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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2115 BIPAX

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2115 BIPAX provides the following product characteristics:

Technology	Epoxy
Color	Clear
Cure	Room temperature cure or Heat cure
Operating Temperature	-70 to 100 °C
Product Benefits	• Low viscosity • Low shrinkage • Excellent mechanical shock resistance • Excellent temperature cycling performance
Mix Ratio, by weight - Resin : Hardener	100 : 30
Application	Assembly
Typical Optic Application	Laser fabrication and Other optic applications
Substrates	Glass, Rigid plastics, Ceramic and Metals

LOCTITE ABLESTIK 2115 BIPAX is an excellent choice for bonding optical components where alignment accuracy is essential. It is capable of withstanding 30 seconds of 60watt direct laser energy. This adhesive h as been used in cycling applications down to 4¦K.

LOCTITE ABLESTIK 2115 BIPAX bonds offer resistance to water and weathering, ozone, most petroleum solvents, mild acids and alkalis and other chemicals.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index	1.0
Viscosity @ 25 °C, cP:	
After Mixing	250
Specific Gravity, mixed	1.22
Pot Life , hours	2
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

24 hours @ 25°C

Alternative Cure Schedule

1 to 2 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

Coefficient of Thermal Expansion, cm/cm/ºC	5.50×10^{-05}
Glass Transition Temperature (Tg), °C	55
Hardness, Shore D	78
Refractive Index	1.55
Izod Impact Strength, ft-lb/in. of notch	0.22

Electrical Properties

Volume Resistivity, ohm-cm @ 25ºC	9.00×10^{08}
Dielectric Strength, volts/mil	430
Dielectric Constant @ 25ºC :	
1kHz	4.8
Dissipation Factor @ 25ºC:	
1kHz	0.01

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous

Lap Shear Strength, psi:

Substrate	
Aluminum to Aluminum	3800

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
2. Remove clamp and thoroughly mix the LOCTITE ABLESTIK 2115 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 separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use
5. 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
The expiration date for pre-mixed and frozen materials is based upon dry storage conditions at or below the temperature indicated on each package. 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. Contents may separate during storage. Resin or hardener in bulk containers (e.g., quarts, gallons) should be thoroughly mixed prior to combining them to obtain all the benefits of the properties designed into the formulation.

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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