TECHFILM®

Adhesive Films and Preforms

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TF I3202
Electrically Insulating Adhesive

Description:

TechFilm I3202 is a high performance liquid adhesive that is specially formulated for bonding to gold or gold plated substrates. TechFilm I3202 will cure at temperatures above 130°C. It features good chemical, heat, and moisture resistance.

Applications:

TechFilm I3202 is a liquid adhesive that is designed for giving high strength bonds to difficult to bond metal surfaces.

Shelf Life:

Two days @ 20°C One week @ 10°C Two months @ -10°C One year @ -40°C

Cure Schedules:

Cure Schedule	60 minutes at 150°C
Alternate Cure Schedules	30 minutes at 165°C, or 180 minutes at 130°C

Uncured Properties

Property	Method	Value Obtained
Viscosity at 25°C, RV-TD, 1RPM, cP	TFTEST001B	130,000
Viscosity at 25°C, RV-TD, 10RPM, cP	TFTEST001B	64,000
Gel time at 160°C, seconds	TFTEST006	140

Cured Properties:

Property	Method	Value Obtained
Color	Visual	Translucent
Specific Gravity	ASTMD 792	1.2
Volume Resistivity at 25°C, Ohm-cm	TFTEST004A	$>1.0 \times 10^{14}$
Lap Shear Strength to Aluminum at 25°C, psi	ASTMD 1002	3400
Lap Shear Strength to Gold at 25°C, psi	ASTMD 1002	3300
Lap Shear Strength to 101 Copper at 25°C, psi	ASTMD 1002*	4200
Lap Shear Strength to 260 Brass alloy at 25°C, psi	ASTMD 1002*	4530
Lap Shear Strength to Nickel at 25°C, psi	ASTMD 1002	4230
Lap Shear Strength to PEEK at 25°C, psi	ASTMD 1002*	320
Lap Shear Strength to ULTEM at 25°C, psi	ASTMD 1002*	810
Glass Transition Temperature, °C, 20°C per minute	ASTME 1356	92
Weight Loss at 150°C, TGA, 20°C/min, N_2, %	ASTMD 3850	0.22
at 200°C	and MIL-STD-883	0.32
at 250°C	Section 3.8.5.1	0.52

*** testing performed on 0.25" thick substrates.**

All values reported above are typical values from the recommended cure, and are reported as a means of reference. Individual testing should be done to determine actual results, tested at specific conditions.

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