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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2113 BIPAX

December 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2113 BIPAX provides the following product characteristics:

Technology	Epoxy
Appearance	Transparent
Cure	Room Temperature or Heat Cure
Product Benefits	• Transparent • Low viscosity • Solvent-free • Room temperature cure capability • Excellent flow properties • Excellent wetting properties • Electrically Insulating • Good chemical resistance • Provides environmental protection
Application	Non-conductive adhesive
Operating Temperature	-60 to 130ºC
Mix Ratio - Resin : Hardener	100 : 11
Surfaces	Glass, Ceramics, Metals and Plastics
Typical Assembly Applications	Fiber optic, Structural laminating or High performance aerospace and electronic applications

LOCTITE ABLESTIK 2113 BIPAX epoxy adhesive is recommended for applications where an initial low viscosity and near transparent color are required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties

Mixed Viscosity @ 25 ºC, mPa·s (cP)	300
Thixotropic Index	1.0
Specific Gravity	1.16
Pot life, minutes	30
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

24 hours @ 25°C or
4 hours @ 65°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

Hardness, Shore D	88
Glass Transition Temperature (Tg), °C	77.0
Coefficient of Linear Thermal Expansion, ppm/ºC	60
Izod Impact Strength, ft-lb/in. of notch	0.24

Electrical Properties

Dielectric Strength, volts/mil	410
Dielectric Constant / Dissipation Factor @ 25ºC:	
@ 1 KHz	4.3/0.02
Volume Resistivity, ohms-cm:	
@ 25 °C	6.00×10^{13}
@ 100 °C	1.0×10^{10}

TYPICAL PERFORMANCE OF CURED MATERIAL

Sample cured 2 hours @ 65°C

Shear Strength

Lap Shear Strength :		
Aluminum to aluminum	N/mm²	15
	(psi)	(2,200)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
2. Remove clamp and thoroughly mix the LOCTITE ABLESTIK 2113 BIPAX epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout
3. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured
4. Some ingredients in this formulation provided in BIPAX, TRA-PAX and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 52ºC for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

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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 : ≤27 °C

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

Disclaimer
Note:
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Reference 1

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