

3M™ One Part Epoxy Adhesive

6011 (Tentative)

Product Features

- One part can fast cure above 60°C
- Excellent bonding strength to PC/ABS, Al, various substrate
- Moderate viscosity, adjustable
- 7 minute cure time at 60°C

Product Description

6011 is one-component low temperature fast cure modified epoxy. Besides low temperature fast curing, it provides excellent adhesion strength to various types of substrates when cured. Also, it has good storage properties.

Typical Applications

It is designed for heat sensitive electronics and semiconductor devices, such as memory cards, CCD/CMOS and high throughput display assembly etc.

Typical Properties

Item	Value
Viscosity, 23°C, 20RPM, 4# spindle	9700 cPs, adjustable
Cure profile	60°C 7'
Adhesion, Overlap Shear 23°C	13 MPa (PC/ABS – Al abraded)
Adhesion, Overlap Shear 23°C	18 MPa (Al abraded – Al abraded)
Pot life, 23°C, days	14

Note: It may be take different time to reach cure temperature in different process. Sufficient time must be added to allow the bond location to reach the desired cure temperature. Curing condition should be developed for each device.

Handling/Curing Information

1. For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation directly depends on the required bond strength and the environmental aging resistance desired by user.
2. Use gloves to minimize skin contact with adhesive.
3. This product is one part epoxy adhesive.

Storage and Shelf Life

Storage: Store products at -20°C or below for maximum storage life. Higher temperatures reduce normal storage life. Rotate stock on a “first-in-first-out” basis.

CAUTION: Products are heat sensitive. Storage above 30°C may cause an exothermic reaction.

Shelf Life: This product has a shelf life of 6 months when stored in their unopened containers @ -20°C.

Technical Information:

are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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