

LOCTITE ABLESTIK 862-2

March 2018

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 862-2 provides the following product characteristics:

Technology	Epoxy
Appearance	Amber paste
Product Benefits	<ul style="list-style-type: none"> Room temperature cure capability
Cure	Room temperature or Heat cure
Application	Component assembly, Non-conductive adhesive

LOCTITE ABLESTIK 862-2 epoxy adhesive is designed for solder pad encapsulation or as a sealant for head/disk area in floppy disc assemblies. This resilient compound is suitable for bonding materials with mismatched coefficients of thermal expansion.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life , hour 1

TYPICAL CURING PERFORMANCE**Cure Schedule**

- 2 hours @ 65°C or
- 3 days @ 25°C or
- 1 hour @ 95°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	60
Coefficient of Thermal Expansion, , cm/cm/°C:	
Above Tg	2×10^{-4}
Below Tg	7.5×10^{-5}

Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	$3 \times 10^{+12}$
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TYPICAL PERFORMANCE OF CURED MATERIAL**Shear Strength**

Lap Shear Strength , Al to Al, psi	2,000
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GENERAL INFORMATION

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

DIRECTIONS FOR USE

- Carefully clean and dry all surfaces to be bonded.
- If packaged in BIPAX, remove clamp and thoroughly mix the LOCTITE ABLESTIK 862-2 epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout.
- If pre-mixed and frozen, thaw adhesive to room temperature. A 25°C water bath is recommended.
- Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
- Cure at 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 in original, tightly covered containers in clean, dry areas. 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

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

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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