Technical Data Sheet

LOCTITE ABLESTIK 66C

December 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 66C provides the following product characteristics:

Technology	Epoxy
Appearance (Resin)	Silver liquid
Product Benefits	• Conductive • Low flow • Can be used with a variety of catalysts
Application	Assembly
Typical Applications	
Operating Temperature	-60 to 120 °C
Substrates	Metals, glass, plastics and ceramic

LOCTITE ABLESTIK 66C adhesive is designed to make electrical connections where hot soldering is impractical or to make electrical connections to nichrome wire or to heat sensitive electrical components.

LOCTITE ABLESTIK 66C can be used with LOCTITE CAT 9 or LOCTITE CAT 11.

CATALYST DESCRIPTION

LOCTITE CAT 9 provides the following product characteristics:

Product Benefits	• General purpose • Good chemical resistance • Good physical strength
Cure	Room temperature cure
Mix Ratio, by weight - Material:Catalyst	100 : 2.5

LOCTITE CAT 11 provides the following product characteristics:

Product Benefits	• Long pot life • Excellent chemical resistance • Good physical and chemical properties at elevated temperatures
Cure	Heat cure
Mix Ratio, by weight - Material:Catalyst	100 : 3

TYPICAL UNCURED PROPERTIES

LOCTITE ABLESTIK 66C

Shelf Life @ 25°C (from date of manufacture), days	182

LOCTITE CAT 9

Viscosity @ 25 °C, mPa·s (cP)	90
Flash Point - See SDS	

LOCTITE CAT 11

Viscosity @ 25 °C, mPa·s (cP)	45
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

LOCTITE ABLESTIK 66C with LOCTITE CAT 9

2 hours @ 50°C or
3 to 5 minutes @ 65 to 90°C

LOCTITE ABLESTIK 66C with LOCTITE CAT 11

8 hours @ 80°C or
1 hour @ 120°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

, **LOCTITE ABLESTIK 66C with LOCTITE CAT 11**:

Physical Properties :

Flexural Strength , (ASTM D1184):	
N/mm²	85
(psi)	(12,300)
Thermal Conductivity, ASTM D-2214, W/(m-K)	5
Coefficient of Linear Thermal Expansion , ASTM D696:	
ppm/°C	36

Electrical Properties:

Volume Resistivity, ASTM D257, ohms-cm	1×10^{-3}

TYPICAL PERFORMANCE OF CURED MATERIAL

LOCTITE ABLESTIK 66C with LOCTITE CAT 11

Shear Strength

Tensile Lap Shear Strength :

N/mm²	4.5
(psi)	(650)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

• LOCTITE ABLESTIK 66C with LOCTITE CAT 9

1. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
2. Mix very thoroughly.
3. Apply adhesive to all surfaces to be bonded and join together.
4. No pressure is required.

• LOCTITE ABLESTIK 66C with LOCTITE CAT 11

1. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
2. Mix very thoroughly.
3. Apply adhesive to all surfaces to be bonded and join together.
4. No pressure is required.

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

(°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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