

I 2500F

ELECTRICALLY INSULATIVE FILM

TECHNICAL DATA

November, 2010

Product Description

I2500F is a high performance B-staged film adhesive. It features relatively high flow with good wetting properties and fairly high glass transition temperature. I2500F will cure at temperatures above 130°C.

APPLICATIONS	FEATURES	RECOMMENDED SUBSTRATES
<ul style="list-style-type: none"> Lid Sealing Automotive 	<ul style="list-style-type: none"> Chemical, heat, moisture resistant All purpose adhesive 	<ul style="list-style-type: none"> Various Stainless Steel

UNCURED PROPERTIES*		
Property	Value	Test Method
Weight Loss, TGA, 20C/min, N ₂ , %	@ 150C: 0.05	ASTM D3850 and MIL-STD-883
	@ 200C: 0.15	

CURED PROPERTIES*		
Property	Value	Test Method
Color	Amber	Visual
Specific Gravity	1.2	ASTM D790
Specific Heat Capacity, J/g-K	1.14	ASTM E1461
Glass Transition Temperature, C	135	ASTM E1356
Volume Resistivity at 25°C Ohm-cm	>2 x10 ¹⁵	ASTM D257

TENSILE SHEAR STRENGTH*		
Property	Value	Test Method
to Aluminum @ 25C, psi	3100	ASTM D1002
to Gold @ 25C, psi	2000	ASTM D1002
to 316 SS @ 25C, psi	3850	ASTM D1002*

* Tested using 0.188" thick substrates

CURE SCHEDULE*		
Property	Value	Test Method
Cure Time @ 150C, min	60	Typical Cure Schedule
Cure Time @ 140C, min	90	Alternate Cure Schedule
Cure Time @ 150C plus 180C, min	15 plus 15	Alternate Cure Schedule
Cure Time @ 130C, min	120	Alternate Cure Schedule
Cure Time @ 165C, min	30	Alternate Cure Schedule

Storage: Store in dry conditions, out of sunlight and in tightly sealed containers.

Shelf Life: One month @ 20C Three months @ 10C Six months @ -20C One year @ -40C

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