

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

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 (Steel/Steel) [MPa]	[PE-Norm P013]	approx. 18
Lap Shear Strength (Alu/Alu) [MPa]	[PE-Norm P013]	approx. 12

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.