

**NovaTherm™ 600 Series 600-325  
2 Part Thermal Gap Filler  
Specification Data**



**DESCRIPTION**

NovaTherm 600 Series 600-325 is a two-component, addition cure silicone gap filler designed for thermally conductive applications. NovaTherm 600-325 cures at room temperature with accelerated cure under heat to form an elastomeric interface material.

**APPLICATIONS**

- EV/HEV/PHEV battery modules
- Power Systems – IGBT & power supplies
- Servers – ASCIS, DSP, microprocessor with heat sinks or cold plates
- LED Lighting – Panels & modules
- Telecommunications – Fiber optics, satellite, ACARS
- DC/DC converters
- Solar, junction boxes, AC/DC inverters

**FEATURES & BENEFITS**

- Easily dispensable
- Convenient 1:1 mix ratio by weight
- Room temperature heat accelerated cure
- Excellent reworkability
- Vibration damping and shock absorption
- Great wetting capability

**INSTRUCTIONS**

This material is shipped in separate containers labeled Part A and Part B. While the material may be mixed by hand, it is more appropriate to use automated meter-mixing equipment. The compound is designed with a 1:1 by volume or weight mix ratio. Automated mixing equipment eliminates the need for a deaeration cycle. If mixing by hand, add equal parts of parts A and B into an appropriately sized mixing vessel and mix thoroughly. De-air before final application.

**PRODUCT SPECIFICATIONS\***

Physical Property	Test Method	Performance Range
Format (One or Two Part)		Two Part
Form		Paste
Cure Chemistry		Addition Cure
Appearance – Part A	Visual	White
Appearance – Part B	Visual	Green-Yellow
Viscosity @ 10s <sup>-1</sup> (cPs) - Part A	ASTM D5099	110,000
Viscosity @ 10s <sup>-1</sup> (cPs) - Part B	ASTM D5099	60,000
Viscosity @ 10s <sup>-1</sup> (cPs) - Mixed	ASTM D5099	85,000
Density at 25°C (g/cm <sup>3</sup> )	ASTM D792	3.3
Mixed Ratio		1:1
Working Time (Pot Life)		>1 hour

**TYPICAL CURED PROPERTIES\***

Physical Property	Test Method	Typical Value
Durometer Hardness (Shore A)	ASTM D2240	76
Appearance (Mixed)	Visual	Lime Green
Dielectric Strength (kV/mm)	ASTM D149	8.0
Dielectric Constant @ 100Hz	ASTM D150	6.2
Dissipation Factor @ 100Hz	ASTM D150	0.0565
Thermal Conductivity (Tc) (W/mK)	ASTM D5470	2.5
Volume Resistivity @ 100V (Ohms-cm)	ASTM D257-14	1.3 x 10 <sup>16</sup>

\* The values outlined reflect testing that was conducted under laboratory conditions, actual results may vary.

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**PROCESSING RECOMMENDATIONS:**

**COMPATIBILITY**

NovaTherm 600-325 will cure in contact with most clean, dry surfaces. However, certain materials, such as butyl and chlorinated rubber, sulfur containing materials, amines, and certain metal soap cured RTV silicone rubber compounds can cause inhibition. Cure inhibition is characterized by a lack of cure of the product at the interface of the silicone rubber and the substrate.

It is recommend that a sample patch test be performed with NovaTherm 600-325 to determine if a barrier coating or other inhibition preventing measures are necessary before pouring the product.

**MIXING**

Remixing Part A and Part B separately is essential if it is observed that the filler is settling prior to 1:1 mixing for your intended application. Please contact your sales representative with specific questions.

**CUSTOMIZATION**

In addition to the current formulations offered Novagard has the technical expertise in-house to make necessary modifications to the chemical and physical properties and performance capabilities for a specific application. No two applications are the same and, as such, Novagard is capable of making the necessary customization listed below for an optimal solution.

**Uncured:**

- Viscosity
- Thixotropy
- Pot life
- Color
- Working time

**Cured:**

- Shore hardness
- Tensile strength
- Adhesion
- Elongation
- Thermal conductivity

Contact Novagard at (216) 881-8111 or [products@novagard.com](mailto:products@novagard.com) for details.

**PACKAGING**

Consult your Novagard representative for packaging options.

**STORAGE AND SHELF LIFE**

The shelf life will be indicated by the “use before date” on the associated documents and is 12 months when stored in the original unopened containers at a temperature below 27°C.

**PRECAUTIONS**

Certain materials, chemicals, curing agents, and plasticizers may inhibit the cure. The most notable are organo-tin catalysts, amino compounds, polysulfide, and other sulfur-containing materials. Do not use in or around highly oxidative chemicals such as liquid oxygen, chlorine, or peroxides.

Consult and obey all applicable local, state, and federal regulations for disposal of solvent and silicone waste. For additional information consult product SDS.

**ADDITIONAL INFORMATION**

Novagard believes that the information provided is a true and accurate description of the typical characteristics of the aforementioned product; however, it is the responsibility of the individual user to thoroughly test the product in their specific application to determine performance, efficacy, and safety.