

# LOCTITE ABLESTIK 927-10

September 2013

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 927-10 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Light yellow liquid
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• One component</li> <li>• Fast heat cure</li> <li>• Resistant to gamma sterilization</li> </ul>
<b>Operating Temperature</b>	-40 to +105°C
<b>Application</b>	Assembly
<b>Typical Assembly Applications</b>	Needle bond assemblies
<b>Key Substrates</b>	Polypropylene, Stainless steel, Glass and various plastics

LOCTITE ABLESTIK 927-10 is designed for medical applications. It is also recommended for bonding, sealing or insulating heat sensitive parts.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	20,000
Gel Time @ 160 °C, seconds	24
Density @ 25 °C, g/cm <sup>3</sup>	1.32
Shelf Life @ 5 to 15°C (from date of manufacture), days	183
Flash Point - See MSDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 10 minutes @ 120°C
- 15 minutes @ 100°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 100°C in masses up to approximately 10grams.

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, ASTM D2240	88
Glass Transition Temperature (T <sub>g</sub> ) by TMA, °C	68
Coefficient of Thermal Expansion, TMA:	
Below T <sub>g</sub> , ppm/°C	53
Above T <sub>g</sub> , ppm/°C	132
Water Absorption, 1hour @ 100°C, ASTM D 570, %	1.13

### Electrical Properties

Volume Resistivity, 500 volts @ 25 °C, ohm-cm	7.2×10 <sup>15</sup>
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## TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength, ASTM D1002:

Aluminum to aluminum:

@ 25°C	N/mm <sup>2</sup> 8
	(psi) (1,160)

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Complete cleaning of the components and substrates should be performed to remove contamination such as dust, moisture, salt and oils which can cause electrical failure, poor adhesion or corrosion in an embedded 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.

## Storage

Store product in the unopened container in a dry location. 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
N/mm <sup>2</sup> x 145 = psi
MPa = N/mm <sup>2</sup>
MPa x 145 = psi
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:

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Reference 0.2