



TECHNICAL DATASHEET

Elecolit® 6616

Elecolit® 6616 is a high-strength, 2part thermally conductive adhesive on an epoxy resin basis, processed in a 1 : 1 mixing ratio. Its toughness provides an excellent combination of cutting and peeling resistance. The product is also superior in terms of vibration and shock resistance. Even at very low temperatures, this adhesive maintains its toughness.

Elecolit® 6616 is a high performance adhesive, which has successfully passed 500 temperature changes from -50°C / +150°C.

Shelf life: 12 months at 25°C

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Technical Data

Color black
Resin 2-part Epoxy

UNCURED PROPERTIES

Viscosity paste-like
Flash point -
Pot-Life [min.] PE-Norm P019 approx. 45
Density [g/cm³] PE-Norm P003 approx. 1.7

Curing

24 hours at 25 °C
120 minutes at 80 °C

CURED PROPERTIES

Temperature Resistance [°C] PE-Norm P030 -50 to 150
Hardness [Shore D] PE-Norm P052 81
Volume resistivity [Ohm x cm] ASTM-D-257-93 3E+14
Shrinkage [%] PE-Norm P031 1
Tg [°C] (DSC) PE-Norm P009 > 85
CTE [ppm/K] PE-Norm P017 77
Dielectric Constant [10kHz] PE-Norm P054 5.3
Thermal conductivity [W/m·K] ASTM 1530 1.01

**Adhesives
and more...**

Mechanical Data

Lap Shear Strength (Steel/Steel) [MPa]	[PE-Norm P013] approx. 19.3
Lap Shear Strength (Alu/Alu) [MPa]	[PE-Norm P013] approx. 11.3

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 Elecolit 2-C products are delivered in separate packing units. Resins can crystallize at deep temperature storage- this process will be reversible by heating for 1 hour at 40°C.

The components A and B have to be homogenised well, weigh out in mixing ration and homogenised with each other for min. 2 minutes.

From now, the pot life time starts and the adhesive has to be applied rapidly.

You can dispense or use them for screen printing processes.

Curing

For curing heat must be applied. In some cases they will cure even at room temperature. But 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.

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