

LOCTITE® ECCOBOND DFB 3328

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PRODUCT DESCRIPTION

LOCTITE® ECCOBOND DFB 3328 provides the following product characteristics:

Technology	Acrylate
Appearance	Light yellow liquid
Product benefits	• One component • Fast curing • Excellent moisture resistance • Highly flexible • Reworkable
Cure	Ultraviolet (UV) light, UV LED
Application	Coating Encapsulation
Typical package application	LCD or OLED module assembly Electrical components

LOCTITE® ECCOBOND DFB 3328 is a one component ultraviolet (UV) curable acrylate adhesive product. It is a fast UV curable material with excellent flexibility and excellent moisture resistance performance. It helps to eliminate cracking or delamination in bending and other function/RA testing.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Rheometer, Cone and Plate, 25°C, Angle 2°, 40mm, mPa.s (cP)

Shear rate 20s ⁻¹	878
Specific gravity	0.97
Shelf life @ 25°C, days	180

TYPICAL CURING PERFORMANCE

Recommended cure condition

Ultraviolet (UV) light, High pressure Hg

Light intensity, (UVA), mW/cm ²	400
Exposure time, seconds	2

LED Lamp

UV Wavelength, nm	365
Light intensity, mW/cm ²	1,000
Exposure time, seconds	2

Cure rate and depth depend on the intensity, spectral distribution of light source, exposure time and light transmittance of the substrate through which the light must pass.

The above cure profiles are guideline recommendations. These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Cured by LED 365nm, 2000mJ/cm²

Physical properties

Elongation at break, %	245
Storage modulus, @25°C by DMA, N/mm ²	306
Water vapor permeability coefficient (WVPC) @ 50°C/100% RH, gm-mil/100 in ² .day	14.4

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

Directions for use

1. This product is light sensitive; exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling.
2. Cure rate is dependent on lamp intensity, distance from light source, depth of cure needed or bondline gap and light transmittance of the substrate.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 18 to 28°C

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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 Henkel representative.

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 the specifications of this product.

Conversions

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

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