

# LOCTITE ABLESTIK A 316-8

November 2021

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK A 316-8 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Black
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• One component</li> <li>• Fast cure</li> <li>• Chemical resistant</li> <li>• High speed production</li> </ul>
<b>Cure</b>	Heat cure
<b>Filler Type</b>	Oxide
<b>Application</b>	Heat resistant adhesive
<b>Typical Package Application(s)</b>	Sensors and Control modules
<b>Surfaces</b>	Plastics, Phenolics, Metals and Ceramics

LOCTITE ABLESTIK A 316-8 one component, oxide-filled epoxy adhesive is designed to bond heat resistant plastics in applications requiring heat and chemical resistance. LOCTITE ABLESTIK A 316-8 features exceptional thermal stability and resistance to acids, bases and solvents. LOCTITE ABLESTIK A 316-8 adhesive is designed to bond magnet and speaker assemblies, batteries, and compressors. It is widely used as an end-cap adhesive in the assembly of Skydrol and hydraulic filters.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	10,500
Density, g/cm <sup>3</sup>	1.3
Shelf Life:	
@ 0 to 8°C, days	180
@ 18 to 25°C, days	60
@ 40°C, days	14
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 20 minutes @ 120°C or
- 5 minutes @ 160°C or
- 2 minutes @ 180°C

### Gel Time

- 5 minutes @ 120°C or
- 50 seconds @ 160°C or
- 20 seconds @ 180°C

The above cure profile(s) are guideline recommendation(s). These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Hardness, Shore D:	
@ 25°C	85
@ 130°C	40

### Electrical Properties

Volume Resistivity, ohms-cm:	
@ 25°C	1×10 <sup>14</sup>
@ 130°C	1×10 <sup>12</sup>

## TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Strength :

Aluminum @ 25°C	N/mm <sup>2</sup> 10
	(psi) (1,450)

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part
2. Apply adhesive to all surfaces to be bonded and join together
3. In most applications only contact pressure is required

## 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: 0 to 8 °C or between 18 to 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 Henkel Representative.

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

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