



## DOWSIL™ TC-6010 Thermally Conductive Encapsulant

DOWSIL™ TC-6010 Thermally Conductive Encapsulant is two-part, flowable, thermally conductive product.

### Features & Benefits

- Two-part material
- Flowable – able to fill and self-level after dispensing
- Versatile heat cure
- Thermally conductive – heat dissipation from sensitive components

### Composition

- Thermally conductive filler
- Polydimethylsiloxane

### Applications

- On-board charger
- Inverter / converter
- Transformer
- Other electronic and electric components

### Application Methods

- Automated or manual mixing and dispensing

### Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Test <sup>1</sup>	Property <sup>2</sup>	Unit	Result
	One Part or Two Part		Two
	Mixing Ratio by Weight		1 to 1
CTM 0176B(ASTM E284)	Color, Part A/B		White/blue
CTM 0050(ASTM D1084)	Viscosity, Part A / Part B / Mixed	mPa·s	2400/2400/2700
CTM 0099(ASTM D2240)	Heat Cure Time <sup>3</sup> at 60°C	minutes	60
	Heat Cure Time at 100°C	minutes	30
CTM 0044(ASTM D70)	Specific Gravity, Part A / Part B at 25°C		1.67/1.66
CTM 0022(ASTM D792)	Specific Gravity, Cured at 25°C		1.67

1. CTM: Corporate Test Method, copies of CTM's are available on request.  
ASTM: American Society of Testing and Materials.
2. Property is in accordance with standard cure condition of 30 minutes at 100°C unless specified.
3. Cure condition needs to be tested and optimized with customer's application and curing environment.

## Typical Properties (Cont.)

Test	Property	Unit	Result
CTM 0055(ASTM D1824)	Pot Life <sup>4</sup> (Working Time) at 25°C	hour	2.5
CTM 0099(ASTM D2240)	Hardness, Shore A		37
CTM 0243(ASTM D1002)	Adhesion Strength on Al @ 60°C*60 min	MPa	0.21
	Adhesion Strength on Al @ 100°C*30 min		0.23
CTM 1163(ASTM 7984)	Thermal Conductivity at 25°C	W/m·K	1.2
CTM 0137(ASTM D412)	Tensile Strength	MPa	0.93
CTM 0137(ASTM D412)	Elongation	%	50
CTM 1098(ASTM D4065)	Shear Modulus by DMA at 25°C	MPa	3.3
CTM 0114(ASTMD149)	Dielectric Strength	kV/mm	22
CTM 0249(ASTM D257)	Volume Resistivity	Ohm·cm	3.20E+12
CTM 0585(ASTM E831)	Coefficient of Thermal Expansion; CTE (-40°C to 150°C)	ppm/K	174
CTM 0112(ASTM D150)	Dielectric Constant at 100 Hz		2.40
	Dielectric Constant at 100 kHz		2.75
CTM 0112(ASTM D150)	Dissipation Factor at 100 Hz		0.0035
UL 94	UL 94 Flammability Classification		V-0

4. Pot Life is described as the time necessary for a system to double in viscosity after catalyzation. This is considered to be the normal useable working time.

### Description

DOWSIL™ TC-6010 Thermally Conductive Encapsulant is a two-component silicone elastomer material. It is designed especially for use in the manufacture of electrical and PCB system assembly products and modules. It cures with heat to form elastic, thermally conductive rubber.

### Mixing and De-airing

Upon standing, some filler may settle to the bottom of the liquid after several weeks. To ensure a uniform product mix, the material in each container should be thoroughly mixed prior to use. Two-part materials should be mixed in the proper ratio either by weight or volume. The presence of light-colored streaks or marbling indicates inadequate mixing. Automated airless dispense equipment can be used to reduce or avoid the need to de-air. If de-airing is required to reduce voids in the cured elastomer, consider a vacuum de-air schedule of > 8 inches Hg (or a residual pressure of 10–0 mm of Hg) for 10 minutes or until bubbling subsides.

### Useful Temperature Ranges

For most uses, silicone encapsulant should be operational over a temperature range of -45 to 150°C (-49 to 392°F) for long periods of time. However, at both the low and high temperature ends of the spectrum, behavior of the materials and performance in particular applications can become more complex and require additional considerations. For low-temperature performance, thermal cycling to conditions such as -55°C (-67°F) may be possible for most products, but performance should be verified for your parts or assemblies. Factors that may influence performance are configuration and stress sensitivity of components, cooling rates and hold times, and prior temperature history. At the high-temperature end, the durability of the cured silicones is time and temperature dependent. As expected, the higher the temperature, the shorter the time the material will remain useable.

<b>Solvent Exposure</b>	In general, the product is resistance to minimal or intermittent solvent exposure, however best practice is to avoid solvent exposure altogether.
<b>Pot Life and Cure Rate</b>	Cure reaction begins with the mixing process. Initially, cure is evidenced by a gradual increase in viscosity, followed by gelation and conversion to a solid elastomer. Pot life is defined as the time required for viscosity to double after Parts A and B (base and curing agent) are mixed and is highly temperature and application dependent. Please refer to the data table.
<b>Handling Precautions</b>	PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.
<b>Usable Life and Storage</b>	The product should be stored in its original packaging with the cover tightly attached to avoid any contamination. Store in accordance with any special instructions listed on the product label. The product should be used by the indicated Exp. Date found on the label.
<b>Limitations</b>	This product is neither tested nor represented as suitable for medical or pharmaceutical uses.
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<b>Disposal Considerations</b>	<p>Dispose in accordance with all local, state (provincial) and federal regulations. Empty containers may contain hazardous residues. This material and its container must be disposed in a safe and legal manner.</p> <p>It is the user's responsibility to verify that treatment and disposal procedures comply with local, state (provincial) and federal regulations. Contact your Dow Technical Representative for more information.</p>
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