

# LOCTITE 3876

December 2016

**PRODUCT DESCRIPTION**

LOCTITE 3876 provides the following product characteristics:

<b>Technology</b>	Acrylate
Appearance - Part A	Pale yellow
Appearance - Part B	Pale blue
Components	Two-component
Product Benefits	<ul style="list-style-type: none"><li>• 175µm spacer beads for bondline thickness control</li><li>• Thermally conductive</li><li>• Ease of use</li></ul>
<b>Cure</b>	Room temperature
<b>Application</b>	Thermal management
Typical Assembly Applications	Transistors, Rectifiers, other power devices and computing applications such as memory chips, chipsets and graphic processor assembly

LOCTITE 3876 self-shimming, bead-on-bead, thermally conductive adhesive is designed to thermally couple and structurally bond heat sinks to heat dissipating electronic components. It is formulated to cure when the two components come into contact with one another, requiring no primer or heat.

LOCTITE 3876 contains glass spacer beads to create uniform bondline, providing consistent thermal properties and a known dielectric value to the interface.

**TYPICAL PROPERTIES OF UNCURED MATERIAL****Part A Properties**

Viscosity, mPa·s (cP):	
@ Speed 2.5 rpm	65,000
@ Speed 20 rpm	32,000
Specific Gravity, g/cc	1.7
Flash Point - See SDS	

**Part B Properties**

Viscosity, mPa·s (cP):	
@ Speed 2.5 rpm	190,000
@ Speed 20 rpm	90,000
Specific Gravity, g/cc	1.7
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE****Fixture Time**

3 to 5 minutes @ 23°C

**Cure Schedule**

24 to 72 hours @ 23°C, 50% RH

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties**

Coefficient of Thermal Expansion, ppm/°C:	
Alpha 1	54
Alpha 2	141
Glass Transition Temperature (T <sub>g</sub> ), °C	28
Thermal Conductivity, ASTM D5470, W/(m·K)	1.76

**TYPICAL PERFORMANCE OF CURED MATERIAL****Shear Strength**

Tensile Shear Strength:	
Grit blasted steel	N/mm <sup>2</sup> 16 (psi) (2,400)
Aluminum	N/mm <sup>2</sup> 13 (psi) (1,900)

Die Shear Strength, kg-f:

@ 25°C:	
Ni/Cu leadframe	60
Ceramic	63
Silicon	68
Mold Compound	34
Contaminated Mold Compound	22
@ 125°C:	
Ni/Cu leadframe	17
Ceramic	11
Silicon	8
Mold Compound	6
Contaminated Mold Compound	6

**TYPICAL ENVIRONMENTAL RESISTANCE**

The ability of LOCTITE 3876 to withstand exposure to a number of severe environments was determined by measuring the change in thermal resistance of a standard test piece.

In these tests, a TO-247 MOSFET was bonded to the subject substrate. The baseline thermal resistance was determined after the material had fully cured.

The numbers referenced below indicated the change in thermal resistance, measured at room temperature, after the test piece had been exposed to the referenced condition for the allotted time.

#### Change in Thermal Resistance (% of Change)

Thermal Exposure , 1,000 hours:

@ 25°C:

Ceramic	4.5
Silicon	-7.6
Mold Compound	-0.3
Contaminated Mold Compound	4.4

@ 125°C:

Ceramic	8.0
Silicon	-3.5
Mold Compound	-0.7
Contaminated Mold Compound	-4.1

Moisture Resistance , 1,000 hrs @ 85°C/85% RH:

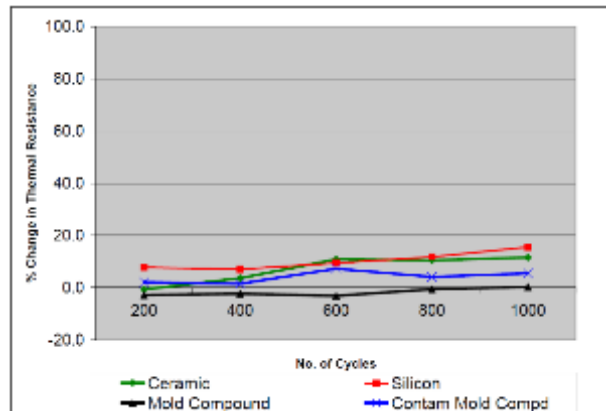
Ceramic	6.5
Silicon	2.5
Mold Compound	-7.1
Contaminated Mold Compound	0.1

Thermal Shock , 15 cycles @ -50 to +150°C (5 mins @ high temp + 5 mins @ low temp per cycle):

Ceramic	2.8
Silicon	0.0
Mold Compound	5.5
Contaminated Mold Compound	3.1

Thermal Cycling , -25 to +125°C temperature cycle, ramp 10°C per minute, 10 minute dwell

#### Profile 1:



#### GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

#### THAWING:

1. LOCTITE 3876 is packed to maintain temperatures between 5 to 10°C during transit.
2. DO NOT open the package before contents reach ambient temperature.
3. A new package of material can be brought to ambient conditions by allowing container to stand at room temperature for 2 hours. Actual time required will vary with package size/volume.
4. DO NOT attempt to thaw by applying additional heat.
5. Do not loosen container lids, caps or covers. Allow syringe packs to equilibrate in tip down orientation..

#### DIRECTIONS FOR USE

1. This two-part adhesive is designed to cure once the two components come into contact with each other. The material fixtures quickly and cures fully in 24-72 hours.
2. For best performance bond surfaces should be clean and free from grease.
3. Apply Part A to the component.
4. Apply Part B to the heat sink.
5. Apply enough material to each side so that there is enough material to cover at least 80% of the surface between the component and the heat sink and the material leaves a small fillet.
6. Best thermal performance is obtained by using a ratio as close to 50:50 as possible.
7. Place the heat sink on top of the component insuring that the beads of material overlap.
8. Secure the assembly and wait for the adhesive to fixture (approx 5 minutes) before further handling.

#### STORAGE:

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

**Optimal Storage: 5 to 10°C. Storage below 5°C or above 10°C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

#### Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{psi} \times 145 = \text{N/mm}^2$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

#### Disclaimer

**Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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**Reference 1**

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