

LOCTITE ABLESTIK 58C

October 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 58C provides the following product characteristics:

Technology	Epoxy
Appearance	Silver paste
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none">• One component• Silver-filled• Electrically conductive• Thermally conductive• High temperature resistance
Operating Temperature	-40 to 180°C
Application	Assembly
Substrates	Metals, Glass, Plastics, Ceramic, Copper and Brass

LOCTITE ABLESTIK 58C adhesive is designed for applications where tin-lead solder is impractical or for surfaces to which conventional solder will not adhere.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density, ASTM D792, g/cm ³	4.1
Shelf Life @ 25°C (from date of manufacture), days	91
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

15 minutes @ 260°C
30 minutes @ 205°C
50 minutes @ 175°C
90 minutes @ 165°C
120 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

Coefficient of Thermal Expansion, ppm/°C	32
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Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	0.002
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TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength :

Tensile Lap Shear Strength, ASTM D1002:	
Al to Al @ 25°C	N/mm ² 8.3 (psi) (1,200)

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. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. Some separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.
3. Power mixing is preferred to ensure a homogeneous product.
4. Apply adhesive to all surfaces to be bonded and join together.
5. In most applications only contact 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. Storage below 25°C or greater than 25°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.

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

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