

Technical data sheet



Product: 8329TFS

Manufacturer: MG CHEMICALS

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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8329TFS THERMALLY CONDUCTIVE ADHESIVE

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8329TFS



Thermally Conductive Adhesive

8329TFS is a 2-part, heat-cure, thermally conductive epoxy adhesive with a 4-hour working time. It is a dark grey, smooth, thixotropic paste that cures to form a hard, durable polymer that is thermally conductive, yet electrically insulating.

This thermally conductive adhesive is used to glue heatsinks to LED's, CPU's, and other heat-generating components.

This product cures slowly. For a faster cure version, use 8329TFF or 8349TFM.



Features & Benefits

- High thermal conductivity
- Long working time
- Provides strong electrical insulation
- Bonds well to a wide variety of substances
- Strong resistance to humidity, salt water, mild bases, and aliphatic hydrocarbons

Cured Properties

Resistivity	$1.0 \times 10^{12} \Omega \cdot \text{cm}$
Hardness	68 D
Tensile Strength	4.2 N/mm ²
Compressive Strength	42 N/mm ²
Lap Shear (stainless steel)	5.0 N/mm ²
(aluminum)	6.3 N/mm ²
Glass Transition Temperature (T_g)	9 °C
CTE Prior T_g	47 ppm/°C
CTE After T_g	164 ppm/°C
Thermal Conductivity @ 25 °C	1.2 W/(m·K)
Service Temperature Range	-40–150 °C

Available Packaging

Cat. No.	Packaging	Net Vol.	Net Wt.
8329TFS-25ML	Dual Syringe	25 mL	52.2 g
8329TFS-50ML	Dual Cartridge	45 mL	94 g

Usage Parameters

Working Time	4 h
Mix Ratio by Volume	1:1
Mix Ratio by Weight	1:0.96

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Uncured Properties

Mixed Density	2.1 g/mL
Viscosity @ 25 °C	(A) N/A
	(B) 700 Pa·s
Shelf Life	>3 y

Application Instructions

Read the product SDS before using this product (downloadable at www.mgchemicals.com).

Recommended Preparation

Clean the substrate with Isopropyl Alcohol, MG #824, so the surface is free of oils, dust, and other residues.

Syringe or Cartridge

1. Twist and remove the cap from the syringe or cartridge. Do not discard cap.
2. Dispense a small amount to ensure even flow of both parts. A manual or pneumatic dispensing gun is required for a 50 mL cartridge.
3. (Optional) Attach a static mixer.
 - a. Dispense and discard 3 to 5 mL of the product to ensure a homogeneous mixture.
 - b. After use, dispose of static mixer.
4. Without a static mixer, dispense material on a mixing surface or container, and thoroughly mix parts A and B together.
5. To stop the flow, pull back on the plunger.
6. Clean nozzle to prevent contamination and material buildup.
7. Re-place the cap on the cartridge or syringe.

Dispensing Accessories

Consult the table below for accessory selection. See the Dispensing Accessories Application Guide for usage instructions. 8MT-50-FT should only be used with a pneumatic dispenser.

Cat. No.	Dispensing Gun	Static Mixer
8329TFS-25ML	N/A	N/A
8329TFS-50ML	8DG-50-1-1	8MT-50, 8MT-50-FT

Cure Instructions

The product will not cure at room temperature. Cure the adhesive in an oven at one of these time/temperature options:

Temperature	65 °C	80 °C	100 °C
Time	3 hours	80 minutes	30 minutes

Storage and Handling

Store between 16 and 27 °C in a dry area, away from sunlight (see SDS). To maximize shelf life, recap product firmly when not in use.

Disclaimer

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