

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.



ENGINEERING YOUR SUCCESS.

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.

Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

Information provided herein is based upon tests believed to be reliable. In as much as Parker LORD has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker LORD does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

©2020 Parker Hannifin - All Rights Reserved

Information and specifications subject to change without notice and without liability therefor. Trademarks used herein are the property of their respective owners.

OD DS3646 02/20 Rev.4



Parker LORD
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 ASK LORD (275 5673)

www.lord.com