

# Circalok™ 6703 Thermally Conductive Silicone Encapsulant

## Description

LORD Circalok™ 6703 thermally conductive silicone encapsulant is a two-component system designed to provide thermal conductivity for encapsulating densely packed power units.

## Features and Benefits

**Low Stress** – exhibits low shrinkage and stress on components as it cures.

**Environmentally Resistant** – provides excellent thermal shock resistance.

**UL Rated** – meets requirements of UL 94 V-O standard; provides excellent flame retardancy.

## Application

**Mixing** – Thoroughly stir each component prior to mixing together. Mix Circalok 6703 A resin with Circalok 6703 B hardener at a 1:1 ratio, by weight. Automatic meter/mix/dispense equipment may be used for high volume production.

Unless a closed-chamber mechanical mixer is used, air will be introduced into the encapsulant system either during mixing or when catalyzing the mixture. Electrical properties of the silicone encapsulant are best when air bubbles and voids are minimized. Therefore, in extremely high voltage or other critical applications, vacuuming may be appropriate.

**Applying** – Apply silicone encapsulant using handheld cartridges or automatic meter/mix/dispense equipment.

Avoid applying Circalok 6703 encapsulant to surfaces that contain cure inhibiting ingredients, such as amines, sulfur or tin salts. If bonding surface is in question, apply a test patch of Circalok 6703 encapsulant to the surface and allow it to set for the normal cure time.

**Curing** – Allow encapsulant to cure for 4 hours at 65°C. This time-at-temperature profile refers to the time the bondline should be allowed to cure once it reaches the target temperature. Allowance should be made for oven ramp rates, parts with large thermal mass and other circumstances that may delay bondline actually reaching the target temperature.

## Typical Properties\*

	<b>6703 A Resin</b>	<b>6703 B Hardener</b>	<b>Mixed</b>
Appearance	Black Paste	White Paste	Light Gray Paste
Viscosity, cps @ 25°C	15,000	6000	8000
Specific Gravity	2.09	1.91	2.0
Gel Time, min @ 66°C	–	–	12-14
Working Life, hr @ 25°C	–	–	1-2

\*Data is typical and not to be used for specification purposes.

# LORD TECHNICAL DATA

## Typical Cured Properties\*\*

Volume Resistivity, ohm-cm @ 25°C ASTM D 257	1 x 10 <sup>14</sup>
Thermal Conductivity, W/mk Hot Disc Transient Method	0.8
Coefficient of Linear Thermal Expansion, ppm/°C ASTM C 864	220
Hardness Shore A	60
Tensile Strength, MPa ASTM D 412	1.38
Elongation at Break, % ASTM D 412	80
Dielectric Strength, V/mil	500
Dielectric Constant @ 25°C 1 MHz, ASTM D 150	4.25
Dissipation Factor, % @ 25°C 1 MHz, ASTM D 150	0.02

\*\*Cure schedule of 1-2 hours at 65°C.

## Shelf Life/Storage

Shelf life of each component is six months from date of manufacture when stored at 25°C in original, unopened container. The material must be periodically rotated within its container to maintain maximum shelf life. Settling will occur if not mixed.

## Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

*For industrial/commercial use only.* Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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