



# LOCTITE® EDAG ML 25208

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PRODUCT DESCRIPTION

LOCTITE® EDAG ML 25208 provides the following product characteristics:

|                               |                                                                                                                                                                                                                                                 |
|-------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Technology                    | Polyester resin                                                                                                                                                                                                                                 |
| Appearance                    | Translucent                                                                                                                                                                                                                                     |
| Product benefits              | <ul style="list-style-type: none"><li>• Conductive</li><li>• Screen printable</li><li>• Excellent printability</li><li>• Fast UV cure</li><li>• Excellent adhesion</li><li>• Excellent flexibility</li><li>• Good dielectric strength</li></ul> |
| Cure                          | Ultraviolet (UV) / visible light                                                                                                                                                                                                                |
| Application                   | Dielectric ink                                                                                                                                                                                                                                  |
| Typical assembly applications | Insulating crossovers, tail coating for membrane touch switches, insulating and protective coating on flexible circuitry and encapsulating coating for Surface Mount Devices (SMDs) on flexible circuitry                                       |
| Key substrates                | Untreated and print receptive polyester and polycarbonate film                                                                                                                                                                                  |

LOCTITE® EDAG ML 25208 ink is designed as an insulating and protective ink in the production of low voltage circuitry on untreated or print receptive polyester and polycarbonate film.

TYPICAL PROPERTIES OF UNCURED MATERIAL

|                                          |                  |
|------------------------------------------|------------------|
| Solids content by weight, %              | 100              |
| Viscosity Brookfield @ 20°C, mPa.s (cP): |                  |
| Speed 20 rpm                             | 10,000 to 25,000 |
| Density, g/cm <sup>3</sup>               | 1.27             |
| Shelf life @ 5 to 25°C, year             | 1                |

TYPICAL SCREEN PRINTING PROCESS

Recommended thickness

|                       |    |
|-----------------------|----|
| Dry coating, µm       |    |
| 61 threads/cm screen  | 25 |
| 77 threads/cm screen  | 18 |
| 120 threads/cm screen | 10 |

For protective coatings, a 10 to 15µm thickness is recommended. A 20 to 30µm thickness is recommended for crossovers, applied in two passes, to obtain a pore-free crossover coating.

Emulsion thickness

|                        |          |
|------------------------|----------|
| Emulsion thickness, µm | 20 to 40 |
|------------------------|----------|

Recommended squeegee

|                         |          |
|-------------------------|----------|
| Polyurethane, durometer | 70 to 75 |
|-------------------------|----------|

Recommended screen type

|                                           |           |
|-------------------------------------------|-----------|
| Monofilament polyester screen, threads/cm | 61 to 120 |
| Stainless steel screen, threads/cm        | 77 to 160 |

Printing equipment type

- Manual
- Semi-automatic
- High speed reel-to-reel

TYPICAL CURING PERFORMANCE

Recommended UV cure condition

UV @ 0.5 Joule/cm<sup>2</sup>

| UV lamp (watt/cm <sup>2</sup> ) | Belt speed (meter/minute) |
|---------------------------------|---------------------------|
| 80                              | 10                        |
| 120                             | 15                        |

Percent volatiles

|          |     |
|----------|-----|
| VOC, g/L | 576 |
|----------|-----|

When applying LOCTITE® EDAG ML 25208 as an encapsulating coating on surface mount devices, belt speed should be chosen so that LOCTITE® EDAG ML 25208 will be exposed to a minimum energy level of 0.7 Joule/cm<sup>2</sup> to achieve a good cure.

When using LOCTITE® EDAG ML 25208 as a crossover, be sure to dry the inks printed over it within 5 minutes. Do not let the inks printed over LOCTITE® EDAG ML 25208 air dry for extended periods of time.

The above cure profiles are guideline recommendations. These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical properties

|                                                                      |    |
|----------------------------------------------------------------------|----|
| Coverage @ 10µm dry coating thickness,m <sup>2</sup> /kg wet product | 78 |
| Adhesion, grade                                                      | 5B |

Electrical properties

|                                    |                    |
|------------------------------------|--------------------|
| Sheet resistivity @ 25µm, ohms/sq  | >2x10 <sup>9</sup> |
| Breakdown voltage @ 25µm, volts AC | >1,500             |



**GENERAL INFORMATION**

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

**DIRECTIONS FOR USE**

1. LOCTITE® EDAG ML 25208 is supplied ready for use and does not require dilution.
2. Stir LOCTITE® EDAG ML 25208 prior to each use.
3. Dot dispensing equipment should be used when applying LOCTITE® EDAG ML 25208 as a protective, encapsulating coating on surface mounted devices like LEDs, etc.
4. Bring product to room temperature prior to use.
5. Protect against exposure to UV sources such as daylight and fluorescent lighting. Care should be taken to avoid LOCTITE® EDAG ML 25208 curing on the screen.

**Clean-up**

To clean screen and equipment, use Methylethylketone (MEK), MIBK, Acetone or similar solvents.

**Storage**

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

**Optimal storage: 5 to 25°C**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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 Henkel representative.

**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 the specifications of this product.

**Conversions**

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

**Disclaimer**

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