

# Technical Datasheet

## Structalit® 5610



° Preliminary Datasheet. The technical statements are only guidelines and can be changed at any time.

### 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® 5610 is a thermal curable one-component SMD adhesive with extremely fast curing at low temperatures. Structalit® 5610 adhesive is characterized by good shock resistance. The application is easily possible with dispenser, screen printing or via needle transfer. Structalit® 5610 can be used as a SMD adhesive for soldering temperatures (max. 5 min.) up to 270 ° C. No more than 2 g of adhesive may be cured at a time.

### 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 150°C	1
Time at 120°C	3
Time at 110°C	5

The curing times given are guidelines. They refer to the curing of 2 g of adhesive. 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 red

#### Uncured material

Viscosity [mPas] (Kinexus Rheometer, 25 °C, 50s-1) <i>PE-Norm 064</i>	18 000 - 25 000
Viscosity [mPas] (Kinexus Rheometer, 25 °C, 5s-1) <i>PE-Norm 064</i>	37 000 - 43 000
Density [g/cm³] <i>PE-Norm 004</i>	1,19
Flash point [°C] <i>PE-Norm 050</i>	>93

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### Cured material

Hardness shore D <i>PE-Norm 006</i>	55 - 65
Temperature resistance [°C]	-40 - 180

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	50 - 70
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	35
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	280

Lap shear strength (FR4/FR4) [MPa] <i>PE-Norm 013</i>	11
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### Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	0°C - 10°C	0°C - 10°C	at delivery min. 3 months max. 6 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.

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### 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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