Technical Data Sheet

LOCTITE ABLESTIK CE 3514-1

March 2018

PRODUCT DESCRIPTION

LOCTITE ABLESTIK CE 3514-1 provides the following product characteristics:

Technology	Epoxy
Appearance	Silver
Filler Type	Silver
Product Benefits	• Two component • Electrically conductive • Long shelf life • Low temperature cure • Low viscosity • Improved thermoshock resistance
Mix Ratio, by weight - Part A: Part B	100 : 100
Cure	Heat cure
Application	Assembly, ECA

LOCTITE ABLESTIK CE 3514-1 is designed for heat sensitive applications requiring a low cure temperature.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties:

Density, g/cm³	3.3
Viscosity @ 25 °C, mPa·s (cP)	35,000
Pot life@ 25°C, 20gram mixture, day	1
Shelf Life @ 18 to 25ºC , days	365

Flash Point - See MSDS

TYPICAL CURING PERFORMANCE

Cure Schedule

2 hours @ 80°C or
30 minutes @ 100°C or
20 minutes @ 120°C or
10 minutes @ 150°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 PROPERTIES OF CURED MATERIAL

Physical Properties

Thermal Conductivity, W/(m-K)	2.5

Electrical Properties

Volume Resistivity, ohm-cm:	
Cure @ 120ºC	2.5×10^{-4}
Cure @ 100ºC	5.0×10^{-4}
Cure @ 80ºC	7.5×10^{-4}

TYPICAL PERFORMANCE OF CURED MATERIAL

Die Shear Strength, kg:		
2 X 2 mm (80 x 80 mil) die		2.0
Tensile Lap Shear Strength	N/mm²	9.0
	(psi)	(1,310)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Mix material thoroughly in the original container prior to removal.
2. Accurately weigh out the required amount of part A and part B as stated in the mix ratio
3. Mix Parts A and B together thoroughly using clean metal mixer
4. Avoid entrapment of air or moisture
5. The surfaces on which the adhesive has to be applied should be clean, dry and free from all dust
6. The best suited application method is dispensing

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 : 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 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
psi x 145 = N/mm²
MPa = N/mm²
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:
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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Reference 1

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