

# Thermoset 7195-125 Black Epoxy Adhesive

## Description

LORD Thermoset 7195-125 Black adhesive is a one-component epoxy adhesive designed for use in SMD component mounting where non-stringing is necessary.

## Features and Benefits

**Thermal Stability** – provides excellent thermal stability.

**Fast Cure** – rapidly cures at 121°C and 177°C.

**Non-Sag** – thixotropic rheology allows shape to be maintained after dispensing.

**Chemically Resistant** – provides excellent resistance to acids and strong bases.

## Application

**Applying** – Before use with dispensing equipment, allow adhesive to be warmed to room temperature (ideally 20-25°C). Allow adhesive to warm by placing syringe in a vertical (upright) position with dispense tip facing downward in an ambient environment. Consult handling instructions\*\* for specific guidelines.

Mount syringe onto the dispensing equipment that has been thoroughly cleaned and purge adhesive through the system until an unbroken flow of material is extruded.

**Curing** – Allow adhesive to cure for 30 minutes at 121°C, or for 10 minutes at 177°C. This time-at-temperature profile refers to the time the material should be allowed to cure once it reaches the target temperature. Allowance

\*\*Handling instructions are available on [LORD.com](http://LORD.com).

## Typical Properties\*

### Uncured

Appearance	Black Paste
Viscosity, cps @ 25°C	125,000
Specific Gravity	1.66
Gel Time, min	
@ 121°C	10
@ 177°C	1

### Cured

Volume Resistivity, ohm-cm @ 25°C	>1 x 10 <sup>15</sup>
Thermal Conductivity, W/mK	0.7
Coefficient of Linear Thermal Expansion, ppm/°C	45
Glass Transition Temperature (T <sub>g</sub> ), °C by TMA	140
Hardness @ 25°C Shore D	90
Lap Shear Strength, psi (AL-AL)	>1595
Dielectric Strength, V/mil @ 25°C	>500
Dielectric Constant @ 25°C 1 MHz	3.9
Dissipation Factor @ 25°C 1 MHz	0.01

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

# LORD TECHNICAL DATA

should be made for oven ramp rates, parts with large thermal mass and other circumstances that may delay material actually reaching the target temperature.

**Cleanup** – Disposable containers and utensils are recommended when working with epoxies. However, when disposable materials are impractical, uncured adhesive can be removed by cleaning equipment with common organic solvents such as isopropyl alcohol. Solvent-cleaned utensils should be thoroughly dried before reuse; any remaining solvent can contaminate the next mixture.

## Shelf Life/Storage

Shelf life is six months from date of manufacture when stored at 5°C in original, unopened container. Syringe must be maintained in vertical (upright) position with the dispense tip facing down. Do not store syringe on its side (horizontally).

If material is stored at 25°C, shelf life will be shortened to approximately two months.

## Cautionary Information

Before using this or any 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 technical data sheet 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.

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