



G757HF

August 2010

PRODUCT DESCRIPTION

G757HF provides the following product characteristics:

Technology	Epoxy
Appearance	Grey
Product Benefits	• One component • Extremely flexible • Good adhesion strength • Process ease • Thixotropic • Low halogen content (total Cl & Br <1500 ppm)
Cure	Heat cure
Application	Assembly
Operating Temperature	-40 to +140 °C
Typical Assembly Application	Ferrite core , Reflectors, SMT type transformer modules and Automobile headlamp lenses
Key Substrates	Glass, Ferrite, Iron, Copper, Aluminum and FRP

G757HF photocurable adhesive is designed for high throughput assembly operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density , g/cm ³	1.15
Sag Resistance (45° angle), mm:	
@ 25°C	1.88
@ 150°C	3.1
Shelf Life @ 0°C, months	6
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

45 minutes @ 140°C
20 minutes @ 160°C or
10 minutes @ 180°C or

Post Cure

2 to 4 hours at the highest expected use temperature
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This product generates high heat during cure. No adverse exotherm effects are obtained when cured in bond thicknesses less than or about 0.125 inches (3.2 mm).

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:

Hardness, :	
Shore D @ 25°C	44
Shore A @ 120°C	35

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength , MPa (psi):

Substrate	@25°C
Aluminum to aluminum	12 (1,740)

GENERAL INFORMATION

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

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.

DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. Some filler settling is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.
3. Apply adhesive to all surfaces to be bonded and join together.
4. Usable shelf life may vary depending on method of application and storage conditions.

Storage

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

Optimal Storage: 0°C. Storage greater than or below 0°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

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

Note

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Reference 0.1