

PRODUCT DESCRIPTION

ST1626 is a two component epoxy adhesive used for manufacturing and maintenance of electronic assemblies.

ST1626 is compliance with REACH and RoHS regulations. If you want a certificate, please contact us (info@abchimie.com).

FEATURES

- Two-component room temperature curing Epoxy adhesive
- Liquid product suitable for injection
- Unfilled product suitable for transparent assemblies
- Fast setting product adapted to reduce assembly time
- Excellent mechanical performances

APPLICATION

ST1626 is packaged in 50 ml cartridges and requires a manual or pneumatic gun.

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheet.

PREPARATION OF THE PCB

The item to be bonded must be free of all dirt, oil or other foreign matter. A clean, dry surface is a must.

CLEANING

To clean equipment or clean uncured ST1626, we recommend using SND or DNS solvent.

PROPERTIES

PHYSICAL PROPERTIES			
Composition	Resin (part A)	Hardener (part B)	MIX
Mix ratio by weight	100	100	
Mix ratio by volume at 25°C	100	100	
Color	Clear amber	Yellow	Yellow
Density at 25°C	1.16	1.14	
Viscosity at 25°C (Pa.s)	11-14	10-20	
Pot life on 100g at 23°C (min)			4 – 6
Open time on 7mm bead at 23°C (min)			5 -6

MECHANICAL PROPERTIES¹		
Property	Value	Method
Hardness (Shore D)	85	
Tensile strength (MPa)	54	ISO 527
Elongation at break (%)	3.5	ISO 527
Young modulus (MPa)	3400	ISO 527
Recommended use temperature (°C)	15 to 25	
Working temperature ² (°C)	-40 to 120	

(1) Cured 16 hours at 70 °C

(2) Working temperature is defined as the temperature at which product keeps 80% of its initial Lap Shear Strength after 1000 hours ageing at this temperature, value on Aluminium, measured at 23 °C.

Handling time (time needed to obtain Lap Shear Strength on Aluminium at 23 °C, of 1 MPa) is 12 minutes.

MECHANICAL PROPERTIES ON ASSEMBLIES¹		
	LAP SHEAR STRENGTH at 23°C (MPa)	
Aluminium 2017A (sandblasted)	<i>Initial</i>	17.5 AF
	<i>After wet cataplastm 7 days at 70°C / 100% RH</i>	14 AF
	<i>After 15 cycles D3²</i>	14 AF
Stainless Steel 304 (sandblasted)	<i>Initial</i>	20 AF
	<i>After wet cataplastm 7 days at 70°C / 100% RH</i>	17 AF
Electro-galvanized Steel (sandblasted)		17.5 AF
Electro-galvanized Steel (acetone wipe)		11.5 AF
ABS (sanded + Isopropanol)		3.5 SF
PC (sanded + Isopropanol)		4 SF
PVC (sanded + Isopropanol)		5 SF
PMMA (sanded + Isopropanol)		4 SF
PA6E (sanded + Isopropanol + Plastic Primer) ³		2 AF
GFR Polyester (Isopropanol wipe)		7 DF
GFR Epoxy (Isopropanol wipe)		13 AF

(1) Cured 16 hours at 70 °C

(2) Cycle D3 : 16 h at 40 °C/95 % RH + 3 h at -20 °C + 5 h at 70 °C/50 % ± 5 % RH

(3) Plastic sanded, Isopropanol wipe and coated with Plastic Primer 5069 from Sika Advanced Resins.

AF: Adhesive Failure, SF: Substrate Failure, DF: Delamination Failure, according to EN ISO 10365 Standard

FLOATING ROLLER PEEL STRENGTH at 23°C		
	Value	Method
Aluminium 2017A (sandblasted) kN/m	1.5	ISO 4578

PACKAGING:

ST1626

50mL Cartridge

Cleaner

Bulk 5 litres

Bulk 5 litres

REFERENCES

ST1626 / S50

SND 05 L

DNS 05 L

STORAGE AND SHELF LIFE:

Storage temperature: Between 15 °C and 25° C in a dry place and in original unopened containers.

Shelf life: 12 months after the date of manufacturing

All information is given in good faith but without warranty. Properties are given as a guide only and should not be taken as a specification. ABchimie cannot be held responsible for the performance of its products within any application determined by the customer, who must satisfy themselves as to the suitability of the product.