

LOCTITE ABLESTIK 5074

July 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 5074 provides the following product characteristics:

Technology	Epoxy Film
Appearance	White
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • Flexible • Reworkable • Uniform bondline control • Custom preforms available • Bonds to a wide variety of substrates
Application	Assembly
Carrier Type	Epoxy coated glass fabric

LOCTITE ABLESTIK 5074 is designed for bonding materials with mismatched coefficients of thermal expansion.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25°C, hours	24
Shelf Life @ -40°C (from date of manufacture), days	183

TYPICAL CURING PERFORMANCE

Cure Schedule

180 minutes @ 100°C or
90 minutes @ 125°C or
60 minutes @ 150°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 Thermal Expansion :	
Below Tg, ppm/°C	45
Above Tg, ppm/°C	350
Glass Transition Temperature (Tg), °C	3
Thermal Conductivity , Laser Flash Diffusivity, W/(m-K)	0.9

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Lap Shear Strength	
Al to Al @ 25°C	N/mm ² 8 (psi) (1,200)
Au to Au @ 25°C	N/mm ² 5 (psi) (750)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Packages removed from storage should be allowed to return to ambient temperature before use.
2. While cleaning of substrates is not mandatory, an organic solvent (e.g. Isopropanol) wipe is recommended to remove any oils that might interfere with the bonding process or electrical interface.
3. This adhesive film is slightly tacky. Components may be assembled and cured without using holding fixtures.
4. This tack will last for approximately 16 hours after removal from frozen storage.

Rework Procedure

1. Components joined with LOCTITE ABLESTIK 5074 may be de-bonded easily by heating the component to 125°C and sliding a thin blade between the bonded surfaces.

AVAILABILITY

1. LOCTITE ABLESTIK 5074 adhesive is available in sheet stock or die cut preforms.
2. LOCTITE ABLESTIK 5074 adhesive can be die cut to customer specifications.

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. Storage below minus (-)40 °C or greater than minus (-)40 °C can adversely affect product properties.

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/mm ²
MPa = N/mm ²
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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