

Adhesive & Potting Solutions for Electric Vehicles









INTRODUCTION

The automotive industry is going through signficant transformation. With consumers today increasingly socially and environmentally conscious, there is a growing demand for energy-efficient vehicles. As a result, investments are being made globally in the design and development of Electric Vehicles. Designers in particular are innovating with different materials and chemistries to achieve the required performance targets. Vehicle lightweighting as well as thermal management are key areas of research and development.

That's where the Insulcast and Plexus range of products play an important role. They are designed to overcome difficult engineering challenges. The Insulcast potting and encapsulation compounds are specifically developed to protect components in applications such as heat sink bonding, surface mount and die attach while meeting the challenges of heat dissipation. This improves performance and longevity of the device. The Plexus range of adhesives bond nearly all thermoplastics, metals and composite materials providing greater design freedom and manufacturing flexibility. They require little to no surface preparation and ensure bonds so strong that the adhesive will outperform the substrate.

BENEFITS

Plexus (Polymethylmethacrylate) MMA adhesives are fast setting, room temperature cured that provide excellent adhesion to metals, composites and thermoplastics. Plexus ensures durable bonds, offering countless possibilities for design engineers and the production managers. They offer superior strength and enable bonding over a wide range of gaps and substrate thickness, providing both a structural bond and final seal.

Insulcast Epoxies are general purpose and thermally conductive compounds. They are not only formulated to provide high thermal conductivity but also superior mechanical strength, excellent moisture resistance and high chemical resistance. They exhibit good adhesion properties.

Insulcast Silicones are both general purpose and thermally conductive compounds. These addition cure silicones exhibit high flexibility, are easily repaired and provide a superior performance over a broad temperature range. They have minimal shrinkage during cure.



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Plexus Adhesives	Description	Mixed color	Mix ratio (by volume)	Viscosity (cps)	Working time (mins)	Fixture time (mins)	Shear strength MPa (psi)	Tensile elongation (%)	Gap fill mm (Inch)	Metals					Plastics						Com			omposites			ther				
MA300	All purpose high strength, fast setting	Cream/ Black	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	3 -6	12 - 15	20.7 - 26.2 (3,000 - 3,800)	5 - 15	3.2 (0.13)	~	✓		\checkmark	✓	✓	✓	\checkmark	✓	✓		\checkmark	~	✓	\checkmark	✓	✓	✓	✓	\checkmark	✓ ·	~
MA310	Ideal for 'difficult to bond plastics'	Cream	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	15 - 18	45 - 55	20.7 – 24.1 (3,000 - 3,500)	5 - 15	3.2 (0.13)	\checkmark	\checkmark		\checkmark	\checkmark	\checkmark	✓	✓	✓	\checkmark		\checkmark	\checkmark	\checkmark	\checkmark	✓	\checkmark	\checkmark	\checkmark	✓	< ·	~
MA420	All purpose, toughened adhesive, fast setting	Blue/Black/ Cream	10:1	A: 100,000 - 125,000 B: 35,000 - 80,000	4 - 6	15 - 18	20.7 - 26.2 (3,000 - 3,800)	30 - 50	9.5 (0.37)	✓	\checkmark		~	\checkmark	\checkmark	✓	✓	✓	~		\checkmark	\checkmark	✓	\checkmark	✓	\checkmark	✓	✓	✓	✓ ·	~
MA8110	Next generation multi-material bonder	Gray	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	8 - 12	35 - 50	12.4 - 16.5 (1,800 - 2,400)	>10	12.7 (0.5)	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	✓	✓	✓	\checkmark	\checkmark		\checkmark	✓		✓	\checkmark					
MA8120	Next generation multi-material bonder	Gray	1:1	A: 40,000 - 70,000 B: 40,000 - 70,000	18 - 22	75 - 90	12.4 - 16.5 (1,800 - 2,400)	>40	12.7 (0.5)	✓	✓	✓	\checkmark	\checkmark	\checkmark	✓	✓	✓	~	\checkmark		\checkmark	✓		✓	\checkmark					
MA830	No primer metal bonder	Gray	10:1	A: 80,000 - 120,000 B: 35,000 - 80,000	4 - 6	15 - 25	13.8 – 19.3 (2,000 - 2,800)	30 - 60	13 (0.51)	\checkmark	\checkmark		\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark		\checkmark	\checkmark	\checkmark	\checkmark	✓	\checkmark	\checkmark	\checkmark	\checkmark	✓ ·	~
MA832	Metal Bonder with medium open time	Gray	10:1	A: 80,000 - 130,000 B: 35,000 - 80,000	12 - 16	55 - 60	13.8 – 19.3 (2,000 - 2,800)	30 - 60	12 (0.47)	✓	✓		\checkmark	\checkmark	\checkmark	✓	\checkmark	✓	~		\checkmark	\checkmark	✓	\checkmark	✓	\checkmark	✓	\checkmark	\checkmark	✓	
MA530	All purpose, high strength, medium open time	Gray	1:1	A: 130,000 - 180,000 B: 160,000 - 215,000	30 - 40	90 - 160	11.7 – 17.2 (1,700 - 2,500)	90 - 160	18 (0.71)	\checkmark	\checkmark		\checkmark	\checkmark	\checkmark	✓	\checkmark	\checkmark	✓	\checkmark	\checkmark	\checkmark	\checkmark	\checkmark	✓	\checkmark	\checkmark	\checkmark	\checkmark	✓ .	~
MA560-1	All purpose, high strength, long open time	Gray	1:1	A: 145,000 - 185,000 B: 170,000 - 205,000	55 -70	220 - 240	11.7 – 17.2 (1,700 - 2,500)	>130	25 (0.98)	✓	✓		\checkmark	\checkmark	\checkmark	✓	\checkmark	✓	~		\checkmark	\checkmark	✓	\checkmark	✓	\checkmark	✓	\checkmark	✓	\checkmark	

Application Details

Plexus two-component systems should be applied at temperatures between 18°C (65°F) and 26°C (80°F). Temperatures below 18°C (65°F) will slow the cure speed; above 26°C (80°F) will increase the cure speed. The viscosities of Parts A and B of these adhesives are affected by temperature. For consistent dispensing in meter-mix equipment, adhesive and activator temperatures should be held reasonably constant throughout the year.

To ensure maximum bond strength, use sufficient material to completely fill the joint and mate the parts together within the specified working time. After joining, the parts must remain undisturbed until the fixture time has elapsed.

Dispensing Equipment

Plexus adhesive may be applied with manual or pneumatic hand-held dispensers, or other approved recommended bulk dispensing equipment. Automated application may be accomplished with a variety of meter-mix equipment that delivers both components through a static mixer. Plexus Engineering should be consulted on all wetted components of dispensing equipment.

Use chemically resistant materials for gaskets, seals and O-rings. Dispensing hoses should be PTFE lined. Run equipment with adhesive and activator for approximately 30 seconds every 2 weeks if equipment is not in use. Refer to equipment manuals for preventive maintenance, cleaning and extended shutdowns.





Insulcast Epoxies	Description		Mix ratio by weight (with curing agent)	Pot life, mins @ 25 °C (77°F)	Viscosity (mixed, cP)	Cure cycle °C (°F)	Shore hardness	Thermal conductiv- ity, (W/m °K)	Glass transition point, °C (°F)	Dielectric constant, (KHz)	Dielectric strength, (Volts/Mil)	Volume resistivity, (Ohm-cm)	Coefficient of thermal expansion (°C)	Service temperature, °C (°F)	UL flamma- bility rating
Insulcast 140FR	Very high thermal conductivity.	Black	100: 3-4 (Icure 11B)	150	50,000	3hr @ 100 (212)	90-95D	2.88	100 (212)	6.3	420	1x10 ¹⁵	26x10 ⁻⁶	-55 to +155 (-67 to + 311)	94 V-1
Insulcast 3230LV	Low viscosity, highly filled formulation that exhibits excellent elec- trical properties and unusually high thermal conductivity with low thermal expansion.	Black	100: 4-5 (Icure 9)	75 - 120	6,000	36hr @ 25 (77)	90D	1.2	80 (176)	6.3	475	1.3x10 ¹⁶	28x10 ⁻⁶	-40 to +105 (-40 to + 221)	None

Insulcast Silicones: Addition cure	Description		Mix ratio by weight (with curing agent)	Pot life, mins @ 25 °C (77°F)	Viscosity (mixed, cP)	Cure cycle °C (°F)	Shore hardness	Thermal conductiv- ity, (W/m °K)	Dielectric constant, (KHz)	Dielectric strength, (Volts/Mil)	Volume resistivity, (Ohm-cm)	Coefficient of thermal expansion (°C)	Service temperature, °C (°F)	UL flammability rating
RTVS 27 FC	Low viscosity, fast cure compound that has excellent electrical properties.	Black	1:1	<5	2,900	1 hr @ 25 (77)	60A	0.31	3	514	1x10 ¹⁵	22x10⁻⁵	-55 to +204 (-67 to +399)	94V-0
RTVS 27 HTC	Low viscosity compound with high thermal conductivity. This combination makes it ideal for potting dense component packages requiring heat dissipation.	Black	1:1	60	6,000	24hr @ 25 (77)	60A	1.01	4	500	1x10 ¹⁵	17x10⁻⁵	-55 to +232 (-67 to +449)	94V-0
RTVS 8127	Flame retardent compound. The low viscosity and high thermal conductivity make it ideal for potting dense component packages requiring heat dissipation.	Gray	1:1	160 - 220	4,000	24hr @ 25 (77)	55A	0.75	4	500	1x10 ¹⁵	18x10⁻⁵	-55 to +204 (-67 to +399)	94V-0
RTVS 3-95-2	High temperature with very high thermal conductivity potting compound.	Red	1:1	15	35,000	24hr @ 25 (77)	85A	1.44	5	425	1x10 ¹⁴	15x10⁻⁵	-55 to +260 (-67 to +500)	94V-0

General Use Instructions

- 1. Mix R.T.V.S. compound in original container to be sure of uniformity.
- 2. Weigh out sufficient R.T.V.S. compound for application. NOTE: Be sure container and stirrer are clean.
- 3. Add catalyst in calculated amount for the desired cure rate. If unsure, use a small amount of compound to check cure rate.
- 4. Mix thoroughly, being sure to incorporate material from sides and bottom of container. Keep air entrainment to a minimum.

- 5. De-airation under vacuum may be necessary if absolutely void-free castings are needed.
- 6. Pour into mold, cavity, etc.
- Cure at room temperature. Length of cure will depend on amount and type of catalyst used. Faster cures can be achieved at 51°C (125°F) for 2-3 hours.





GLOBAL OPERATIONS

North America

ITW Performance Polymers

30 Endicott Street Danvers, MA 01923 T: +1 855-489-7262 cs@itwpp.com www.itwpp.com

ITW Performance Polymers

130 Commerce Drive Montgomeryville, PA 18936 T: +1 215-855-8450 customerservice.na@itwpp.com www.itwpp.com

South America

Rua Antonio Felamingo, 430 Macuco, Valinhos, SP 13279-452 T: +55 19 2138-7600 www.itwppf.com.br

Europe

ITW Performance Polymers Bay 150 Shannon Industrial Estate Shannon, County Clare Ireland T: +353 61 771 500 E: customerservice.shannon@itwpp.com www.itwpp.com

Asia Pacific ITW PP&F China

2703, Xingyuan Building No. 418, Guiping Rd. Cao He Jing Hi-Tech Park Shanghai China 200233 T: +86-21-5426-1212 www.itwppfchina.com

ITW PP&F Japan

30-32 Enoki-cho, Suita, Osaka 564-0053 Japan T: +81-6-6330-7118 www.itwppfjapan.com

ITW PP&F Korea

13th floor, PAX Tower, Unit B 231-13, Nonhyeon-Dong, Gangnam-Gu Seoul, Korea 135-010 T: +82-2-2088-3560 www.itwppfkorea.com

ITW P & F – Polymers Australia

100 Hassall Street, Wetherill Park NSW 2164 Tel: +800 063 511 www.itwpf.com.au

ITW India Limited

Plot no: 34 to 37, Phase-2, IDA, APIIC, Pashammylaram, Medak Dist-502307 Andhra Pradesh, India Tel: +08455-224700,224701 www.itwchemin.com

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+1 215-855-8450

www.insulcast.com www.itwpp.com



+1 855-489-7262 www.itwplexus.com www.itwpp.com