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DeltaBond™ 152 adhesive is ideal for general cementing; thermally bonding semiconductors and components to chassis or heat sinks, while electrically isolating one from the other; fabricating heat sinks or thermal links; and for all permanent bonding of assemblies which require high thermally conductive interfaces. It produces a rigid, high strength bond to most materials when cured. **DeltaBond™ 152** is available in bi-packs, kits, and quarts. Order one bottle of hardener A-4 or B-4 per one quart of **DeltaBond™ 152** separately. Shelf life: 152KA 3 year, all others 3 years.

| DELTA BOND™ 152 | | |
|---|-------------------------|-------|
| Characteristics | Hardener Type | |
| Typical Properties Fully Cured | A4 | B4 |
| Thermal conductivity - W/(m) (°K) | 0.836 | 0.908 |
| (Btu) (in. y/hr) (ft²) (°F) | 5.8 | 6.3 |
| Thermal resistivity - (°C) (in.) watt | 47 | 42 |
| Bond shear strength 77°F | 2,900 | 2,900 |
| 1 in. overlap - psi 125°F | 2,200 | 2,000 |
| etched aluminum to etched aluminum 212°F | 400 | 800 |
| Heat distortion point - °F | 130 | 225 |
| Minimum dielectric strength, v/ml, 0.125 in. sample | 400 | 400 |
| Max operation temp - °C | 65 | 150 |
| | Continuous intermittent | 100 |

| DELTA BOND™ 152 | | |
|--|----------------|---------------|
| Mixing Proportions and Working Properties | | |
| Characteristics | A4 | B4 |
| Parts of hardener per 100 parts of resin by weight | 7.5 | 3.5 |
| *Working Time - at 77°F | 45 min | 30 min |
| †Initial cure time 77°F | 8 hrs | 6 hrs |
| 150°F | 45 min | 30 min |
| 250°F | 20 min | 15 min |
| ‡Post-cure time at a temp in °F | 4 hrs @200°F | 4 hrs @ 200°F |
| ‡Alternate room temp. aging time at 77°F | 4 days | 4 days |
| Working consistency (77°F) | viscous liquid | paste |
| Working viscosity (77°F) cps | 25,000 | — |

| DELTA BOND™ 152 | | | |
|-------------------------------------|----------|-----------------------------------|---|
| Ordering Guide - Resin and Hardener | | | |
| Model Number | Resin | | Hardener |
| | Part No. | Container | Part Number |
| DeltaBond™ 152 | 152-1A | Bi-Pack (1 oz) | Included in PIN 152-1 A ("A-4") Type |
| | 152-1B | Bi-Pack (1 oz) | Included in P/N 152-1 B ("B-4") Type |
| | 152-KA | Kit (7 oz Resin, 0.5 oz Hardener) | Included in P/N 152-KA |
| | 152-Q | 1 quart (4 lbs) | A-4 (0.316 lb), B-4 (0.14 lb), (order 1 only) |

All hardener part numbers A-4, B-4

NOTES:

* Since the hardener/resin reaction is exothermic, it is important that batch size be matched to hardener speed. Working times given are for approximate batch sizes: A—200 gms, B—200 gms. Larger batch sizes will greatly reduce working time.

** For optimum electrical properties, dry parts for 15 minutes at 150°F (65°C) or 30 minutes at 75°F (24°C) to slowly evaporate the thinner and then final cure for 4 hours at 275°F (135°C).

† After initial cure, material may be handled, removed from fixture, etc., but has not yet achieved full properties and should be room temperature aged or post-cured as shown to achieve full physical and electrical properties.

‡ After initial cure, material may be brought to full physical and electrical properties during post-cure or may be room temperature aged for charted length of time to achieve same full properties.

The information contained herein is based on data believed to be reliable but we do not assume responsibility for accuracy. All such information is used at the customer's own risk conditions of use being beyond our control.

Series 120 | Series 126 | Series DeltaBond 152 | Series DeltaBond 153 | Series DeltaBond 154 | Series DeltaBond 155

152-1A 152-1B 152-KA 152-Q

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| | Continuous intermittent | 100 |

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| | |
|----------------------|--------------------------------------|
| Standard P/N | 152-1A |
| Resin Container Size | Bi-Pack (1 oz) |
| Hardener Part Number | Included in PIN 152-1 A ("A-4") Type |