

# Polytec TC 304

## Properties

Polytec TC 304 is a standard single component, metal filled, heat curing epoxy adhesive with excellent thermal conductivity.

Polytec TC 304 was designed for all applications where heat transfer is essential (heat-sinking, aluminum or ceramic packaging etc.). It has a conveniently long pot- and shelf life and is ideal for all dispensing and screen printing applications.

TC 304 has an excellent adhesion on metals, ceramic, glass and most plastics.

The material can be applied by dispensing, screen or stencil printing.



## Processing

- For two-component products the components A and B should be mixed carefully within the specified mixing ratio.
- For filled products both components should be homogenized carefully prior mixing, in order to prevent a possible settling of the filler.
- Processing should be carried out rapidly after mixing the components; as an indication the pot life can be used.
- Surfaces should be clean, thus free of dirt, grease, oil, dust or process chemicals.
- One-component products can be applied directly and are not subject to a pot life (except pre-mixed/frozen products).
- Please take notice of respective minimum curing temperature and time.
- For Safety information please refer to the respective Material Safety Data Sheet.

# Polytec TC 304

## Thermally Conductive Adhesive

### Technical Data

# Polytec TC 304

Properties in uncured state	Method	Unit	Technical Data
Chemical basis	-	-	Epoxy
No. of components	-	-	1
Mixing ratio (weight)	-	-	-
Mixing ratio (volume)	-	-	-
Pot life at 23°C	TM 702	months	1
Storage Stability at 23°C	TM 701	months	6
Consistency	TM 101	-	Creamy Paste
Density Mix	TM 201.2	g/cm <sup>3</sup>	1.78
Density A-Part	TM 201.2	g/cm <sup>3</sup>	-
Density B-Part	TM 201.2	g/cm <sup>3</sup>	-
Type of filler	-	-	Aluminium
Max. particle size	-	µm	<45
Viscosity Mix 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	35 000
Viscosity A-Part 10 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	-
Viscosity B-Part 84 s <sup>-1</sup> at 23°C	TM 202.1	mPa·s	-

Properties in cured* state	Method	Unit	Technical Data
Colour	TM 101	-	Metal grey
Hardness (Shore D)	DIN EN ISO 868	-	85
Temperature resistance continuous	TM 302	°C	-55 / +180
Temperature resistance short term	TM 302	°C	-55 / +280
Degradation Temperature	TM 302	°C	+380
Glass Transition Temperature (T <sub>g</sub> )	TM 501	°C	-
Coefficient of thermal expansion (<T <sub>g</sub> )	ISO 11359-2	ppm	-
Coefficient of thermal expansion (>T <sub>g</sub> )	ISO 11359-2	ppm	-
Thermal conductivity	TM 502	W/m·K	1.4 ±0.2
Specific volume resistivity	DIN EN ISO 3915	Ω·cm	10 <sup>8</sup>
Young modulus	TM 605	N/mm <sup>2</sup>	7 400
Tensile strength	TM 605	N/mm <sup>2</sup>	65
Lap shear strength (Al/Al)	TM 604	N/mm <sup>2</sup>	17
Elongation at break	TM 605	%	1.6
Water absorption 24 h, 23°C	TM 301	%	-

\*The above data has been determined with samples cured at 150°C. Please notice, by varying the curing temperature these properties can be influenced to some extend.

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Curing*	Method	Unit	Technical Data
Minimum curing temperature		°C	120
Curing time at 120°C		min	45
Curing time at 150°C		min	10
Curing time at 180°C		s	-

\*Curing temperatures refer to the temperature in the respective bond line. When choosing the respective curing conditions, the time needed to heat the substrate has to be considered. Depending on the type of heat source (convection oven, hot stamp, heating plate) the heat input may vary.

## Standard pack sizes:

30cc\* / 60 g

250 g, 500 g

1 kg, 25 kg

Customized Packaging

\*: EFD-Cartridges

## Please note:

The above listed information are typical data based on tests and are believed to be accurate. Polytec PT makes no warranties (expressed or implied) as to their accuracy. The above listed data do not constitute specifications. The processing (in particular the cure conditions) of the material, the process control and the variety of different applications at various customers are not under Polytec PT's control. Therefore Polytec PT will not be liable for concrete results in any specific application or in any connection with the use of this product. In particular the cure conditions do have a major effect on the properties of the cured material. Therefore it is highly recommended to keep the cure schedule – once established - under tight control. With the release of this data sheet all former data sheets will be null and void.

Subject to alteration.

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