

# LOCTITE ABLESTIK CE 3104WXL

August 2012

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK CE 3104WXL provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Silver
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Electrically conductive</li> <li>• Stencil or screen printable</li> <li>• Pb-free alternative to solder</li> <li>• Controlled particle size</li> <li>• Low cure temperature</li> </ul>
<b>Filler Type</b>	Silver
<b>Filler Weight, %</b>	74
<b>Application</b>	Electrically Conductive Adhesive
<b>Surfaces</b>	Sn, Sn/Pb and OSP coated Cu
<b>Typical Package Application</b>	SMD component attach

LOCTITE ABLESTIK CE 3104WXL is an electrically conductive epoxy adhesive that is a Pb-free alternative to solder. This product uses a unique blend of fillers with tightly controlled particle sizes to provide ultra-fine pitch resolution (<500µm) when printed using either a stainless steel mesh screen or a metal mask stencil. The lower surface tension versus solder means no bridging on fine-pitch assembly patterns.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index	6.0
Viscosity at 25°C, mPa·s (cP) (Plate 2 cm at 15 s <sup>-1</sup> )	65,000
Work Life @ 25°C, days	3
Shelf Life @ -40°C, days	365
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

#### Reflow:

3 minutes @ 150°C or

5 minutes @ 125°C

#### Convection:

8 minutes @ 125°C or

5 minutes @ 150°C

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 PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength, MPa	9
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## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Bring LOCTITE ABLESTIK CE 3104WXL to room temperature before using

### 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 to -35°C. Storage below -40°C can adversely affect product properties (freeze-thaw voids).**

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

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

### 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

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