TECHNICAL DATASHEET

Elecolit® 6604

Elecolit® 6604 is a 1 component Epoxy adhesive with outstanding mechanical properties and excellent thermal conductivity. The product shows good flow behaviour and can be used with dispenser or in screen printing processes, it can further be handled comfortably with a coating knife or a spatula.

Shelf life: 6 months at 5 °C

Technical Data

Color
white
Resin
epoxy
Filler
approx. 42% Aluminiumoxid 4µ

UNCURED PROPERTIES

Viscosity (Brookfield LVT/25 °C) [Pa·s]
PE-Norm P001
110 to 140
Flash point [° C]
PE-Norm P050
> 100
Density [g/cm³]
PE-Norm P003
approx. 1.71

Curing

30 minutes at 130 °C
10 minutes at 150 °C
60 minutes at 100 °C

CURED PROPERTIES

Temperature Resistance [° C]
PE-Norm P030
-40 to 200
Hardness [Shore D]
PE-Norm P052
80 to 90
Volume resistivity [Ohm x cm]
ASTM-D-257-93
2E+15
Water Absorption [mass-%]
PE-Norm P053
< 0.3
Tg [°C] (DSC)
PE-Norm P009
110 to 120
CTE [ppm/K]
PE-Norm P017
34.6
Dielectric Constant [10kHz]
PE-Norm P054
0,4
Thermal conductivity [W/m·K]
ASTM 1530
1.05
Dielectric Strength [kV/mm]
PE-Norm P055
18.1

Generally the guidelines for application, storage etc. as mentioned in our general data sheet for Elecolit® are valid.

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KATRIN.FUCHS

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TECHNICAL DATASHEET

Elecolit® 6604

Mechanical Data

Lap Shear Strength (Steel/Steel) [MPa]  approx. 18
[PE-Norm P013]

Lap Shear Strength (Alu/Alu) [MPa]  approx. 12
[PE-Norm P013]

Instructions for Use

Surface Preparation

The surfaces to be bonded should be free of dust, oil, fat or any other dirt in order to optimise reproducible results. Lightly soiled surfaces can be cleaned with cleaner IP to create a suitable working surface.

Application

Our products are delivered ready for use. As soon as you receive them, you can dispense or use them for screen printing processes. You should store the products at 5°C for longer shelf life time.

Before using acclimate the adhesive up to room temperature. Liquid Elecolit products have to be homogenised well before application. Paste-like products can be used directly.

1-C Products have no mixing ration and pot life time.

Curing

For curing heat must be applied. The polyaddition starts at temperature over 100°C. Higher temperature will reduce the curing time. For detailed curing information, please look into the technical data sheet.

If help is required, please contact our engineering department.

Please read the corresponding Safety Data Sheet for this product.