Technical Datasheet

Elecolit® 3648

Product Description

Modified epoxy | 1 part | solvent-free | thermal-curing | thermally conductive | electrically conductive

- Die attach
- Conductive bonding
- Very flexible
- Snap cure; curing with thermode possible

Curing Properties

This adhesive can be cured with heat. Typical curing temperatures are listed in the table below.

Temperatures	Time
80°C	30 min
90°C	15 min
100°C	5 min
115°C	25 sec

The curing times given are guidelines. They refer to rheological measurements according to PE-Norm 067. The heating times of the parts to be joined are not taken into account. Actual cure times can vary based on part size, configuration, adhesive volume, temperature control, and the time required for the component substrates to attain oven temperature.

The final bond strength of the adhesive is achieved no sooner than 24 h after the bonded components are removed from the oven.

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Resin	Epoxy
Appearance	Grey
Filler	Silver
Filler - weight [%]	80
Particle size D90 [µm]	21.8

Uncured Material	
Viscosity [mPas] (Kinexus Rheometer, 25 °C, $10s^{-1}$) *PE-Norm 064*	10,000 – 15,000
Thixotropic index [1/10] *PE-Norm 064*	2 – 3
Density [g/cm³] *PE-Norm 004*	3.9 – 4
Working life [h] *@ room temperature*	48

Cured Material	
Hardness shore D *115°C, 30min* *PE-Norm 006*	50 – 60
Temperature resistance [°C]	-40 – 180
Shrinkage [%] *115°C, 30min* *PE-Norm 031*	<0.5
Water absorption [%] *115°C, 30min* *PE-Norm 016*	<1
Glass transition temperature - DSC [°C] *115°C, 30min* *PE-Norm 009*	-10 – 20
Coefficient of thermal expansion [ppm/K] below Tg *115°C, 30min* *PE-Norm 017*	40 – 50
Coefficient of thermal expansion [ppm/K] above Tg *115°C, 30min* *PE-Norm 017*	180 – 200
Thermal conductivity [W/m*K] *115°C, 30min* *PE-Norm 062*	3 – 4
Volume resistivity [Ohm*cm] *115°C, 30min* *PE-Norm 040*	1 – 3E-4
Young´s modulus – DMA [MPa] *115°C, 30min* *PE-Norm 022*	300 – 400

Transport/Storage/Shelf Life

Package type	Transport	Storage	Shelf life*
Syringe/Cartridge	0°C – 10°C	0°C – 10°C	At delivery min. 1.5 months max. 3 months
Other packages			

Store in original, unopened containers!

Instructions for use

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP® from Panacol, or a solution of Isopropyl Alcohol at 90% or higher concentration. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on the packaging, our adhesives may be dispensed by hand directly from the package, or they can be applied using dispensing systems and automation. Many commercially available valve and controller options are available to ensure accurate and consistent adhesive dispensing. For assistance with dispensing and curing questions, please contact our Applications Engineering department. Adhesive and substrate should not be cold for proper bonding. They must be allowed to warm to room temperature prior to processing. After curing, the adhesive must be allowed to cool to ambient temperature before testing the product's performance. For safety information refer to our Material Safety Data Sheet (MSDS).

Storage

Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Panacol cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

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Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

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