ASSEMBLY
MATERIALS

Product Type: SMT Adhesive
Product Name: PD 860002 SPA

Description
PD 860002 SPA is a thermosetting single component, solvent-free polymer adhesive, developed especially for the surface mounting of SMT components onto PCBs and for use on bare substrates. This adhesive is developed for dispensing application. In case of printing we recommend a closed head printing system, due to the sensitivity of the PD 860002 adhesives, against humidity.

Key Benefits
- High reliability by dispensing and printing
- Consistent batch-to-batch quality
- Specially developed for glass diodes

Applications
- Printing
- Dispensing

Physical Properties

<table>
<thead>
<tr>
<th>Processing</th>
<th>Curing Profile</th>
<th>Colour</th>
</tr>
</thead>
<tbody>
<tr>
<td>SPA version is made for small and medium sized components (up to SO28).</td>
<td>The standard curing conditions are 125°C / 3 minutes. Max curing temperature should not be higher than 200°C.</td>
<td>Red</td>
</tr>
</tbody>
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<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>Time (min)</th>
</tr>
</thead>
<tbody>
<tr>
<td>100</td>
<td>8</td>
</tr>
<tr>
<td>125</td>
<td>3</td>
</tr>
<tr>
<td>150</td>
<td>1.5</td>
</tr>
<tr>
<td>180</td>
<td>1</td>
</tr>
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Cleaning Instructions
Before curing: The adhesive can be removed with Zestron HC and other Zestron and Vigon cleaning materials. Do not use alcohol as this will cure the adhesive. Cleaned dispensing units should be completely dried before installation.
After Curing: Defective components can be replaced by heating (with hot air) the cured adhesive joint above 100°C. After removing the component (torsion movement), the hot air should be focused on the remaining adhesive in order to remove it with a sharp tool.

Adhesive Conditioning
- Remove adhesive from fridge: Before opening the package leave it for at least 2 hours at room temperature so that adhesive heats up
- Do not open cartridge while adhesive is cold to prevent condensation
- Before using adhesive cartridge: Before inserting nozzle, press small quantity of glue out of cartridge until homogeneous glue comes out – during storage of cartridges, low viscosity glue constituents may be found on the tip of the cartridge
Storage

- Store the SMT-adhesive in originally-sealed containers and avoid exposure to high humidity and sunlight
- Store cartridges with tip pointing downwards
- In cartridges: Min 6 months at 15 – 25°C