

DESCRIPTION

The PERMACOL 2505 is a one component epoxy adhesive, which cures at elevated temperatures. This product is used when a thermal conductive bonding is required, without electrical conductivity. The adhesive shows very little shrinkage and can be used as top coat. After curing, the product is stable and is resistant to moist, chemicals and high temperature.

Technical details	
Basis	Epoxy
Colour	Light Brown
Filling degree	50-60%
Viscosity	100 Pa.s (D=30/s 23°C)
Temperature resistance	-30°C up to +150°C
Curing time	3 min at 150°C
	6 min at 125°C
	15 min at 100°C
Hardness	85 shore D
Volume resistance	$<3 \times 10^{-3} \Omega \cdot \text{cm}$
Thermal conductive coefficient	1.20 W/m.K

Curing recommendations

The standard curing conditions are 3 minutes at 150°C or 6 minutes at 125°C. In practice the oven time might need to be longer to allow the substrate to heat up.

Do not return used glue in the packaging to avoid contamination.

CLEANING

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

BENEFITS

- Thermal conductive
- High volume resistance
- Low shrinkage
- Resistant to higher temperatures
- Fast curing
- RoHS und REACH compatible

Cured adhesives must be removed mechanically. We advise to heat up the adhesive bond over 100°C. At this temperature, the adhesive dot will become softer and the component can easily be removed using torsion.

STORAGE

Store in its original packaging below 4°C. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 6 months at 4°C.

SAFETY

Use protective gloves to avoid direct contact with the skin. Check the Material Safety Data Sheet for specific safety information.

PACKAGING

The PERMACOL 2505 can be supplied in all dispenser-specific syringes, tins and pots.

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