

LOCTITE ABLESTIK 144A P2

December 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 144A P2 provides the following product characteristics:

Technology	Epoxy
Appearance	Black paste
Cure	Heat cure
Product Benefits	• One component • Good adhesion strength • High viscosity • Low sag • Good chemical resistance • Good thermal resistance
Application	Non-conductive adhesive
Operating Temperature	-60 to 200 °C
Surfaces	Metals, Glass and Plastics

LOCTITE ABLESTIK 144A P2 adhesive is designed for use in automated assembly and in-line curing operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density, g/cm ³	1.55
Viscosity @ 25 °C, mPa·s (cP)	120,000
Sag Test, %	<50
Work Life @ 25°C, days	3
Shelf Life (from date of manufacture):	
@ -25 to -18°C, days	183
@ 18 to 25°C, days	3
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

8 minutes @ 180°C
30 minutes @ 150°C
1 hour @ 120°C
4 hours @ 80°C

For optimum performance at temperature above 2 to 4°C, a post cure of hours at °C is recommended.

This product may generate excessive heat if cured in thicknesses greater than 6 mm (0.236 inch) at a temperature above 120°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 Linear Thermal Expansion, ppm/°C	40
Glass Transition Temperature (T _g), °C	110
Hardness, Shore D	90

Electrical Properties

Volume Resistivity, ohm-cm @ 25°C	1×10 ¹⁴
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TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Tensile Lap Shear Strength :

Al to Al:	
Tested @ 25 °C	N/mm ² 17 (psi) (2,470)
Tested @ 100 °C	N/mm ² 15 (psi) (2,180)
Tested @ 150 °C	N/mm ² 8 (psi) (1,160)
Tested @ 200 °C	N/mm ² 3 (psi) (435)

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. 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

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 : -25 to -18 °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 $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$ $\text{kV/mm} \times 25.4 = \text{V/mil}$ $\text{mm} / 25.4 = \text{inches}$ $\text{N} \times 0.225 = \text{lb}$ $\text{N/mm} \times 5.71 = \text{lb/in}$ $\text{psi} \times 145 = \text{N/mm}^2$ $\text{MPa} = \text{N/mm}^2$ $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$ $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$ $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$ $\text{mPa}\cdot\text{s} = \text{cP}$ **Disclaimer****Note:**

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