

LOCTITE ABLESTIK 813J01 BIPAX

May 2020

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 813J01 BIPAX provides the following product characteristics:

Technology	Silicone
Appearance	Red
Cure	Room Temperature or Heat Cure
Product Benefits	• Excellent thermal conductivity • Bonds well to difficult substrates • Low stress
Application	Encapsulation
Typical Applications	Transformers, Thermistors, Power supplies and Heat sinks
Operating Temperature Range	-65 to 260°C

LOCTITE ABLESTIK 813J01 BIPAX exhibits very low stress upon cure thus preventing component cracking and other stress-related problems. This adhesive can be cured at room temperature in thick or thin sections. It is non-corrosive and will not revert when exposed to high temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity, mixed	2.1
Mixed Viscosity, mPa·s (cP)	40,000
Work Life (100 g) , minutes	100
Shelf Life @ 25°C, days	274

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Recommended Curing Conditions

- 2 to 7 days @ 25°C or
- 1 to 4 hours @ 65°C or
- 20 minutes @ 150°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	75
Thermal Conductivity, W/(m·K)	1.1
Glass Transition Temperature (T _g), °C	-120
Coefficient of Thermal Expansion, ppm/°C	200

Electrical Properties:

Volume Resistivity @ 25°C, ohm-cm	1.00×10 ¹⁵
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TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength:

Al to Al

N/mm² 3.45
(psi) (500)

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.
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 : ≤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

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

Reference 2**Disclaimer****Note:**

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