

LOCTITE D 124F-1 RED

October 2014

PRODUCT DESCRIPTION

LOCTITE D 124F-1 RED provides the following product characteristics:

Technology	Epoxy
Appearance	Red paste
Product Benefits	<ul style="list-style-type: none">• One component• High dot profile• No stringing• Fast cure• Low temperature cure• Improved green strength• High thixotropy• Resistant to wave soldering• Fluorescent under black light
Cure	Heat cure
Application	Surface Mounted Devices
Typical Assembly Applications	Bonding high profile MELF and Flat chip components
Operating Temperature Range	-40 to 105°C

LOCTITE D 124F-1 RED epoxy is formulated for bonding surface mounted devices to printed circuit boards prior to wave soldering.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density , g/cm ³	1.2
Brookfield Viscosity # TD, mPa·s (cP):	
Speed 10 rpm	220,000
Thixotropic Index	3.8
Shelf Life @ 4°C, days	91
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Cure Schedule**

- 15 minutes @ 100°C or
- 5 minutes @ 120°C or
- 2.5 minutes @ 150°C

Infrared Heat Source**Recommended Ramp Rate:**

2 to 3 minutes @ 1°C per second from 25°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 PROPERTIES OF CURED MATERIAL

Dielectric Strength, kV/mm	14.8
Dielectric Constant @ 1mHz	3.0
Volume Resistivity @ 25°C, ohm-cm	1×10 ¹³

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength :	
Al to Al @ 25°C	N/mm ² 1,100 (psi) (7.6)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. LOCTITE D 124F-1 RED can be applied by dispensing or stenciled and pin transferred in equipment with squeegee assist

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 : 4 °C

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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa = N/mm²
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = 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 our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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