Technical Data Sheet

LOCTITE ABLESTIK 342-37

February 2020

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 342-37 provides the following product characteristics:

Technology	Epoxy
Cure	Heat cure and Room temperature cure
Product Benefits	• Room temperature cure • Thermal shock resistant
Application	General assembly
Filler Type	Silica
Operating Temperature	-55 to 150ºC

LOCTITE ABLESTIK 342-37 epoxy adhesive is designed for applications requiring outstanding thermal shock properties. LOCTITE ABLESTIK 342-37 adhesive may be used to bond semi-porous materials such as ferrites, where a physical rather than a chemical bond is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Thixotropic Index	5.25
Viscosity, mPa·s (cP):	
@ Speed 5.0 rpm, In-process check by production at beginning of syringe filling	25,000
Heat Cycle, ºC	150
Shelf Life @ -40°C (from date of manufacture), days	365
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

2 hours @ 65°C

Alternate Cure Schedule

48 hours @ 25°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	85
Coefficient of Thermal Expansion, , TMA, ppm/°C:	
alpha 1 (-55 to 79°C)	39
alpha 2 (79 to 150°C)	15
Glass Transition Temperature(Tg), °C	79
Thermal Conductivity @ 121°C, W/(m-K)	0.29

Outgassing Properties

Outgassing , TGA:	
Sample cured 120 minutes @ 93ºC	
@ 100°C, %	0.03
@ 250°C, %	0.55

Electrical Properties

Volume Resistivity , ohms-cm	26×10^{14}
Dielectric Strength, kV/mm	28
Dielectric Constant @ 1KHz	4.1

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous

Lap Shear Strength :		
Al to Al @ 25°C	N/mm² (psi)	9.65 (≥1,400)

GENERAL INFORMATION

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

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

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/F
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. 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 caused by our negligence and any liability under any applicable mandatory product liability law.

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Americas +1.888.943.6535
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