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LOCTITE

Technical Data Sheet

LOCTITE ABLESTIK 64C

December 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 64C provides the following product characteristics:

Technology	Epoxy
Technology (Part B)	Amine
Appearance, Resin (Component A)	Dark gray paste
Appearance, Hardener (Component B)	Clear liquid
Components	Two component - requires mixing
Mixing Ratio, by weight Component A: Component B	100 : 5
Product Benefits	• Low cost • General purpose • Two component • Non-silver filled • Electrically conductive • Easy application • Protect surfaces against sea water corrosion
Cure	Room temperature or Heat cure
Application	Assembly
Operating Temperature Range	-55 to +130ºC

LOCTITE ABLESTIK 64C non-silver, electrically condutive adhesive is designed for a wide variety of applications. It is special recommended for use where exposure to sea water causes silver based electrically conductive adhesives to corrode.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Density , g/cm³	3.2
Shelf Life @ 25°C, days	180
Flash Point - See SDS	

Part B Properties

Density , g/cm³	1.0
Shelf Life @ 25ºC , days	180

Mixed Properties

Density , g/cm³	3.2
Work Life @ 25 °C, 100 gram mass, minutes	40
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

1 hour @ 70°C
24 hours @ 25°C

For optimum performance, follow the initial cure with a post cure of 2 to 4 hours at the highest expected use temperature.

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 , TMA, ppm/°C	45
Thermal Conductivity , W/(m-K)	1.44

Electrical Properties

Volume Resistivity @ 25ºC, ohm-cm	0.02

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous:

Tensile Lap Shear Strength	N/mm²	5.5
	(psi)	(800)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. 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.
3. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
4. Blend components by hand, using a kneading motion, for 2 to 3 minutes and scrape the bottom and sides of the mixing container frequently to produce a uniform mixture.
5. Apply adhesive to all surfaces to be bonded and join together.
6. In most applications only contact pressure is required.

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 in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

Optimal Storage : 25 °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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