LORD® EX-5640 Adhesive

Technical Data Sheet

LORD® EX-5640 adhesive is a semi-thixotropic, two-component structural epoxy adhesive system used to bond various materials together for electronic applications.

Features and Benefits:

Controlled Flow – provides excellent wetting to most metal, plastic and ceramic substrate surfaces without dripping/ slumping off.

Application:

Mixing – Mix LORD EX-5640 A resin with LORD EX-5640 B hardener at a 4:1 ratio, by weight.

Applying – For high volume production, apply adhesive using automatic meter/mix/dispense equipment.

Curing – LORD EX-5640 adhesive will cure to full strength in 24 hours at 25°C.

Shelf Life/Storage:

Shelf life is one year when stored at 25°C in original, unopened container.

Typical Properties*

	EX-5640 A Resin	EX-5640 B Hardener	Mixed
Appearance	Off-white Liquid	Red Liquid	Red Liquid
Viscosity, cP @ 25°C	18,500 Spindle 7, 50 rpm	6250 Spindle 6, 50 rpm	–
Specific Gravity	1.1	1.08	–
Gel Time, minutes			
@ 25°C	–	–	20 - 45
@ 65°C	–	–	10

*Data is typical and not to be used for specification purposes.

Typical Cured Properties*	
Thermal Conductivity, W/m·K	0.21
Coefficient of Linear Thermal Expansion, ppm/°C by TMA	51
Hardness Shore D, 24 hours @ 25°C	85
Volume Resistivity, ohm-cm @ 25°C	1 x 10^{14}
Dielectric Strength, kV/mm (V/mil)	17.7 (450)
Dielectric Constant 100 kHz	4.2
Dissipation Factor 100 kHz	0.035
Arc Resistance, seconds	88

*Data is typical and not to be used for specification purposes.

Cautionary Information:

Before using this or any Parker LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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