

## Technical Data Sheet



### ASSEMBLY MATERIALS

**Product Type:** Conductive Adhesive

**Product Name:** PC 3231

#### Description

PC 3231 is a thermosetting, one-component, solvent-free, silver-filled epoxy conductive adhesive, designed for the connection of passive components and bare dies on lead frames and PCB for dispensing application. The glue has a hardener system, which includes a cationic curing agent.

#### Key Benefits

- High electrical and thermal conductivity
- Excellent adhesion strength
- Solvent-free, one component

#### Compliant Products

- Conductive Adhesive: PC3600 Series
- Non-conductive Adhesive: NCA 6, NCA 11

#### Applications

- Dispensing

#### Physical Properties

Processing Life (days)	Curing Profile	Substrate and Components
5	2 min / 180 °C 3 min / 150 °C	Flex PCB, Flex lead frames and foils. Recommended surface: Ni/Au and Ag
Adhesion (N/mm <sup>2</sup> ) <i>Standard: DIN EN 1465</i>	Weight Loss during Curing Process at 150 °C (%)	Glass Transition Temperature (°C)
Min. 25	Max. 0.5	Approx. 58
Thermal Conductivity (W/mK)	Volume Resistivity (mΩ.cm)	
Min. 5	Max. 0.3	

#### Halogen Content

##### Hydrolyse Halogen

Tolerance: Halogen < 50 ppm

#### Cleaning Instructions

The uncured adhesive can be removed with Zestron HC and other Zestron and Vigon cleaning materials. The cleaned parts must be completely dry before installing them in the machine. Defective components can be removed by heating the cured adhesive joint with hot air above 250°C. The hot remaining adhesive can be removed with a sharp tool.

#### Adhesive Conditioning

- Remove adhesive from freezer: Before opening the package leave it for at least 2 hours at room temperature so that adhesive heats up
- Do not open jar/cartridge while adhesive is cold to prevent condensation
- Do not use faster defrost systems

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### Storage

- Store the adhesive in tightly-sealed containers and avoid exposure to high humidity and sunlight
- In cartridges: From the date of manufacture 12 months in a freezer at – 20 °C
- Store the cartridges with tip pointing downwards

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