

Thermalbond™ is a thermally conductive, high strength epoxy adhesive. It provides exceptional adhesion to copper, aluminum, steel, glass, ceramics, and most plastics. Thermalbond™ also has a coefficient of thermal expansion compatible with aluminum, copper, and brass, making it particularly well suited for thermally bonding semiconductors and other components to chassis or heat sinks.

ORDERING INFORMATION

Part number	Net weight
4949G	0.8 oz (25 gram kit)
4950G	1.7 oz (50 gram kit)
4951G	3.5 oz (100 gram kit)
4952G	7.0 oz (200 gram kit)
4953G	4 lbs (1814 grams)

MIXING INSTRUCTIONS

Mix resin thoroughly before removing material. Add 7.1 parts of RT-7 hardener to 100 parts of resin by weight, or 17 parts of RT-7 hardener to 100 parts of resin by volume. Adhesive will set up in:

24 hrs at 25°C (77°F)	1 hr. at 100°C (212°F)
2 hrs. at 65°C (149°F)	30min. at 130°C (266°F)

Note: For maximum electrical and physical properties, a post cure is necessary. Post cure at room temperature for 4 days or for 4 hours at 93°C (200°F).

HANDLING CHARACTERISTICS

Typical electrical and physical properties at room temperature with RT-7 hardener

Color	Green
Specific gravity	2.35
Working viscosity	25,000 cps
Thermal conductivity	1.34W/(m °C) (0.77 Btu/hr ·ft· °F)
Thermal resistivity	29.4°C in/watt
Tensile strength	6.34 x 10 ⁷ Pa (9,2000 psi)
Compressive strength	1.44 x 10 ⁸ Pa (20,9000 psi)
Bond shear strength aluminum to aluminum, 25.4mm (1") overlap @ 25°C, (77°F)	3.17 x 10 ⁷ Pa (4,6000 psi)
Thermal coefficient of expansion	24 x 10 ⁻⁶ /°C (1.32 x 10 ⁻⁶ /°F)
Water absorption, % after 10 days@ 25°C (77°F)	0.20
Hardness, Shore D	86
Volume resistivity	1.0 x 10 ¹⁶
Dielectric strength	59.1 x 10 ³ volts/mm (1500 volts/mil)
Dielectric constant@25°C (77°F) 100KHz	6.1
Dielectric factor@25°C (77°F) 100KHz	0.020
Operating temperatures	-65°C to 155°C (-85°F to 311°F)
Linear shrinkage	0.002 in/in
Shelf life	12 months*
Pot life@25°C (77°F)	2-3 hours
Suggested stripping agent	Miller-Stephenson MS 111
Cleaning solvent	Acetone

* Stated shelf life is from date of manufacture. To allow for inventory cycle, product shipped from Aavid will have less than 12 months remaining shelf life. Aavid guarantees a minimum of 3 months remaining shelf life. Please adjust order quantity so all product will be consumed within 3 months of date of shipment.