Technical Data Sheet

DOWSIL™ 3-6752 Thermally Conductive Adhesive

FEATURES & BENEFITS

- Thixotropic – increased flowability under shear/dispense
- Heat cure
- Outstanding thermal conductivity values
- UL V-0 recognized
- No added solvents
- One part - no mixing of separate components required
- Rapid, versatile cure processing controlled by temperature
- Able to flow, fill or self leveling after dispensing
- Provides heat flow away from circuitry components can increase reliability
- Can be considered for uses requiring added flame resistance

COMPOSITION

- Thermally conductive fillers
- Polydimethylsiloxane adhesive

Thixotropic thermally conductive adhesive with good flame resistance

APPLICATIONS

- DOWSIL™ 3-6752 Thermally Conductive Adhesive typical applications include bonding organic and ceramic substrates to heat sinks for electronic control modules in automotive applications

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications.

Property	Unit	Result
One part or Two part		One part
Color		Gray
Viscosity	cP	83,300
	Pa-sec	83.3
	mPa-sec	83,300
Thixotropy	NA	3.9
Specific Gravity (Cured)		2.61
Durometer Shore A		87
Tensile Strength	psi	545
	MPa	3.8
	kg/cm^2	38.3
Elongation	%	15
Unprimed Adhesion - Lap Shear (Al)	psi	518
	MPa	3.6
	N/cm^2	357
Heat Cure Time at 100°C	minutes	40
Heat Cure Time at 125°C	minutes	10
Heat Cure Time at 150°C	minutes	3
Rheometer T90 Cure Time at 125°C	minutes	5.2
Dielectric Strength	volts/mil	400
	kV/mm	16
Dielectric Constant at 100 Hz		5.64
Dielectric Constant at 100 kHz		5.51
Volume Resistivity	ohm*cm	7.1 E+13
Dissipation Factor at 100 Hz		0.007
Dissipation Factor at 100 kHz		< 0.0001
Agency listing		UL 94 V-0
Arc Track Resistance	seconds	352
Linear CTE (by TMA)	ppm/°C	138
Thermal Conductivity	btu/hr-ft-°F	0.98
	W/mK	1.7
UL Flammability Classification	NA	94 V-0

DESCRIPTION

The heat-cure, thermally conductive adhesives produce no by-products in the cure process, allowing their use in deep section and complete confinement. These adhesives will develop good, primerless adhesion to a variety of common substrates including metals, ceramics, epoxy laminate boards, reactive materials and filled plastics. PCB system assemblies are continually designed to deliver higher performance. Especially in the area of consumer devices, there is also a continual trend towards smaller, more compact designs. In combination these factors typically mean that more heat is generated in the device. Thermal management of PCB system assemblies is a primary concern of design engineers. A cooler device allows for more efficient operation and better reliability over the life of the device. As such, thermally conductive compounds play an integral role here. Thermally conductive materials act as a thermal "bridge" to remove heat from a heat source (device) to the ambient via a heat transfer media (i.e. heat sink). These materials have properties such as low thermal resistance, high thermal conductivity, and can achieve thin Bond Line Thicknesses (BLTs) which can help to improve the transfer of heat away from the device.

SUBSTRATE TESTING

To ensure maximum bond strength for adhesives on a particular substrate, 100 percent cohesive failure of the adhesive in a lap shear or similar adhesive strength test is needed. This ensures compatibility of the adhesive with the substrate being considered. Also, this test can be used to determine minimum cure time or to detect the presence of surface contaminants such as mold release agents, oils, greases and oxide films.

PROCESSING/CURING

Addition-cure adhesives should be cured at 100°C (212°F) or above. The cure rate is rapidly accelerated with heat (see heat-cure times in Typical Properties table). Thin sections of less than 20 mils may be cured in 15 minutes at 150°C (30°F). For thicker sections, a pre-cure at 70°C (158°F) may be necessary to reduce voids in the elastomer. Length of pre-cure will depend on section thickness and confinement of adhesive. It is recommended that 30 minutes at 70°C (158°F) be used as a starting point for determining necessary pre-cure time. Addition-curing materials contain all the ingredients needed for cure with no by-products from the cure mechanism. Deep-section or confined cures are possible. Cure progresses evenly throughout the material. These adhesives generally have long working times.

ADHESION

Dow silicone adhesives are specially formulated to provide unprimed adhesion to many reactive metals, ceramics and glass, as well as to selected laminates, resins and plastics. However, good adhesion cannot be expected on non-reactive metal substrates or non-reactive plastic surfaces such as Teflon®, polyethylene or polypropylene. Special surface treatments such as chemical etching or plasma treatment can sometimes provide a reactive surface and promote adhesion to these types of substrates. Dow primers can be used to increase the chemical activity on difficult substrates. For best results, the primer should be applied in a very thin, uniform coating and then wiped off after application. After application, primers should be thoroughly cured prior to application of the silicone elastomer. Poor adhesion can be experienced on plastic or rubber substrates that are highly plasticized, since the mobile plasticizers act as release agents. Small-scale laboratory evaluation of all substrates is recommended before production trials are made. In general, increasing the cure temperature and/or cure time will improve the ultimate adhesion.

USEFUL TEMPERATURE RANGES

For most uses, silicone adhesives should be operational over a temperature range of -45 to 200°C (-49 to 392°F) for long periods of time. However, at both the low and high temperature ends of the spectrum, behavior of the materials and performance in particular applications can become more complex and require additional considerations. For low-temperature performance, thermal cycling to conditions such as -55°C (-67°F) may be possible for most products, but performance should be verified for your parts or assemblies. Factors that may influence performance are configuration and stress sensitivity of components, cooling rates and hold times, and prior temperature history. At the high-temperature end, the durability of the cured silicones is time and temperature dependent. As expected, the higher the temperature, the shorter the time the material will remain useable.

SOLVENT EXPOSURE

In general, the product is resistance to minimal or intermittent solvent exposure, however best practice is

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To avoid solvent exposure altogether.

USABLE LIFE AND STORAGE

The product should be stored in its original packaging with the cover tightly attached to avoid any contamination. Store in accordance with any special instructions listed on the product label. The product should be used by the indicated Exp. Date found on the label.

HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT WWW.CONSUMER.DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, www.consumer.dow.com or consult your local Dow representative.

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