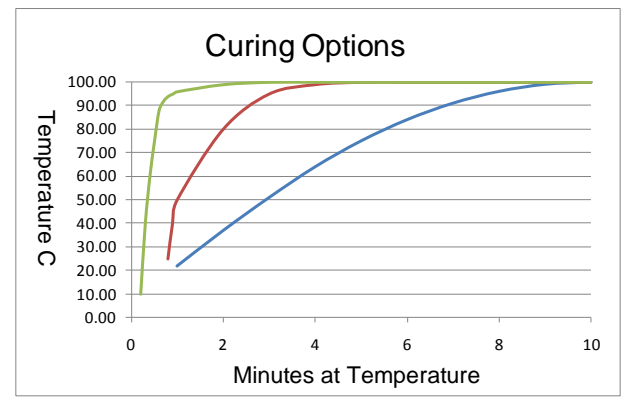


SMA D77 High-Speed Dispensing Adhesive

- Good dispensing Performance
- Low Susceptibility to Moisture Absorption
- Wide Process Window
- Exceptional Adhesion Properties
- Resistant to Internal Void Formation
- Proprietary filling means true void free packaging (No skips)
- Pb Free or Sn/Pb process compatible



TYPICAL CAPABILITIES AND INSTRUCTIONS FOR USE:

	Property	Recommendations/ Attributes	Units / Values	Reference Document/ Test Procedure
Physical	Pigment:	red	N/A	Green and Cured color is the same
	Density:	1.2 g/cc		Used for weighs in syringes, and Mass Flow Control Systems
	Homogeneity:	no particle > 150 microns	microns	Used to calculate min tip openings
	Characteristics	good visible color, filled in red color, syringes bubble-free	bubble-free	
	Glass transition temperature:	approximately 73°C shear rate D [s-1]		Used to set rework temperatures
	Viscosity	Yeild Point	about 500 LMS	Flows easially, but forms a high profile dot
Process	Cure	150oC for 30 minutes	IR or thermal	Standard cure Can stay in the dispenser for days
	Life at room temp	3 weeks	passed	
	Repairability	SMD replacement without damage	passed	Heat past Td and twist
	Cleanability	completely with solvent	cleanable	Avoid IPA Holds components and will accept components in a line down situation
	Tack time	min. 8 hours	passed	
	Dispensability	reproducible – without stringing	passed	Good, no or low stringing, tailing and smearing
Cleaning	Before curing: The uncured adhesive can be removed with Acetone or Zestron (HC or Vigon), Ensolv, The cleaned parts must be completely dry, before installing them on the machine.			
	After curing: Because of the known residual thermoplasticity of the cured adhesive, defective After removing the component the hot air should be focused on the remaining with a sharp tool.			

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www.dispensetips.com

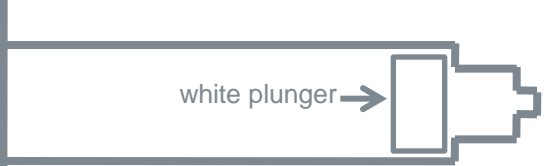
The descriptions and engineering data shown here are the best known data available. While we believe these to be accurate and correct, each user must test a verify the suitability for the applications. There is no guarantee or warranty stated or implied. The data is supplied on the condition that the user shall conduct tests to determine materials suitability for a particular application

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SMA D77 Adhesive
High-Speed Dispensing

• Syringe availability



Fits: Automelec; Camelot 1212, 1414, 1818 & 5000; Dynapert MPS 500 & 525; HEEB HM-60; Quad 4000 & Star; Siemens HS-180, MS-102, -132, -72 & -90, SP-120; Zevatech PPM 7



Fits: All Asymtek; Camelot 1414, 1818 & 5000; all Creative Automation, Dynapert MPS118, 2000, 2500 & 318; Icon; Philips PA 1433HSD; Sanyo TDM 41/61; TDK RX 4260; Universal 4713D & 4714 D



Fits: Fuji GL-I, -II & -V