

LOCTITE ABLESTIK 965-1L

October 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 965-1L provides the following product characteristics:

Technology	Epoxy
Appearance	Silver
Cure	Heat cure
Product Benefits	- Electrically conductive - Stress absorbing - Low levels of contaminants - Void-free bondline with minimal bleed
Application	Die attach
pH	5.5
Filler Type	Silver

LOCTITE ABLESTIK 965-1L is designed for bonding large die integrated circuits with mismatched coefficients of thermal expansion. It is designed for high speed, automated assembly operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):

Speed 5 rpm	12,000
Thixotropic Index (0.5/5 rpm)	4.5
Work Life @ 25°C, hours	24
Shelf Life @ -40°C, days	365
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Recommended Curing Conditions

1 hour @ 150°C

Weight Loss on Cure

Weight Loss on Cure, % 4.2

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Coefficient of Thermal Expansion, TMA expansion:

Below Tg	50
Above Tg	190

Glass Transition Temperature, TMA penetration, °C 72

Extractable Ionic Content, ppm:

Chloride (Cl-)	≤15
Sodium (Na+)	≤10
Potassium (K+)	≤5

Tensile Modulus, DMTA :

@ -65 °C	N/mm ² 5,800 (psi) (840,000)
@ 25 °C	N/mm ² 4,800 (psi) (700,000)
@ 150 °C	N/mm ² 290 (psi) (42,000)
@ 250 °C	N/mm ² 300 (psi) (44,000)

Water Extract Conductivity, μmhos-cm 7

Thermal Conductivity, W/(m-K) 3.0

Electrical Properties

Volume Resistivity, ohms-cm ≤0.0005

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Die Shear Strength:

2 X 2 mm (80 x 80 mil) Si die on Ag/Cu LF, kg-f/die:

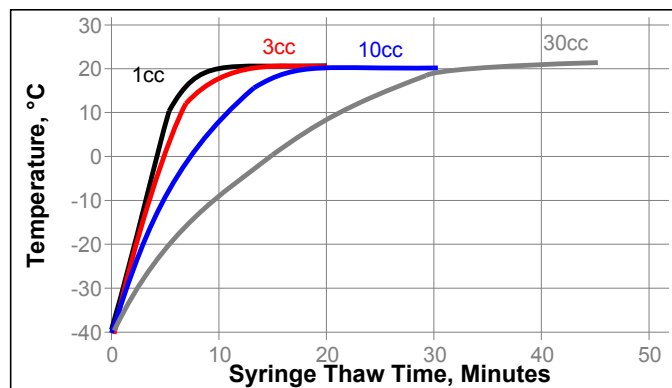
@ 25°C	10
@ 250°C	0.6
Lap Shear Strength	N/mm ² 10 (psi) (≥1,400)

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

THAWING:

- Allow container to reach room temperature before use.
- After removing from the freezer, set the syringes to stand vertically while thawing.
- DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
- DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.



DIRECTIONS FOR USE

1. Thawed adhesive should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Adhesive must be completely used within the product's recommended work life.
4. Apply enough adhesive to achieve a 25 to 50 µm wet bondline thickness, dispensed with approximately 25 to 50 % filletting on all sides of the die.
5. Alternate dispense amounts may be used depending on the application requirements.
6. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} = \text{N/mm}^2$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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