Technical Data Sheet

LOCTITE ABLESTIK TE 3524

June 2017

PRODUCT DESCRIPTION

LOCTITE ABLESTIK TE 3524 provides the following product characteristics:

Technology	Epoxy
Appearance	White
Cure	Heat cure
Product Benefits	• Low stress • One component • Thermally conductive
Application	Thermal management
Operating Temperature	-45 to +200 °C

LOCTITE ABLESTIK TE 3524 is designed for use in mismatched TCE applications such as substrate attach and heat sink bonding.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	36,000
Density, g/cm³	2.1
Filler Content as supplied, % by weight	70
Shelf Life @ -25 to -18 °C, days	183
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

90 minutes @ 120°C or
60 minutes @ 150°C or
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

Hardness, Shore D	50
Thermal Conductivity , W/(m-K)	1.0
Extractable Ionic Content, , ppm:	
Chloride (Cl-)	200
Sodium (Na+)	10
Potassium (K+)	10
Ammonium (NH4+)	75

Electrical Properties

Volume Resistivity @ 25 °C, ohms-cm	4×10^{13}
Surface Resistivity, ohms	1.5×10^{14}

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength, Minimum, MPa	3

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. After removing from the freezer, set the syringes to stand vertically while thawing.

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 to -18 °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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