

# LOCTITE ABLESTIK GA 47-2LV

May 2013

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK GA 47-2LV provides the following product characteristics:

|                         |   |
|-------------------------|---|
| <b>Technology</b>       | Epoxy   |
| <b>Appearance</b>       | Green   |
| <b>Cure</b>             | Heat cure   |
| <b>Product Benefits</b> | <ul style="list-style-type: none"><li>• One component</li><li>• Low viscosity</li></ul> |
| <b>Application</b>      | Instrument adhesive   |

LOCTITE ABLESTIK GA 47-2LV exhibits excellent compatibility with conventional gyro flotation fluids. LOCTITE ABLESTIK GA 47-2LV has a coefficient of thermal expansion which approximates that of aluminum within a normal temperature range.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

|                             |        |
|-----------------------------|--------|
| Mixed Viscosity, mPa·s (cP) | 50,000 |
| Specific Gravity, mixed     | 2.1    |
| Work Life @ 25°C, minutes   | 30     |
| Shelf Life @ -40°C, days    | 365    |
| Flash Point - See SDS       |        |

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 2 hours @ 95°C or
- 4 hours @ 75°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                                  | 90   |
| Glass Transition Temperature (T <sub>g</sub> ), °C | 95.0 |
| Coefficient of Linear Thermal Expansion, ppm/°C:   |      |
| Below T <sub>g</sub>                               | 25   |

## TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

|          |                   |         |
|----------|-------------------|---------|
| Al to Al | N/mm <sup>2</sup> | 13.8    |
|          | (psi)             | (2,000) |

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
2. Remove clamp and thoroughly mix the LOCTITE ABLESTIK GA 47-2LV epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout
3. 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
4. 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 50°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**

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

Reference 0.0

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