



Outgassing

One concern some users of adhesives and coatings have is outgassing. Under conditions of heat, vacuum, or both, a plastic material can exhibit loss in weight due to gaseous emission. Outgassing data is often a requirement before electronic, aerospace and defense, space, or optical companies will consider a new adhesive.

Severe outgassing could be a concern for any or all of the following reasons:

- Outgassing could be indicative of decomposition or a change in the structure of a substrate, coating, or adhesive.
- Vapor deposition on a surface which must remain clean to retain its electrical properties.
- Vapor depositions could conceivably indicate potential corrosion, plastics crazing, or other surface weakening mechanisms.
- Contamination of the environment the part is used in.

One widely accepted outgassing standard is ASTM E595. This testing is run at 125°C (257°F) under a 5×10^{-5} Torr vacuum for 24 hours. The total weight loss (TML) and condensable volatile material (CVCM) are measured.

CVCM is of particular interest to avionics or optoelectronic applications. It might be indicative that optical parts could become fogged, electrical continuity lost, or some other effect caused by material being deposited where it is not intended.

The below products have been tested to the ASTM E595 standard and meet the TML and CVCM thresholds historically used as screening for spacecraft materials:

Adhesive Tested	Product Type	Total Weight Loss* (TML), %	Volatile Condensable Material (CVCM), %
9801	Low Shrinkage Active Alignment Epoxy	0,37	0,01
9803	Low Shrinkage Active Alignment Epoxy	0,23	0,01
9771	Light + Moisture Conformal Coating	0,90	0,02
9773	Staking & Ruggedizing Adhesive	0,86	0,04
9900-AA	Low Shrinkage Active Alignment Epoxy	0,37	0,01
9906-AA	Low Shrinkage Active Alignment Epoxy	0,23	0,01
Screening Level		1,00 maximum	0,10 maximum

* Estimated to be primarily entrapped air or moisture.

In some applications, meeting the spacecraft thresholds may not be a requirement but low TML and CVCM are still needed or preferred. Please see additional products tested below that are often used in electronic, aerospace, or optical applications:

Adhesive Tested	Product Type	Total Weight Loss* (TML), %	Volatile Condensable Material (CVCM), %
3069	Flexible Laminating and Bonding Adhesive	4,21	0,01
3094-T-REV-A	Low-Stress Plastic Adhesive	4,90	0,24
3099	Acrylic Bonding Adhesive	2,53	0,04
6-621-VT	Multi-Cure® Dissimilar Substrate Adhesive	3,45	<0,01
6-621-VT-RF	Multi-Cure® Dissimilar Substrate Adhesive	3,48	<0,01
6-630	Multi-Cure® Dissimilar Substrate Adhesive	4,18	0,08
729	Plating and Harsh-Chemical Maskant	3,36	0,03
7501-T-UR-SC	LED-Curable Dissimilar Substrate Sealant	3,74	0,15
9451	True Black Multi-Cure® Conformal Coating	2,36	<0,01
9482	Light + Moisture Conformal Coating	3,15	0,54
9483	Light + Moisture Conformal Coating	2,02	0,13
984-LVF **	Multi-Cure® Conformal Coating	5,55	0,04
984-LVF ***	Multi-Cure® Conformal Coating	4,75	0,03
OP-24-REV-B	Multi-Cure® Dissimilar Substrate Adhesive	2,12	0,02
OP-60	Low Shrinkage Optical Positioning Adhesive	1,87	0,09
OP-61-LS	Low Shrinkage Optical Positioning Adhesive	3,34	0,03
OP-67-LS	Low Shrinkage Optical Positioning Adhesive	1,92	0,10
9037-F	Blue Fluorescing Encapsulant with Secondary Heat Cure	3,64	0,02
9309-SC	BGA & CSP Reinforcement Adhesive with See-Cure Technology	3,44	0,07

* Estimated to be primarily entrapped air or moisture.

** Reference: Hughes Aircraft Corp., UV-curable conformal coating material evaluation; J. Lum, 1992.

*** Testing done following post bake of 160°F for four hours.

© 1997-2025 Dymax Corporation. All rights reserved. All trademarks in this guide, except where noted, are the property of, or used under license by Dymax Corporation, U.S.A.



www.dymax.com

Technical data provided is of a general nature and is based on laboratory test conditions. Dymax Europe GmbH does not warrant the data contained in this bulletin. Any warranty applicable to products, its application and use is strictly limited to that contained in Dymax Europe GmbH's General Terms and Conditions of Sale published on our website. Dymax Europe GmbH does not assume any responsibility for test or performance results obtained by users. It is the user's responsibility to determine the suitability for the product application and purposes and the suitability for use in the user's intended manufacturing apparatus and methods. The user should adopt such precautions and use guidelines as may be reasonably advisable or necessary for the protection of property and persons. Nothing in this bulletin shall act as a representation that the product use or application will not infringe a patent owned by someone other than Dymax Corporation or act as a grant of license under any Dymax Corporation Patent. Dymax Europe GmbH recommends that each user adequately test its proposed use and application of the products before actual repetitive use, using the data contained in this bulletin as a general guide. TB097EU 9/29/2025