

LOCTITE ABLESTIK A 304-6

September 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK A 304-6 provides the following product characteristics:

Technology	Epoxy
Appearance	Light blue
Product Benefits	<ul style="list-style-type: none"> • Non-conductive • One component • Readily pourable • Fast cure • Good toughness • Excellent chemical resistance
Operating Temperature Range	-40 to +155°C
Cure	Heat cure
Application	Adhesive and Sealant
Typical Package Application	<ul style="list-style-type: none"> • End cap adhesive for hydraulic oil • High temperature industrial/aerospace filters

LOCTITE ABLESTIK A 304-6 epoxy adhesive and sealant is designed for high throughput assembly operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	21,500
Density, g/cm ³	1.5
Shelf Life @ 25 °C, days	120
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Gel Time

10 minutes @ 120°C
70 seconds @ 160°C
15 seconds @ 180°C

Cure Schedule

1hour @ 120°C
30 minutes @ 160°C
15 minutes @ 180°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 160°C in masses up to approximately 30 grams.

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, minimum (units):

@ 25°C	80
@ 125°C	50

Thermal Conductivity, W/(m-K)

0.44

Resistance, 200 hours @ 125°C:

Skydrol 500	No attack
7808 Hydraulic Oil	No attack

Glass Transition Temperature, 1 hr @ 120°C, °C

104

Coefficient of Linear Thermal Expansion, 1 hr @ 120°C, ppm/°C:

Below Tg	41
Above Tg	135

Tensile Modulus:

@ 35°C	N/mm ²	3,833
	(psi)	(555,930)
@ 40°C	N/mm ²	3,810
	(psi)	(552,590)
@ 60°C	N/mm ²	3,603
	(psi)	(522,570)
@ 80°C	N/mm ²	3,032
	(psi)	(439,750)
@ 100°C	N/mm ²	1,794
	(psi)	(260,200)
@ 125°C	N/mm ²	564
	(psi)	(81,800)
@ 150°C	N/mm ²	244
	(psi)	(35,390)
@ 175°C	N/mm ²	123
	(psi)	(17,840)

Electrical Properties

Volume Resistivity, ohms-cm

1×10¹⁴

Dielectric Strength, kV/mm

15.3

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength :

Tensile Lap Shear Strength @ 25 °C	N/mm ²	18
	(psi)	(2,610)

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 : 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

Note:

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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