

LOCTITE ABLESTIK 927-10E

September 2013

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 927-10E provides the following product characteristics:

Technology	Epoxy
Appearance	Yellow
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • One component • Fast heat cure • Resistant to gamma sterilization
Operating Temperature	-40 to +105°C
Application	Assembly

LOCTITE ABLESTIK 927-10E is designed for medical applications. It is also recommended for bonding, sealing or insulating heat sensitive parts. This material adheres well to a variety of substrates including stainless steel, glass and various plastics. It is ideal for application by needle dispense.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Brookfield Viscosity , ASTM D2393, mPa·s (cP):

Speed 10 rpm, spindle 6	11,000
Density, ASTM-D-792, g/cm ³	1.34
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
- 20 minutes @ 90°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 82°C in masses up to approximately 5grams.

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	86
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Electrical Properties

Volume Resistivity @ 25°C, ASTM D257, ohm-cm	6×10 ¹⁴
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TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Tensile Lap Shear Strength , ASTM D1002:

Aluminum to aluminum: @ 25°C	N/mm ² 9.66 (psi) (1,400)
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GENERAL INFORMATION

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

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
4. DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.

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 : 5 to 15 °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/mm² x 145 = psi
 MPa = N/mm²
 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

Reference 0.4

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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