

# Technical Datasheet

## Structalit® 3060 N



### Product Description

Panacol Structalit® adhesives are solvent free single or two-component adhesives. They are mostly based on epoxy resin and can be cured at room temperature or by exposure of heat. Structalit® products are designed for bonding, casting and protecting components in electronic and automotive industry.

Structalit® 3060 N is a one-component non-conductive die attach epoxy-based adhesive with high flexibility and very short curing times. No more than 0.4 g of adhesive may be cured at a time. Structalit® 3060 N has a high ionic purity of <10ppm.

### Curing Properties

The product is a one-component adhesive and cures under exposure to heat. Possible curing temperatures are listed in the table below.

| Thermal curing | [min] |
|----------------|-------|
| Time at 120°C  | 1,5   |
| Time at 150°C  | 0,75  |
| Time at 180°C  | 0,33  |

The curing times given are guidelines. The heating up of the joining members are not taken into account.

The final strength of the adhesive is reached at the earliest after 24 h.

### Technical Data

Resin epoxy  
Appearance transparent

#### Uncured material

|   |                 |
|---|-----------------|
| Viscosity [mPas]<br>(Brookfield LV, 25°C, Sp 4,6 rpm)<br><i>PE-Norm 001</i> | 42 000 - 46 500 |
| Flash point [°C]<br><i>PE-Norm 050</i>                                      | >100            |
| Refractive index [nD20]<br><i>PE-Norm 018</i>                               | 1,4825          |

#### Cured material

|  |           |
|--|-----------|
| Hardness shore D<br><i>PE-Norm 006</i> | 30 - 45   |
| Temperature resistance [°C]            | -40 - 180 |
| Shrinkage [%]<br><i>PE-Norm 031</i>    | <3        |

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|   |         |
|---|---------|
| Glass transition temperature DSC [°C]<br><i>PE-Norm 009</i>                         | 40 - 50 |
| Coefficient of thermal expansion [ppm/K] below T <sub>g</sub><br><i>PE-Norm 017</i> | 30      |
| Coefficient of thermal expansion [ppm/K] above T <sub>g</sub><br><i>PE-Norm 017</i> | 247     |

|  |     |
|--|-----|
| Young's modulus E [MPa]<br><i>PE-Norm 056</i>                | 105 |
| Elongation at break [%]<br><i>PE-Norm 014</i>                | 25  |
| Lap shear strength (steel/steel) [MPa]<br><i>PE-Norm 013</i> | 8   |
| Lap shear strength (Al/Al) [MPa]<br><i>PE-Norm 013</i>       | 5   |

### Transport/Storage/Shelf Life

| Trading unit   | Transport  | Storage    | Shelf-life*                                   |
|----------------|------------|------------|---|
| Cartridge      | 0°C - 10°C | 0°C - 10°C | at delivery min. 4,5 months;<br>max. 9 months |
| Other packages |            |            |   |

**\*Store in original, unopened containers!**

### Instructions for Use

#### Surface preparation

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

#### Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

For safety information refer to our safety data sheet.

### Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.**

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