

LOCTITE ABLESTIK 539IA

April 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 539IA provides the following product characteristics:

Technology	Epoxy Film
Appearance	Transparent
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • Non-conductive • Uniform bondline control
Application	Assembly
Carrier Type	Polyester
Surfaces	Plastics, Ceramics and Difficult-to-bond metals
Typical Assembly Applications	Liquid crystal display

LOCTITE ABLESTIK 539IA non-conductive film adhesive is designed for assembly applications. This adhesive film may be die cut to customer specifications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25°C, month	1
Shelf Life @ 0°C, days	365
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

1 hour @ 150°C

Alternate Cure Schedule

2 hours @ 125°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 PERFORMANCE OF CURED MATERIAL

Shear Strength

Lap Shear Strength	N/mm ²	20.69
Al to Al @ 25°C	(psi)	(3,000)

GENERAL INFORMATION

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

THAWING:

1. Allow material to reach room temperature before use.
2. DO NOT open the package before contents reach ambient temperature.
3. Any moisture that collects on the thawed package should be removed prior to opening the package.

DIRECTIONS FOR USE

1. Place precut adhesive film between clean surfaces to be bonded.

2. Assemble components.
3. Apply spring loaded clamp or dead weight to provide continuous pressure of at least 1 to 5psi during cure cycle.
4. Place assembly in a preheated oven and cure at the recommended cure schedule.

AVAILABILITY

1. LOCTITE ABLESTIK 539IA adhesive is available in sheet stock or die cut preforms.
2. LOCTITE ABLESTIK 539IA adhesive can be die cut to customer specifications.
3. Tolerances are as close as 0.005 inch in length or width and 0.001 inch in thickness.
4. This adhesive film can be supplied on 1/2-mil or 1-mil polyester film.

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. Storage below minus (-)40 °C or greater than minus (-)40 °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

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

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

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Reference 0.1