

Elecolit® 3653 is a 1K silver-filled highly flexible, solvent-free conductor adhesive. The flexibility allows use in applications that are subject to vibrations or quick temperature fluctuations. The product may be processed via dispenser, stamping or screen printing.

Elecolit® 3653 is a single component product and can be cured thermally in the shortest amount of time.

Shelf life: 6 months at 5°C

Technische Daten :

Color	silver
Resin	epoxy
Filler	approx. 80% silver

UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [mPa*s]	PE-Norm P001	8000 to 10000
Flash point [°C]	PE-Norm P050	> 100
Density [g/cm³]	PE-Norm P051	approx. 3.7

Curing

5	minutes at	150 °C	0,002 Ohm x cm
10	minutes at	120 °C	0,005 Ohm x cm
20	minutes at	110 °C	0,01 Ohm x cm

Full Strength: 24 hours

CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 180
Hardness Shore D	PE-Norm P052	62 to 75
Volume resistivity [Ohm x cm]	ASTM-D-257-93	0.005
Water Absorption [Gew-%]	PE-Norm P053	< 0,3
TG DSC [°C]	PE-Norm P009	50 to 60
Thermal Expansion [ppm/K]	PE-Norm P017	77
Thermal conductivity [W/mK]	ASTM 1530	2

Our data sheets have been compiled to the best of our knowledge. The information included in our data sheets is exclusive information for the intended user and describes characteristics, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. In general, for guarantee claims, please refer to our standard terms and conditions.

Adhesives
and more...

Mechanical Data

Lap Shear Strength (Alu/Alu) [MPa]	[PE-Norm P013]	approx. 16,7
E-Modul [MPa]	[PE-Norm P056]	2210

Instructions for UseSurface 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. Higher curing temperature will lead to better electrical conductivity and less volume resistivity.

If help is required, please contact our engineering department.
Please read the corresponding **Safety Data Sheet** for this product.