

LOCTITE ABLESTIK 508

April 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 508 provides the following product characteristics:

Technology	Epoxy Film
Appearance	Amber
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • Reworkable
Application	Assembly

LOCTITE ABLESTIK 508 thermoplastic adhesive is designed to provide a temporary bond in ceramic chip or ferrite dicing applications. Parts bonded with LOCTITE ABLESTIK 508 adhesive film may be separated by reheating or immersion in a solvent such as acetone, MEK, or tetrahydrofuran.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25°C, days	365
Shelf Life @ 25°C, days	183
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Melt Process Temperature

Melt Process Temperature, °C	95
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Recommended Cure Schedule

15 minutes @ 125°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 PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Aluminum to Aluminum @ 25°C	N/mm ²	2.75
	(psi)	(400)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Remove separator paper from adhesive film.
2. Place LOCTITE ABLESTIK 508 adhesive film between parts to be bonded.
3. Apply enough pressure to bring surfaces into intimate contact.
4. Heat assembled parts to 95°C (bondline temperature).
5. Allow parts to return to ambient temperature before removing pressure.

Rework Procedure

1. To disassemble parts, reheat to 95°C.
2. While warm, remove parts from adhesive film.
3. Adhesive residue may be removed by using Acetone, Methyl ethyl ketone or Tetrahydrofuran.
4. Parts may also be disassembled by soaking the bonded assembly in Acetone, Methyl ethyl ketone or Tetrahydrofuran. This method is only practical for narrow (0.5 inch width or less) bondlines.

AVAILABILITY

1. LOCTITE ABLESTIK 508 adhesive film is available in sheet stock or die cut preforms dimensioned to customer drawings.

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

LOCTITE ABLESTIK film products can be stored at -40°C for up to one year. The shelf life of the film is only valid when the material has been stored at the specified storage conditions. Incorrect storage conditions will degrade the performance of the material in final cured properties. Avoid flexing film when frozen.

Conversions

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

Disclaimer

Note:

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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