

LOCTITE ABLESTIK 2106T BIPAX

October 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2106T BIPAX provides the following product characteristics:

Technology	Epoxy
Appearance	Light yellow to orange
Cure	Room temperature and Heat cure
Mix Ratio, by weight - Resin : Hardener	110 : 93
Product Benefits	<ul style="list-style-type: none"> • Two component • Room temperature cure • Solvent-free • Low shrinkage • Electrically Insulating • Chemical resistant
Operating Temperature	-60 to 115°C
Operating Temperature - Intermittent	up to 150°C
Application	Assembly
Key Substrates	Metals , Phenolic plastics, Polyester, Glass, Glass fabrics, Hard boards & forestry products, Ceramics, Rubbers, Masonry materials and other construction materials

LOCTITE ABLESTIK 2106T BIPAX is designed for high strength structural bonding applications. LOCTITE ABLESTIK 2106T BIPAX develops significant properties 1 hour after mixing.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Viscosity @ 25 °C, mPa·s (cP)	3,600
Specific Gravity, mixed	1.22
Pot Life , minutes	5
Shelf Life - Refer to package label	
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

- 4 to 6 hours @ 25°C or
- 1 hour @ 65°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 @ 25°C after 10minutes:	
After 10 minutes	25
After 30 minutes	67
After 60 minutes	72

Glass Transition Temperature (Tg), °C	25
Coefficient of Expansion, ppm/°C	60
Izod Impact Strength, ft-lb/in. of notch	1.9
Reactive solids contents, %	100

Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	5×10 ¹¹
Dielectric Strength, volts/mil	410
Dielectric Constant @ 25°C : @ 1 KHz	4.8

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Aluminum to aluminum	N/mm ² 1.37	(psi) (200)
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GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. LOCTITE ABLESTIK 2106T BIPAX develops high exotherm. Use immediately after mixing. The exothermic reaction begins within 2 minutes after initiating the mixing step. Everything must be ready before removing the Bipax clamp.
2. Carefully clean and dry all surfaces to be bonded.
3. Remove clamp and thoroughly mix the LOCTITE ABLESTIK 2106T BIPAX epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout.
4. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
5. Some ingredients in this formulation provided in BIPAX, TRA-PAX and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 50°C for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results.

STORAGE:

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

Optimal Storage : 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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