



TECHNICAL DATA SHEET

TDS# 2627

DATE: JUNE 2013

BACON INDUSTRIES

THERMALLY CONDUCTIVE ADHESIVE LCA-127

Adhesive LCA-127 is a thermally conductive, electrically insulating epoxy adhesive. It has a paste consistency and will not run from vertical surfaces.

RECOMMENDED MIXING AND HANDLING PARAMETERS

Adhesive	LCA-127
Activator	BA-49
Parts by weight of activator required per hundred of adhesive	3.83
Consistency	Thixotropic paste (>4000 poise)
Work life at 77°F, minutes	150
Tack-free time at 77°F, hours	7
Recommended cure ¹ , minutes/°F	30/200

TYPICAL PROPERTIES OF CURED ADHESIVE:

Color	Black
Specific Gravity	2.32
Hardness, Shore D	95
Lap Shear Strength to aluminum, psi	
at -65°F	2300
at 77°F	2300
at 150°F	2400
at 200°F	900
Thermal Conductivity (ASTM F433) Btu-in/hr-ft ² -°F	
at 104°F	8.7
at 250°F	8.3
Coefficient of Linear Thermal Expansion (ASTM E831), 10 ⁻⁶ /°F	
between -65°F and 77°F ¹	15
between 77°F and 150°F	22
between 77°F and 212°F	34
ASTM Heat Distortion Temperature (264 psi), °F	170
Glass Transition temperature ¹ , °F	
by DSC	170
by TMA	142
Flexural Strength, psi	12,700

(over)

