

AC M60-6

Dual Curable, High Temperature Resistance Adhesive

Features

- High temperature resistance
- One-component resin
- Low shrinkage
- Low moisture permeability

Description

- Dual curable adhesive

APPLICATIONS

AC M60-6 was designed for applications where high adhesion to substrates is required.

TYPICAL PROPERTIES

Liquid

Viscosity (cps, 25 °C)	12,000-17,000
Storage (°C)	15 – 23
Shelf life (15-25 °C)	3 months
Pot life (15-25 °C)	1 month

Cured film

Water absorption (% , 100 °C until saturation) 0.30

Water permeability 6.0
(50 °C/95% RH, g/m² 24 hrs, ASTM E96-80)

Shrinkage (linear, %) <0.3

Hardness – Shore D 85

Glass transition temperature (°C) 107

Coefficient of thermal expansion (TMA), 75 µm film
below T_g (x10⁻⁶), °C⁻¹ 28
above T_g (x10⁻⁶), °C⁻¹ 129

Physical properties tested at 25°C, 50% RH (ASTM D638)

Elongation (%) 17
Modulus, psi (kgf/mm²) 170,000 (119)

UV curing conditions

Spot cure system – UV dose (J/cm²), air
250 – 450 nm filter 10 to 20

Flood cure system – UV dose (J/cm²), air 2 to 4

Heat curing conditions:

@ 150 °C 16 - 24 hrs (if thermal is the only curing method)
16 – 20 hrs (if both UV and thermal curing are used)

@ 180 °C 3-6 hr (if thermal is the only curing method)
2-5hrs (if both UV and thermal curing are used)

For achieve optimal adhesive properties the adhesive needs to be cured by heat OR thermal post cure after UV curing is required.

The cured film has a yellow to amber color

SAFETY AND HANDLING

The un-cured adhesive can be cleaned from apparatus with isopropyl alcohol (IPA), methyl ethyl ketone (MEK), or commercial alcohol based cleaning solution. Use caution in handling this material. Avoid direct skin and eye contact. Use only in well ventilated areas. Use protective clothing, **gloves and safety goggles**. Read [Material Safety Data Sheet](#) before handling.

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