

LOCTITE ABLESTIK 6202C-X

January 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 6202C-X provides the following product characteristics:

Technology	Proprietary Hybrid Chemistry
Appearance	Yellow
Filler Type	Silica
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • Stencil printing • Low moisture uptake • Low flow (<150µm) • Low warpage • Long work life • Low modulus
Application	Die attach
Substrates	Laminate
Typical Package Application	Chip scale packages and Stencil printing

LOCTITE ABLESTIK 6202C-X B-stageable adhesive is ideal for laminate-based packages where tolerance and bleed need to be minimized. This low modulus adhesive is recommended for large die sizes.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index (0.5/5 rpm)	2.5
Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):	
Speed 5 rpm	30,000
Work Life @ 25°C, days	7
Storage Life @ -40°C (from date of manufacture), days	365
Print Open Time, hours	15
Flash Point - See SDS	

TYPICAL PROCESS DATA

Recommended B-Stage Condition

30 minute ramp from RT + 90 minutes @ 125°C + 30 minute ramp down to RT in vented magazine in oven with good air flow

Dwell Time after B-Stage

Without Predry, hours	8
With Predry, days	10

Pre-Dry Prior to Die Attach

4 to 10 minutes @ 90 to 95°C

(Based on substrate thickness and complexity. Needs to be optimized for each customer based on real-life data)

Recommended when there is a significant amount of time (i.e., 4 hours or more) between B-stage and die attach.

Chip Attach

Die Temperature, °C	150 to 175
Substrate Temperature, °C	30 to 70
Force, kg-f	6 to 12
Time, seconds	0.5 to 1.5

Post Die Attach Dwell

Prior to Cure, hours	24
----------------------	----

TYPICAL CURING PERFORMANCE

Cure Schedule

30 minutes ramp from 30 to 90°C, hold 60 minutes plus
30 minutes ramp to 175°C, hold 60 minutes in vented magazine in oven with good air flow

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, :	
Below Tg, ppm/°C	70
Above Tg, ppm/°C	232
Glass Transition Temperature (Tg) by TMA, °C	40
Tensile Modulus, DMTA :	
@ 25 °C	N/mm ² 894 (psi) (129,663)
@ 150 °C	N/mm ² 5 (psi) (725)
@ 250 °C	N/mm ² 6 (psi) (812)
Extractable Ionic Content, :	
Chloride (Cl-)	25
Sodium (Na+)	10
Potassium (K+)	10
Water Extract Conductivity, µmhos/cm	120
Moisture Absorption @ Saturation, wt.% @ 85°C/85%RH	1.03
Density before B-Stage, g/cc	1.1
Density after B-Stage, g/cc	1.15

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Shear Strength, 2 x 2 mm Si die on ceramic, kg-f:

@ 25°C	10
@ 245°C	1

GENERAL INFORMATION

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

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. 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.
4. DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.

DIRECTIONS FOR USE

1. Apply enough adhesive to the stencil to ensure complete filling of the stencil with a 15 to 20 mm diameter bead. Typically, this requires 20 to 50 cc of adhesive, depending on the stencil size. For two-direction printing, double beading is recommended.

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.

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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

Any liability in respect of the information in the Technical Data Sheet or

any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada, Inc. the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Conversions

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

Reference 2