

# LOCTITE ABLESTIK CE 8500-S39

August 2018

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK CE 8500-S39 provides the following product characteristics:

<b>Technology</b>	Modified epoxy
<b>Appearance</b>	Silver
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"><li>• One component</li><li>• Low stress</li><li>• 39 µm spacers for bondline thickness control</li></ul>
<b>Application</b>	Component assembly, Electrically Conductive Adhesive
<b>Operating Temperature</b>	up to 200°C

LOCTITE ABLESTIK CE 8500-S39 is a solventless epoxy adhesive that combines low stress with good adhesion on nearly all surfaces. This adhesive is suitable for use on applications with mismatched CTE.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, Brookfield, 25 °C, mPa·s (cP):	
Speed 10 rpm, #TD	130,000
Density, g/cm <sup>3</sup>	3.12
Shelf Life @ -25 to -18°C, days	122
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE****Cure Schedule**

2 hours @ 110°C
90 minutes @ 120°C
40 minutes @ 150°C
15 minutes @ 175°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 :**

Glass Transition Temperature, °C	24
Extractable Ionic Content, ppm:	
Chloride (Cl <sup>-</sup> )	150
Sodium (Na <sup>+</sup> )	10
Potassium (K <sup>+</sup> )	10
Ammonium (NH <sub>4</sub> <sup>+</sup> )	10

**Electrical Properties:**

Volume Resistivity, ohm-cm	1 x 10 <sup>-3</sup>
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**TYPICAL PERFORMANCE OF CURED MATERIAL**

Lap Shear Strength	N/mm <sup>2</sup> 3
	(psi) (435)

**GENERAL INFORMATION**

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

**DIRECTIONS FOR USE**

1. The surfaces on which the adhesive has to be applied should be clean, dry and free from all dust.
2. Refrigeration between -25 to -18°C is required to maintain viscosity.
3. Allow unopened container to reach room temperature before use.

**STORAGE:**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: -18 °C 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**

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

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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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