

# LORD® EX-5640 Adhesive

## Description

LORD® EX-5640 adhesive is a semi-thixotropic, two-component structural adhesive system used to bond various materials together for electronic applications.

## Features and Benefits

**Controlled Flow** – provides excellent wetting to most metal, plastic and ceramic substrate surfaces without dripping/slumping off.

## Application

**Mixing** – Mix LORD EX-5640-A resin with LORD EX-5640-B curative at a 100:25 ratio, by weight.

**Applying** – For high volume production, apply adhesive using automatic meter/mix/dispense equipment.

**Curing** – LORD EX-5640 adhesive will cure to full strength in 24 hours at 25°C.

## Shelf Life/Storage

Shelf life is six months from date of manufacture when stored at 25°C in original, unopened container.

## Typical Properties\*

	<b>EX-5640-A Resin</b>	<b>EX-5640-B Curative</b>	<b>Mixed</b>
Appearance	Off-white Liquid	Red Liquid	Red Liquid
Viscosity, cps @ 25°C	17,000-20,000 Spindle 7, 50 rpm	5000-7500 Spindle 6, 50 rpm	–
Specific Gravity	1.0-1.2	1.06-1.09	–
Gel Time, min			
@ 25°C	–	–	20-45
@ 65°C	–	–	10

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

# LORD TECHNICAL DATA

## Typical Cured Properties\*

Volume Resistivity, ohm-cm @ 25°C	1 x 10 <sup>14</sup>
Thermal Conductivity, W/mK	0.21
Coefficient of Linear Thermal Expansion, ppm/°C by TMA	51
Hardness Shore D, 24 hours @ 25°C	80-90
Dielectric Strength, V/mil	400-500
Dielectric Constant 100 kHz	4.2
Dissipation Factor 100 kHz	0.035
Arc Resistance, sec	88

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## Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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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### LORD Corporation World Headquarters

111 Lord Drive  
Cary, NC 27511-7923  
USA

### Customer Support Center (in United States & Canada)

+1 877 ASK LORD (275 5673)

[www.lord.com](http://www.lord.com)

For a listing of our worldwide locations, visit [LORD.com](http://LORD.com).