

Keratherm Adhesives

Property	unit	Adhesive Type	
		Sil-S1	Sil-S2
Color		transparent	transparent
Film Type		PSA Silicone	Gel Silicone
Suitable for Film Types		Standard silicone films with reinforcement	Standard silicone films with or without reinforcement
Application Temperature	°C	-60 to +250	-60 to +250
Coating Thickness	µm	20 - 50	30 - 75
Suitable for Reflow Process	(10sec.-270°C)	yes	yes
Peel Resistance*1 DIN 53375, DIN 53282, DIN 53283	N/25mm	2 - 10	1 - 5
Bonding Strength	Nmm	> 0.15	> 0.2
Tack (<i>surface adhesiveness</i>)	mm	> 0.5	< 1.0
Shelf Life*2	months	8	8

Property	unit	Adhesive Type		
		Acryl-A1	Acryl-A2	Acryl-A3
Color		transparent	transparent	Milky white
Film Type		Acrylate	Removable Acrylate	Filled Acrylate
Suitable for Film Types		For all silicone free films	For all silicone free films	For all silicone free films
Application Temperature	°C	-40 to +180	-40 to +180	-40 to +180
Coating Thickness	µm	15 - 25	20 - 50	40 - 60
Suitable for Reflow Process	(10sec.-270°C)	no	no	yes
Peel Resistance*1 DIN 53375, DIN 53282, DIN 53283	N/25mm	5 - 12	2 - 5	2 - 5
Bonding Strength	Nmm	> 0.3	> 0.2	> 0.2
Tack (<i>surface adhesiveness</i>)	mm	> 1.0	> 0.8	> 0.5
Shelf Life*2	months	12	12	12

*1 **Peel Resistance:** Peeling at 180°C, peel speed: 300 mm/min.;
Width of test strip: 25 mm; Length of test strip: 220 mm;
Finath test-method in accordance with DIN 53375, 53282, 53283.

*2 **Shelf Life:** **Silicone Adhesive** - eight (8) months from date of manufacture provided the material has been stored in its original packaging and at max. 21°C (70°F). and 50% relative humidity.

Acrylate Adhesive - twelve (12) months from date of manufacture provided the material been stored in its original packaging and at max. 21°C (70°F). and 50% relative humidity.

*3 **Phase Change:** phase change occurs at 50-55°C

Notice: When using adhesives as single-sided coating for Keratherm® Thermal Conductivity Films the thermal impedance increases.