

# LOCTITE ABLESTIK ICP 3535M2

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## PRODUCT DESCRIPTION

LOCTITE ABLESTIK ICP 3535M2 provides the following product characteristics:

<b>Technology</b>	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>• Adhesion stability</li> <li>• Electrically conductive</li> <li>• Pb-free alternative to solder</li> <li>• Excellent reliability on Tin (Sn) terminated components</li> </ul>
<b>Application</b>	Component assembly, ECA
<b>Filler Type</b>	Silver
<b>Operating Temperature</b>	-45 to +150°C

LOCTITE ABLESTIK ICP 3535M2 electrically conductive adhesive is designed for circuit assembly applications. It is specifically recommended for mounting lower cost tin (Sn) finished components onto the conductive trace terminations of printed circuit boards or co-fired ceramic circuitry. This material is designed for applications with small size components (0603, 0402) where no bleeding or wicking is tolerated. This adhesive can be applied by stencil printing.

LOCTITE ABLESTIK ICP 3535M2 passes NASA outgassing standards.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25°C:	
Plate 2 cm @ Shear rate 15 s <sup>-1</sup> , mPa·s (cP)	80,000
Increase after 24 hours, %	17
Thixotropic Index	4.0
Density, g/cm <sup>3</sup>	4.0
Shelf Life @ -40°C, days	183
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

1 hour @ 150°C or  
10 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, Tan δ, °C 96

### Electrical Properties:

Volume Resistivity, ohms-cm 2.0×10<sup>3</sup>

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Miscellaneous:

Tensile Lap Shear Strength, N/mm<sup>2</sup> 4.6

## TYPICAL ENVIRONMENTAL RESISTANCE

### Outgassing Properties

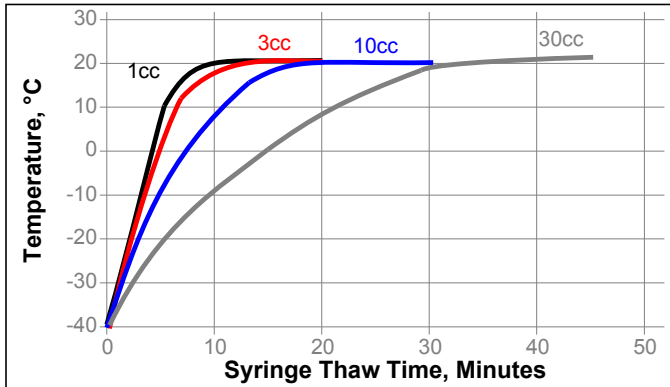
Outgassing :	
TML, %	0.26
CVCM, %	0.03
WVR, %	0.08

## GENERAL INFORMATION

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

### THAWING:

1. Allow container to reach room temperature before use.
2. Material is ready to use after 1 hour @ 25°C.
3. After removing from the freezer, set the syringes to stand vertically while thawing.
4. Refer to the Syringe Thaw time chart for the thaw time recommendation.
5. 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.
6. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.



#### DIRECTIONS FOR USE

1. Thawed material should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Silver-resin separation may occur if the adhesive is left out at room temperature, beyond the recommended work life.

#### STORAGE:

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

#### Optimal Storage : -40 °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.

#### 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.

#### 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

##### 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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury

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Reference 2