- halogen-free according to IEC 61249-2-21

Function

- electronic adhesive

Typical area of use

- -40 - 130 °C
- fast component fixation

Curing

Suitable lamp types LED 365 nm, LED 400 nm

Recommended light fixation time

*intensity 55 - 60 mW/cm²
UVA* 1 - 5 s

Recommended curing time

*at +80 °C
in air convection oven* 30 min

*at +90 °C
in air convection oven* 20 min

*at +100 °C
in air convection oven* 10 min

Processing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 10 ml* 0.5 h

*when stored in cold conditions
in containers up to 50 ml* 1 h

*when stored in cold conditions
DELO FLEXCAP 10 ml* 1 h

*when stored in cold conditions
DELO FLEXCAP 30 ml* 2 h

Processing time

in standard climate +23 °C / 50 % r. h. 72 h

Storage life in unopened original container

at -18 °C 6 month(s)

Technical properties

Color in cured condition in 1 mm layer thickness gray

Transparency in cured condition in 1 mm layer thickness opaque

Filler particle type minerals

Filler particle size d95 = 21 µm

Parameters

Density 1.27 g/cm³
DELO Standard 13 | Liquid

Viscosity 145000 mPa·s
Liquid | Rheometer | Shear rate: 10 1/s | Gap: 100 µm

Thixotropy index 7.8
Liquid | Rheometer

Compression shear strength 42 MPa
*DELO Standard 5 | **Glass** | **Glass** | 100 °C | 45 min*

Compression shear strength 26 MPa
*DELO Standard 5 | **AI** | **AI** | 100 °C | 45 min*

Compression shear strength 36 MPa
*DELO Standard 5 | **FR4** | **FR4** | Pretreatment: Annealing | 100 °C | 45 min*

Compression shear strength 10 MPa
*DELO Standard 5 | **LCP E130i** | **LCP E130i** | 100 °C | 45 min*

Compression shear strength 41 MPa
*DELO Standard 5 | **PC** | **PC** | 100 °C | 45 min*

Tensile strength <i>Based on DIN EN ISO 527 100 °C 45 min</i>	15	MPa
Elongation at tear <i>Based on DIN EN ISO 527 100 °C 45 min</i>	20	%
Young's modulus <i>Based on DIN EN ISO 527 100 °C 45 min</i>	500	MPa
Shore hardness D <i>Based on DIN EN ISO 868 100 °C 45 min</i>	72	
Glass transition temperature <i>DMTA 100 °C 30 min</i>	50	°C
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: -20 °C - 15,08 °C 100 °C 45 min</i>	91	ppm/K
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 50 °C - 130 °C 100 °C 45 min</i>	195	ppm/K
Shrinkage <i>DELO Standard 13 100 °C 45 min</i>	2.4	vol. %
Water absorption <i>Based on DIN EN ISO 62 100 °C 45 min Type of storage: Temp. Duration: 72 h</i>	0.24	wt. %

Converting table

°F = (°C x 1.8) + 32	1 MPa = 145.04 psi
1 inch = 25.4 mm	1 GPa = 145.04 ksi
1 mil = 25.4 µm	1 cP = 1 mPa·s
1 oz = 28.3495 g	1 N = 0.225 lb

General curing and processing information

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. The heating time of the components must be added to the actual curing time. It depends on component size and oven type. The specified curing temperature must be reached directly at the adhesive. Increasing or decreasing the curing temperature and / or irradiation intensity and / or irradiation time shortens or prolongs the curing time and can lead to changed physical properties. Only a small part of the bonding should be light-fixed as the maximum build-up of adhesion is achieved by pure heat curing. The period of time between prefixation and heat curing should not exceed 1 h at room temperature (approx. +23 °C / 50 % r.h.). The adhesive shows postcuring behavior. After heat curing at low temperatures and a short curing time, a certain level of strength is already achieved. The adhesive postcures at room temperature and achieves a level

of strength corresponding to the curing temperature after approx. 24 hours.

Depending on the adhesive quantity used, exothermic reaction heat is generated which can lead to overheating. In this case, a lower curing temperature is to be selected.

All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer.

Prefixation is performed with light. Heat curing is mandatory.

Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this. It is the customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions. The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

Instructions for use

The instructions for use are available on www.DELO-adhesives.com.

We will be pleased to send them to you on demand.

Occupational health and safety

See material safety data sheet.

Specification

Nothing contained in this Technical Datasheet shall be interpreted as any express warranty or guarantee. This Technical Datasheet is for reference only and does not constitute a product specification. Please ask our responsible Sales Engineer for the applicable product specification which includes defined ranges. DELO is neither liable for any values and content of this Technical Datasheet nor for oral or written recommendations regarding the use, unless otherwise agreed in writing. This limitation of liability is not applicable for damages resulting from intent, gross negligence or culpable breach of cardinal obligations, nor shall it apply in case of death or personal injury or in case of liability under any applicable compulsory law.

CONTACT

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ADHESIVES

DISPENSING

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