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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2135D BIPAX

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2135D BIPAX provides the following product characteristics:

Technology	Epoxy
Color	Light amber
Cure	Room temperature cure or Heat cure
Components	Two-components
Product Benefits	• Easy mixing • Good wetting • High impact strength • Excellent mechanical, impact and shock resistance • Excellent environmental resistance
Mix Ratio, by weight - Resin : Hardener	100 : 60
Operating Temperature	-60 to 100 °C
Application	Assembly
Typical Assembly Applications	Bonding, Laminating, Sealing and Structural repair
Substrates	Metals, Ceramic, Wood, Concrete, Phenolics, Polyester, Epoxy, Many urethanes and Other plastics

LOCTITE ABLESTIK 2135D BIPAX is a medium viscosity, two-part, room temperature curing epoxy adhisive that bonds a wide variety of materials

LOCTITE ABLESTIK 2135D BIPAX is a tough, durable, electrically insulating adhesive with excellent mechanical, impact and shock resistance properties after fully cured

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Viscosity @ 25 ºC, mPa·s (cP)	1,200
Specific Gravity, mixed	1.11
Pot Life , minutes	60

TYPICAL CURING PERFORMANCE Cure Schedule

24 hours @ 25°C

Alternative Cure Schedule

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

Coefficient of Expansion, cm/cm/ºC	5.5×10^{-5}
Glass Transition Temperature (Tg), °C, ultimate	54
Hardness, Shore D	70
Reactive solids contents, %	100

Electrical Properties

Volume Resistivity @ 25ºC, ohm-cm	2.7×10^{13}
Dielectric Strength, volts/mil	435
Dielectric Constant / Dissipation Factor @ 25ºC: @ 1 KHz	3.68/0.02

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Aluminum to Aluminum:

24 hours @ 25ºC	N/mm²	1.61
	(psi)	(234)
4 hours @ 65ºC	N/mm²	20
	(psi)	(2,888)

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 2135D 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:
The expiration date is based upon dry storage conditions at or below 27ºC, unless specified otherwise on the packaging, in the original, sealed and unopened containers for BIPAX, TRA-PAX and bulk packaged materials. The expiration date for pre-mixed and frozen materials is based upon dry storage conditions at or below the temperature indicated on each package. 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

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Reference N/A

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