



Electrodag™ 725A (6S-61)™

August 2009

PRODUCT DESCRIPTION

Electrodag™ 725A (6S-61)™ provides the following product characteristics:

Technology	Thermoplastic
Appearance	Silver
Filler Type	Silver
Product Benefits	<ul style="list-style-type: none"> • Conductive • Process ease • Screen printable • Long shelf life • Good printability • Excellent flexibility • No thinning required • Low electrical resistance • Excellent adhesion strength • Good screen residence time
Cure	Heat cure
Application	Conductive Ink
Operating Temperature-Maximum	100°C
Typical Assembly Applications	Membrane keyboards, membrane touch switches and Flexible circuits

Electrodag™ 725A (6S-61)™ is designed for use in the production of low voltage circuitry on polyester film.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Solids Content (3 hours @ 110°C), %	60 to 63
Viscosity, Brookfield, mPa·s (cP):	
Speed 20 rpm, @ 20°C	15,000 to 18,000
Density, Kg/cm ³	2,100
Theoretical coverage, m ² /kg:	
@ 10µm dry coating thickness	12
Shelf Life @ 4 to 8°C, year:	
From date of qualification in original seal	1
Flash Point, Tag Closed Cup Flash Tester, °C	94

TYPICAL SCREEN PRINTING PROCESS

Emulsion Thickness	
Solvent resistant emulsion, µm	10 to 40
Recommended Squeegee	
Shore Hardness	70 to 80
Recommended Screen Type	
Monofilament polyester screen, threads/cm	64 to 80
Stainless steel screen, threads/cm	68 to 130
Printing Equipment Type	
Manual	
Semi-automatic	
High speed reel-to-reel	

TYPICAL CURING PERFORMANCE

Recommended Drying Cycle

15 minutes @ 120°C

The above cure profile is a guideline recommendation. 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

Dry Coating on Polyester foil, dried 15 minutes @ 120°C

Physical Properties

Adhesion, grade	5B
Cohesion test (resistance change), %	<3

Electrical Properties

Sheet Resistivity @ 25µm, ohms/sq	0.008 to 0.014
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GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Mix thoroughly with plastic spatula or mechanical stirrer from bottom of container, careful not to whip air in to the product. Using a plastic spatula will decrease the possibility of introducing plastic grindings from the container sidewalls into the product, which could damage the screen.
2. Bring product to room temperature prior to use.
3. Electrodag™ 725A (6S-61)™ is supplied ready for use. Should thinning become necessary, dilute 1 to 3% by weight with Electrodag™ DBE.

Clean-up

To clean screen and equipment, use Methyl ethyl ketone (MEK) 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: 4 to 8 °C

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.



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.

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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