

LOCTITE ABLESTIK 216C03 TRA-PAX

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 216C03 TRA-PAX provides the following product characteristics:

Technology	Epoxy
Appearance	Amber
Cure	Room Temperature or Heat Cure
Product Benefits	<ul style="list-style-type: none"> • Flexible • Thixotropic • Low viscosity • Easy application • Easy mix ratio • Room temperature cure
Application	Non-conductive adhesive
Mix Ratio, by weight - Resin : Hardener	100 : 100
Substrates	Nylon, PVC, Polyethylene, Acrylic, Lexan, Polypropylene, Kapton and Other thermoplastics

LOCTITE ABLESTIK 216C03 TRA-PAX is a general purpose adhesive designed for applications requiring excellent chemical bonding to plastic parts .

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties:

Viscosity, Brookfield - LV #4 , 25 °C, mPa·s (cP):	
Speed 12 rpm	16,000
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

24 hours @ 25°C or
1 hour @ 65°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 A:	
Cured 1 hour @ 65°C	90
Cured 24 hours @ 25°C	90
Glass Transition Temperature (Tg), °C, by DSC	18.0
Specific Gravity, cured	1.02

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Lap Shear Strength :

Al to Al:	
Cured 1 hour @ 65°C	N/mm ² 10.3 (psi) (1,500)
Cured 24 hours @ 25°C	N/mm ² 7.2 (psi) (1,050)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
2. If packaged in BIPAX, remove clamp and thoroughly mix the LOCTITE ABLESTIK 216C03 TRA-PAX epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout
3. If pre-mixed and frozen, thaw adhesive to room temperature. A 25°C water bath is recommended
4. 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
5. Cure at recommended cure schedules
6. Some ingredients in this formulation provided in BIPAX, TRA-PAX and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 52°C for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results

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 : ≤27 °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:**

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