

**LOCTITE ABLESTIK 342-37**

February 2020

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK 342-37 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Cure</b>	Heat cure and Room temperature cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>Room temperature cure</li> <li>Thermal shock resistant</li> </ul>
<b>Application</b>	General assembly
<b>Filler Type</b>	Silica
<b>Operating Temperature</b>	-55 to 150°C

LOCTITE ABLESTIK 342-37 epoxy adhesive is designed for applications requiring outstanding thermal shock properties. LOCTITE ABLESTIK 342-37 adhesive may be used to bond semi-porous materials such as ferrites, where a physical rather than a chemical bond is required.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Thixotropic Index	5.25
Viscosity, mPa·s (cP):	
@ Speed 5.0 rpm, In-process check by production at beginning of syringe filling	25,000
Heat Cycle, °C	150
Shelf Life @ -40°C (from date of manufacture), days	365
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE****Cure Schedule**

2 hours @ 65°C

**Alternate Cure Schedule**

48 hours @ 25°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**

Hardness, Shore D	85
Coefficient of Thermal Expansion, , TMA, ppm/°C:	
alpha 1 (-55 to 79°C)	39
alpha 2 (79 to 150°C)	15
Glass Transition Temperature(Tg), °C	79
Thermal Conductivity @ 121°C, W/(m-K)	0.29

**Outgassing Properties**

Outgassing , TGA:

Sample cured 120 minutes @ 93°C

@ 100°C, % 0.03

@ 250°C, % 0.55

**Electrical Properties**Volume Resistivity , ohms-cm 26×10<sup>14</sup>

Dielectric Strength, kV/mm 28

Dielectric Constant @ 1KHz 4.1

**TYPICAL PERFORMANCE OF CURED MATERIAL****Miscellaneous**

Lap Shear Strength :

Al to Al @ 25°C	N/mm <sup>2</sup>	9.65
	(psi)	(≥1,400)

**GENERAL INFORMATION**

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

**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 : -40 °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** $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$  $\text{kV/mm} \times 25.4 = \text{V/mil}$  $\text{mm} / 25.4 = \text{inches}$  $\text{N} \times 0.225 = \text{lb/F}$  $\text{N/mm} \times 5.71 = \text{lb/in}$  $\text{psi} \times 145 = \text{N/mm}^2$  $\text{MPa} = \text{N/mm}^2$  $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$  $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$  $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$  $\text{mPa}\cdot\text{s} = \text{cP}$ **Disclaimer****Note:**

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