

LOCTITE ABLESTIK 8515

October 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 8515 provides the following product characteristics:

Technology	Epoxy
Appearance	Yellow paste
Cure	Heat cure
Product Benefits	- Electrically insulating - Fast cure - Excellent dispense properties - Anti-delamination properties
Application	Die attach

LOCTITE ABLESTIK 8515 fast curing adhesive is designed for use in flip chip BGA applications. LOCTITE ABLESTIK 8515 is suitable for bonding bare die to flex and laminate based substrates. This material was originally released as RP-262-9.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index (0.5/5 rpm)	6.8
Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):	
Speed 5 rpm	11,500
Work Life @ 25°C, Viscosity increase by 25%, hours	24
Storage Life @ -40°C (from date of manufacture), 365 days	
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

15 minutes @ 150°C

Weight Loss on Cure

10 x 10 mm Si die on glass slide, % 0.8

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

Physical Properties

Coefficient of Thermal Expansion, TMA expansion mode:

Below Tg, ppm/°C	98
Above Tg, ppm/°C	150

Glass Transition Temperature, TMA penetration mode, °C 39

Thermal Conductivity @ 121°C, C-matic Conductance Tester, W/(m·K) 0.26

Moisture Absorption @ Saturation, wt.% @ 85°C/85%RH 0.6

Moisture Absorption @ Saturation, wt.%, Environmental chamber 1.6

Tensile Modulus, DMTA :

@ -65 °C	N/mm ² 2,300 (psi) (330,000)
@ 25 °C	N/mm ² 1,300 (psi) (190,000)
@ 150 °C	N/mm ² 43 (psi) (6,200)
@ 250 °C	N/mm ² 43 (psi) (6,200)

Weight Loss @ 300°C, TGA, % 0.35

Extractable Ionic Content, @ 100°C ppm:

Chloride (Cl-)	21
Sodium (Na+)	1
Potassium (K+)	0
Fluoride (F-)	9

Electrical Properties

Volume Resistivity, ohm-cm	1.6×10 ¹⁵
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TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous

Die Shear Strength

2 X 2 mm (80 x 80 mil) Si die on Ag/Cu LF, Kg:

@ 25°C	14
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3 X 3 mm (120 x 120 mil) Si die:

Post Cure:

On BGA, kg-f/die:

@ 25°C	25.6
@ 150°C	2.6
@ 200°C	2.1

After 30°C/60% RH Exposure for 168 hours:

On Solder mask, kg-f/die:

@ 25°C	20.6
@ 150°C	2.6
@ 200°C	2.4

Chip Warpage @ 25°C vs Chip Size

0.38 mm thick:

Si die on Ag/Cu LF, µm:

7.6 x 7.6 mm chip size	7.7
12.7 x 12.7 mm chip size	16

Si die on BGA, µm:

7.6 x 7.6 mm chip size	4
12.7 x 12.7 mm chip size	10

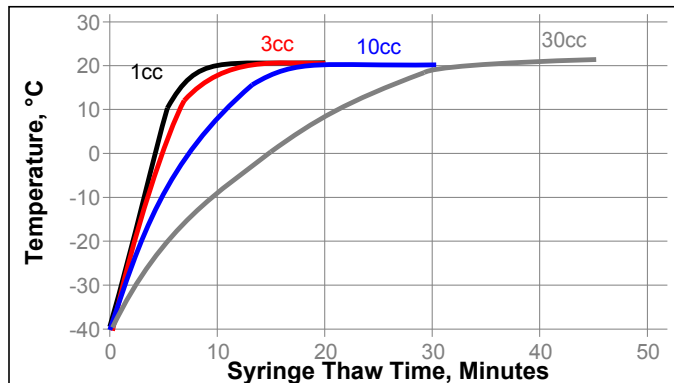
GENERAL INFORMATION

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

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.

3. Refer to the Syringe Thaw time chart for the thaw time recommendation.
4. DO NOT open the container before contents reach 22°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
5. DO NOT re-freeze. Once thawed to 22°C, the adhesive should not be re-frozen.



DIRECTIONS FOR USE

1. Thawed adhesive should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Adhesive must be completely used within the products recommended work life.
4. Silver-resin separation may occur if the adhesive is left out at 22 °C beyond the recommended work life.
5. Apply enough adhesive to achieve a 25 to 50 µm wet bondline thickness, dispensed with approximately 25 to 50 % filletting on all sides of the die.
6. Alternate dispense amounts may be used depending on the application requirements.
7. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.

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: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °C can adversely affect product properties.

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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} = \text{N/mm}^2$
 $\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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