

# LOCTITE ABLESTIK 293-1.5T

January 2014

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 293-1.5T provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Black liquid
<b>Components</b>	One-component
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>General purpose</li> </ul>
<b>Cure</b>	Heat cure
<b>Application</b>	General assembly
<b>Surfaces</b>	Gold, Nickel, Silver, Copper and Brass

LOCTITE ABLESTIK 293-1.5T epoxy adhesive is designed to provide strong, semi-rigid bonds to a variety of difficult-to-bond substrates, such as gold, nickel, silver, copper, and brass. This version of the 293-series is designed to be more flexible.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25 °C, hours	8
Shelf Life @ -40 °C, days	365
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

24 hours @ 60°C

### Alternate Cure Schedule

4 hours @ 75°C or  
1.5 hours @ 95°C or  
45 minutes @ 120°C

The above cure profile is a guideline recommendation. 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

Tensile Shear Strength @ 25 °C:

Al to Al	N/mm <sup>2</sup>	37
	(psi)	(5,500)
Au to Au	N/mm <sup>2</sup>	27
	(psi)	(4,000)
Ag to Ag	N/mm <sup>2</sup>	26
	(psi)	(3,800)
Brass to brass	N/mm <sup>2</sup>	27
	(psi)	(4,000)

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Thaw adhesive to room temperature.
2. Apply adhesive as required.
3. Assemble bonds.
4. Cure at the 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.

## AVAILABILITY

1. This adhesive is available in a variety of package sizes, ranging from 1 cc to 1pound.

## 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 This adhesive is shipped frozen and must be stored continually at -40°C or colder until ready to use.**

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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