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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 2907

October 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2907 provides the following product characteristics:

Technology	Epoxy
Appearance	Silver
Filler Type	Silver
Cure	Room Temperature or Heat Cure
Components	Two component - requires mixing
Product Benefits	• Electrically conductive • Thermally conductive • Medium viscosity • Two component • Room temperature cure • Solvent-free • Free of copper or carbon additives • Bond dissimilar substrates
Typical Assembly Applications	Electrical modules, Printed circuitry, Wave guides, Flat cables and High frequency shields
Application	Assembly, Bonding, Sealing or Repair
Surfaces	Metals, Ceramics, Glass and Plastic laminates

LOCTITE ABLESTIK 2907 is designed for electronic bonding and sealing applications that require a combination of good mechanical and electrical properties. It can also be used as a "cold solder" for heat sensitive components where hot soldering is impratical.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Viscosity, mPa·s (cP) :	
cp #52, 10 rpm	6,500
Thixotropic Index (1/10 rpm)	3.5
Pot life , minutes	100
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

10minutes @ 100°C or
2 hours @ 65°C or
24 hours @ 25°C

The above cure profile is a guideline recommendation. 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

Glass Transition Temperature (Tg), ultimate, °C	50
Coefficient of Expansion, ppm/°C	$4.90\times10^{+01}$
Hardness, Shore D:	
10minutes @ 100ºC	87
2hours @ 65ºC	88
24hours @ 25ºC	85

Electrical Properties

Volume Resistivity @ 25ºC, ohm-cm:	
Sample cured 10 minutes @ 100ºC	3×10^{-04}
Sample cured 2 hours @ 65ºC	4×10^{-03}
Sample cured 24 hours @ 25ºC	8×10^{-03}

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :		
Aluminum to aluminum:		
Cured @ 100 °C for 10 minutes	N/mm²	9.0
	(psi)	(1,300)
Cured @ 65 °C for 2 hours	N/mm²	10
	(psi)	(1,500)
Cured @ 25 °C for 24 hours	N/mm²	8.0
	(psi)	(1,200)

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. If packaged in BIPAX, remove clamp and thoroughly mix the LOCTITE ABLESTIK 2907 epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout.
3. If pre-mixed and frozen, thaw adhesive to room temperature. A ºC water bath is recommended.
4. 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.
5. Cure at recommended cure schedules.

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.

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

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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
N/mm² x 145 = psi
MPa = N/mm²
MPa x 145 = psi
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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Americas
+1.888.943.6535

Europe
+32.1457.5611

Asia
+86.21.3898.4800

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