

# LOCTITE ABLESTIK 12-2

August 2014

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK 12-2 provides the following product characteristics:

|                         |                                                                                                                |
|-------------------------|----------------------------------------------------------------------------------------------------------------|
| <b>Technology</b>       | Silicone                                                                                                       |
| <b>Appearance</b>       | white                                                                                                          |
| <b>Cure</b>             | Heat cure                                                                                                      |
| <b>Product Benefits</b> | <ul style="list-style-type: none"><li>• Thermally conductive</li><li>• Reworkable</li><li>• Unfilled</li></ul> |
| <b>Application</b>      | General assembly                                                                                               |

LOCTITE ABLESTIK 12-2 adhesive is the lower viscosity version of ABLETHERM 12-1 adhesive. It is designed for bonding applications which require high thermal conductivity and reworkability.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

|                                                     |    |
|-----------------------------------------------------|----|
| Work Life @ 25°C, hours                             | 4  |
| Shelf Life @ -40°C (from date of manufacture), days | 91 |
| Flash Point - See SDS                               |    |

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

1 hour @ 95°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 A | 90 |
|-------------------|----|

**TYPICAL PERFORMANCE OF CURED MATERIAL**

Lap Shear Strength @ 25°C:

Post Cure

| Substrate | N/mm <sup>2</sup> | psi |
|-----------|-------------------|-----|
| Al to Al  | 2.07              | 300 |

**GENERAL INFORMATION**

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

**THAWING:**

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. 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.

4. DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.

**DIRECTIONS FOR USE**

1. Apply adhesive as required.
2. Assemble bonds.
3. Cure at one of the recommended cure schedules.

**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: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °C can adversely affect product properties.**

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.

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**Conversions**

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

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Reference 0.0