

# LOCTITE ABLESTIK 16-1

June 2021

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 16-1 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Silver
<b>Cure</b>	Heat cure and Room temperature cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Two component</li> <li>• Electrically conductive</li> <li>• Room temperature cure</li> <li>• Good adhesion</li> <li>• Low volume resistivity</li> </ul>
<b>Application</b>	General assembly
<b>Filler Type</b>	Silver

LOCTITE ABLESTIK 16-1 epoxy adhesive is designed for general purpose applications. This adhesive cures at room temperature, while providing a reasonable work life.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25°C, hours	2
Shelf Life @ -40 °C (from date of manufacture), days	183
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

30 minutes @ 95°C

### Alternate Cure Schedule

1 hour @ 65°C or  
24 hours @ 25°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Hardness, Shore D	85
Coefficient of Thermal Expansion, , TMA:	
Below Tg, ppm/°C	70
Above Tg, ppm/°C	300
Glass Transition Temperature(Tg), °C	57
Thermal Conductivity @ 121°C, W/(m-K)	2.0
Weight Loss , TGA, %:	
@ 150°C	0.1
@ 250°C	0.7

## Electrical Properties

Volume Resistivity , ohms-cm	≤0.005
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## TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

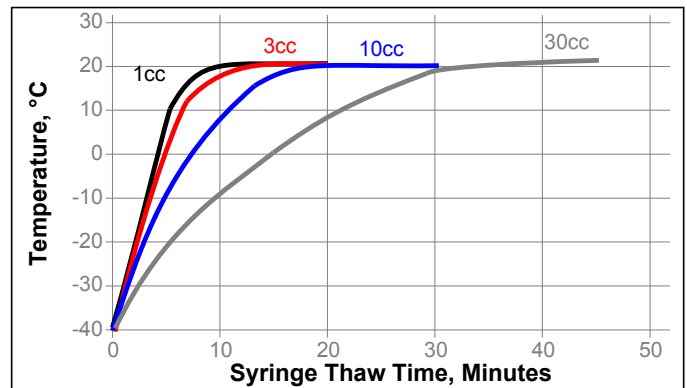
Al to Al @ 25°C	N/mm <sup>2</sup>	6.89
	(psi)	(1,000)
Au to Au @ °C	N/mm <sup>2</sup>	8.27
	(psi)	(1,200)

## GENERAL INFORMATION

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

## 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. Refer to the Syringe Thaw time chart for the thaw time recommendation.
4. 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.
5. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.



## Directions for Use

1. Apply adhesive as required.
2. Assemble bonds.
3. Cure at one of the recommended cure schedules.
4. For best results, it is recommended the adhesive be used within 2 hours after removal from freezer.

## AVAILABILITY

1. LOCTITE ABLESTIK 16-1 this adhesive is available premixed and frozen in a variety of sizes or in pound kits.

**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 -40°C or above -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 Henkel Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb/F}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

**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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Reference 0.4