



Microwave solutions for the next generation in advanced materials processing

VFM TECHNICAL DATA SHEET

DEXTER

HYSOL 4652

ADHESIVE PROPERTIES (As reported by manufacturer)

Color: Black
Viscosity (cP): 180,000
Tg Measured by DSC (°C): 150
Tg Measured by TMA (°C): N/A
CTE Below Tg (ppm/°C): 14
CTE Above Tg (ppm/°C): 60

RECOMMENDED VFM CURE

VFM Cure Profile: 1.5 Minutes @ 110°C
+ 3 Minutes @ 165°C

Compared to Manufacturer's Suggested 15 Minutes @ 110 °C
Convection Oven Cure Profile: +30 Minutes @ 165°C

DSC COMPARISON

Dexter 4652 Fill

