



TECHNICAL DATA SHEET

TDS# 2524

DATE: JUNE 2013

BACON INDUSTRIES

ELECTRICALLY CONDUCTIVE ADHESIVE LCA-24

Bacon Industries offers silver-filled epoxy adhesives for making electrical connections in applications where the high temperatures necessary to make soldered connections are detrimental to components. Because these materials are filled with silver, they also have relatively high thermal conductivity.

Adhesive LCA-24 is an excellent all-around system with better strength about 160°F and better long-term conductivity

RECOMMENDED MIXING AND HANDLING PARAMETERS

Adhesive	LCA-24
Activator ¹	BA-9
Parts by weight of activator required per hundred of adhesive	5.00
Work life at 77°F, minutes	60
Recommended cure ¹ , minutes/°F	2/200

TYPICAL PROPERTIES OF CURED ADHESIVE:

Color	Silver
Specific Gravity	2.7
Hardness, Shore D	91
Volume Resistivity, ohm-cm	0.002
After heat aging:	
160°F:	
3 months	0.003
6 months	0.003
200°F:	
3 months	0.006
6 months	0.030
250°F	
3 months	0.070
6 months	0.090
Weight Loss after Six Months	
at 200°F, %	0.09
at 250°F, %	0.21
Bond Strength to aluminum, psi	
at -65°F	1800
at 75°F	1800
at 160°F	1900
at 200°F	2300
at 250°F	1200

(over)

NOTES:

1. Activator BA-9 is supplied in 2.5 cc metal tubes. Eleven drops is equivalent to approximately 0.3 g. One tube is supplied with a 1 oz jar and eight tubes are supplied with an 8 oz jar.

INSTRUCTIONS FOR USE:

Mix well at room temperature, the contents of the adhesive container before removing material. For optimum mixing and mix ratio accuracy, we recommend that batch sizes be not smaller than 25 grams and that the weighing tolerances be within $\pm 5\%$. Add the designated activator to the preweighed adhesive and mix thoroughly. In some applications, warming the substrate to 120°F will aid the flow during application. Cure as indicated.

FOR INDUSTRIAL USE ONLY! WARNING!!

May cause injury to skin following prolonged or repeated contact. Use with adequate ventilation and avoid breathing vapor. See MSDS for more health and safety information.

SHELF LIFE:

The minimum shelf life of Adhesive LCA-24 and Activator BA-9 is at least two years when stored in unopened containers at an average temperature below 85°F.

AVAILABILITY:

Adhesive LCA-24 is available in 1 oz and 8 oz kits, as well as pre-mixed and frozen in Freeze-Paks (see Data Sheet No.