

LOCTITE ABLESTIK KS 4008

October 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK KS 4008 provides the following product characteristics:

| | |
|--|---|
| Technology | Epoxy |
| Technology (Part B) | Proprietary |
| Appearance, Resin (Component A) | Silver |
| Appearance, Hardener (Component B) | Amber |
| Filler Type | Silver |
| Components | Two component - requires mixing |
| Mixing Ratio, by weight Component A: Component B | 100 : 6 |
| Product Benefits | <ul style="list-style-type: none"> • Two component • High current density • High bond strength |
| Cure | Room Temperature or Heat Cure |
| Application | Assembly |
| Typical Assembly Applications | Protection against electrostatic discharge (ESD) |
| Operating Temperature | -55 to 125°C |

LOCTITE ABLESTIK KS 4008 is designed for bonding static dischargers to aircraft.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

| | |
|---|------|
| Density @ 25 °C, ASTM D1475, g/cm ³ | 3.05 |
| Specific Gravity @ 25 °C, ASTM D1475, g/cm ³ | 2.2 |
| Shelf Life @ 25°C, days | 365 |
| Flash Point - See SDS | |

Part B Properties

| | |
|---|-------|
| Brookfield Viscosity - RVF, ASTM D2393, mPa·s (cP): Spindle 5, speed 4 rpm, 25°C | 7,000 |
| Density @ 25 °C, ASTM D1475, g/cm ³ | 1.1 |
| Specific Gravity @ 25 °C, ASTM D1475, g/cm ³ | 1.6 |
| Shelf Life @ 25°C, days | 365 |
| Flash Point - See SDS | |

Mixed Properties

| | |
|--|----|
| Working Time, 28 g mass @ 25 °C, minutes | 60 |
|--|----|

TYPICAL CURING PERFORMANCE

Cure Schedule

| |
|-------------------|
| 2 hours @ 60°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 their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

| | |
|--|------|
| Density @ 25 °C, ASTM D792 g/cm ³ | 2.9 |
| Specific Gravity | 3.65 |
| Flammability | Pass |

Electrical Properties

| | |
|----------------------------|------|
| Volume Resistivity, ohm-cm | 0.01 |
|----------------------------|------|

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous:

Tensile Lap Shear Strength :

| | | |
|-----------------------|-------------------|---------|
| Al to Al: | | |
| Cured 2 hours @ 60°C | N/mm ² | 10.3 |
| | (psi) | (1,500) |
| Cured 24 hours @ 25°C | N/mm ² | 8.3 |
| | (psi) | (1,200) |

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. Mix HYSOL KS4008 Part A in the can in which it is received.
3. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
4. The mix ratio of LOCTITE ABLESTIK KS 4008 is fixed by their chemistry. Any attempt to increase or decrease cure rate by adding more or less hardener will result in degraded materials..
5. Mix Parts A and B together thoroughly..
6. Apply adhesive to all surfaces to be bonded and join together.
7. In most applications only contact pressure is required.

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: 25°C. Storage below 25°C or greater

than 25°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 Technical Service Center or Customer Service Representative.

Conversions
 $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} = \text{N/mm}^2$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$
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Reference 0.1