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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2332

November 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2332 provides the following product characteristics:

Technology	Epoxy
Appearance	Black
Cure	Heat cure
Product Benefits	• One component • Excellent adhesion • Non-conductive • Low temperature cure • High strength
Application	Non-conductive adhesive
Operating Temperature	-40 to 150 °C
Surfaces	Copper, Aluminum, Nickel, FRP and Rigid plastics

LOCTITE ABLESTIK 2332 is a solventless epoxy adhesive that develops high bond strength when cured at temperatures as low as 100°C. This product combines toughness at low temperatures plus high peel and tensile shear strengths over a very broad temperature range.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	65,000 to 85,000
Specific Gravity	1.17 to 1.23
Shelf Life @ 0 to 8°C, months	6

Flash Point - See SDS

TYPICAL CURING PERFORMANCE Cure Schedule

1 hour @ 120°C

Alternative Curing Conditions

90 minutes @ 100°C or
30 minutes @ 120°C or
20 minutes @ 150°C

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 , K^{-1}		100×10^{-6}
Glass Transition Temperature (Tg) by TMA, °C		105
Hardness, Shore D		
@ 25ºC		75
@ 120ºC		30
Tensile Modulus, DMTA :		
@ 50 °C	N/mm² (psi)	1,043 (151,235)
@ 100 °C	N/mm² (psi)	508 (73,660)
@ 150 °C	N/mm² (psi)	20 (2,900)
@ 200 °C	N/mm² (psi)	10 (1,450)
Linear Shrinkage, %		2.3

Electrical Properties:

Volume Resistivity, ohm-cm @ 25ºC	6×10^{14}

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Aluminum:		
Tested @ 25 °C	N/mm² (psi)	20.4 (2,960)
Tested @ 90 °C	N/mm² (psi)	15.3 (2,220)
Tested @ 125 °C	N/mm² (psi)	12.5 (190)
Tested @ 150 °C	N/mm² (psi)	4.9 (710)
PBT:		
Tested @ 25 °C	N/mm² (psi)	6.0 (870)
Tested @ 125 °C	N/mm² (psi)	3.1 (450)
Tested @ 150 °C	N/mm² (psi)	1.2 (175)

GENERAL INFORMATION

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

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STORAGE:
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 0 to 8°C. Storage greater than or below 0 to 8°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
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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