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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2248 BIPAX

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2248 BIPAX provides the following product characteristics:

Technology	Epoxy
Appearance	Tan
Cure	Heat cure
Product Benefits	• Thixotropic • Good toughness • High temperature properties • Excellent impact resistance • Excellent thermal shock resistance • Low permeability to gases and vapors • Easy mixing • Easy handling
Application	Staking compound
Operating Temperature	-60 to 190ºC
Mix Ratio, by weight - Resin : Hardener	100 : 19.4
Surfaces	Metals, Glass, Ceramics and Plastics

LOCTITE ABLESTIK 2248 BIPAX bonds offer resistance to water, weather, ozone, most petroleum solvents, fuels, mild acids and alkalis and other organic and inorganic compounds.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties:

Mixed Viscosity, Brookfield - LV #4 , 25 °C, mPa·s (cP):	
Speed 12 rpm	10,000
Specific Gravity	1.2
Pot life, hours	2
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

1 hour @ 100°C

An additional post cure of 2 hours @ 125ºC is recommended when application temperatures higher than 125ºC are anticipated.

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	87
Glass Transition Temperature (Tg), °C	109.0
Water Absorption (24 hr immersion), %	0.001
Coefficient of Expansion, ppm/°C	50
Izod Impact Strength, ft-lb/in. of notch	0.52
Elongation, %	2
Heat Distortion Temperature, ºC	148

Electrical Properties

Dielectric Strength, kV/mm	14.8
Dielectric Constant / Dissipation Factor @ 25ºC: @ 1 KHz	4.35/0.02
Volume Resistivity, ohm-cm @ 25ºC	2.50×10^{15}

Outgassing Properties

Outgassing ASTM E 595-90	Passes

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :		
Al to Al	N/mm²	17.9
	(psi)	(2,600)
Tensile Strength	N/mm²	72.4
	(psi)	(10,500)

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 2248 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 50ºC 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:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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Reference 1

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