



**2532**

2532 is two-component addition type thermal conductive potting material, room temperature and heating fast cure silicone system. This material has excellent conductivity insulation, flame retardancy, weather and high temperature resistance. 2532 is formulated to function as a bonding, sealing and encapsulating material for electronic components. This material performs at temperatures ranging from -60°C to 210°C.

Technology / Base	Vinylpolydimethyl Siloxane
Type of Product	Silicone Sealant
Components	Two Part
Curing	Room temperature alcohol cure and secondary moisture cure
Appearance / Color	Grey
Consistency	Low Viscosity Liquid

**Features and Benefits**

- Halogen free
- RoHS compliant
- Low odor and non-corrosive
- Excellent thermal conductivity
- Flame retardancy can meet UL94-V0
- High adhesion to a variety of materials including, FRP, FR4, solder mask, glass, aluminum and composites
- Excellent weather and high temperature resistance
- Fast cure when heated

**Technical Data**

Physical Property	Value	Condition/Method
<b>Rheology</b>		
Viscosity, Part A	4000 - 5000 cPs	
Viscosity, Part B	3000 - 4000 cPs	
Viscosity	Low Viscosity Liquid	
<b>Uncured Material Characteristics</b>		
Specific Gravity	1.6	
Volume Mix Ratio	1:1	
Weight Mix Ratio	1:1	
Working Time	1 hr	
Fixture Time		
Cure Schedule	10 min at 120°C, or 40 min at 50°C, or 24hr at 25°C	
<b>Cured Material Properties</b>		
Thermal Service Range	-60°C to 210°C	
Thermal Conductivity	0.8 W/mK	DIN EN 821
Hardness	58 Shore A	GB/T531
Tensile Strength	1.8 MPa	GB/528, 23±2°C 50% RH
Elongation to Break	90%	GB/528, 23±2°C 50% RH
Lap Joint Shear Strength Aluminum		
<b>Electrical Properties</b>		
Volume Resistivity	1.0 x 10 <sup>15</sup> Ωcm	GB/T1692
Breakdown Voltage		

Test Sample Conditions: 2mm Thickness, Cured at 50±2°C for 40min. Tested at 23±2°C



## Typical Applications

- Electronics potting
- Electronics thermal interface material
- Inverter potting
- Power device potting

## Storage and Shelf Life

Product shall be ideally store in a cool, dry area in unopened containers. Material should be stored at a temperature of 8-25°C for a maximum shelf life of 6 months in the original unopened container. Do not return unused material back into the container.

## Curing Conditions

Certain materials, chemicals, curing agents and plasticizers can inhibit the cure of 2530 silicone adhesive. Most notable of these include: organo-tin and other organometallic compounds; silicone rubber containing organo-tin catalyst; sulfur, polysulfides, polysulfones or other sulfur containing materials, amines, urethanes or amine containing materials, unsaturated hydrocarbon plasticizers; some flux residues. Cure performance should be checked on all substrates contacting the adhesive. Cure speed will vary with temperature, relative humidity, depth of material and presence of moisture. Some applications may require special surface preparation. Contact H.B. Fuller Company technical support for additional curing recommendations.

## Safety and Disposal

**For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.**

## General Instructions

- For best performance bond surfaces should be clean, dry and free of any contaminants and oils
- Part A and Part B should be blended respectively before mixing in order to make filling material distribute evenly
- Mix evenly according to the ratio
- Potting must be finished during the working time
- Working time and Cure speed will vary with environment temperature
- Moving after initial gelation and testing after full cure
- Recommended using automatic dispensing equipment to applying the potting compound

## Note

The values noted in this data sheet are typical properties only and are not intended to be used as material specifications. For assistance in writing a material specification, please contact H.B. Fuller Company for further details.

## Ordering Information

Stock No.  
 A: 25320405A, 25kg  
 B: 25320405B, 25kg

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