

ET 1628

Thermally Conductive Adhesive

Typical Properties			
Property	Unit	Value	Test Method
Color / Component A		White	Visual
Color / Component B		Grey	Visual
Mixing Ratio (A : B)	By weight	2:1	
Density (as mixed)	Gram /cc	2.9	ASTM D792
Viscosity as Mixed at 25°C	Pa.s	90 to 230	ASTM D2196
Property as Cured			
Color		Grey	Visual
Young's modulus	GPa	5.8	DMA
Thermal Conductivity	W/m-K	2.3	ASTM D5470
Heat Capacity at 25°C	J/g-K	1.5	ASTM D1269
Dielectric Strength	Volt/mil AC	> 400	ASTM D149
Volume Resistivity	Ohm-cm	> 10E+10	ASTM D257
Coefficient of Thermal Expansion	ppm/C	120 (@ > Tg) 32 (@ < Tg)	IPC-TM-650
Adhesion (Al/Al lap shear)	Psi	> 1500	ASTM D1002
Tg	°C	55 to 75	DMA
Temperature Usage	°C	-80 to 200	TGA
Cure Profile			
Cure at 25°C	hr	4 ~ 8	DSC
Cure at 60°C	Min	60	DSC
Cure at 105°C	Min	10	DSC
Pot / Work Life at 25°C	Min	30	Viscosity double

These figures are only intended as a guide and should not be used in preparing specifications.

Processing Instruction

Important! Only components A and B with the same lot number may be processed together! For the package in a container (not in a cartridge), to ensure homogeneity of the material, the components must be stirred thoroughly before they are removed or processed in order to uniformly disperse any fillers that might have settled during storage. For long-term storage, it is recommended to store the material in - 30°C freezer to prevent filler from settling.

We recommend running preliminary tests to optimize conditions for the particular application. Comprehensive processing instructions can be obtained by contacting directly to United Adhesives, Inc.

Storage

ET 1628 has a shelf life of at least 12 months when stored below 25°C in the originally sealed container. The 'Best use before end' date of each batch appears on the product label. Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

Safety information

General hygiene regulations should be observed. Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from United Adhesives, Inc.

Characteristics

ET 1628 is a thermally conductive epoxy adhesive for electronic applications. It is two components with 2:1 mixing ratio, and can be cured at room temperature or elevated temperature after mixing. It provides strong bonding to metals such as aluminum, copper, plastics, FR4 PCBs, ceramics, glass, etc, with excellent thermal conductivity. The cured material also has very low CTE that can provide better thermal cycle performances. ET 1628 is printable.

Special Features and Benefits

- Room temperature curable
- High thermal conductivity
- High temperature stability
- Low CTE for stress compliance
- Low bleeding, low volatile
- Low ionic content

Typical Applications

- Aerospace electronics
- Automotive electronics
- Semiconductor and Telecommunications
- Bonding while dissipating heat
- Bonding of power devices to heat sinks
- Thermally conductive structural bonding
- Thermally conductive vibration

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