

# LOCTITE ABLESTIK 2156 BIPAX

December 2016

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2156 BIPAX provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Tan
<b>Cure</b>	Room Temperature or Heat Cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Thixotropic</li> <li>• Thermally conductive</li> <li>• Two component</li> <li>• Strong bond strength</li> <li>• High impact strength</li> <li>• Electrically Insulating</li> </ul>
<b>Application</b>	Non-conductive adhesive
<b>Operating Temperature</b>	-70 to 100°C
<b>Mix Ratio, by weight - Resin : Hardener</b>	100 : 23
<b>Surfaces</b>	Metals, Silica, Alumina, Sapphire, Ceramics, Glass and Plastics

LOCTITE ABLESTIK 2156 BIPAX is used for staking heat sinks, transistors, diodes, resistors, integrated circuits and other heat-sensitive components to printed circuit boards. LOCTITE ABLESTIK 2156 BIPAX bonds offer resistance to salt solutions, mild acids and alkalis, petroleum solvents, lubricating oils and alcohol.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Mixed Properties:

Mixed Viscosity @ 25 °C, mPa·s (cP):	
After Mixing	12,000
Specific Gravity	2.3
Pot life, minutes	5
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 1 hour @ 25°C plus 2 hours @ 65°C
- 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 :

Hardness, Shore D	80
Glass Transition Temperature (T <sub>g</sub> ), °C	33.0
Coefficient of Linear Thermal Expansion, ppm/°C	2.60×10 <sup>-1</sup>
Reactive solids contents, %	100

### Thermal Properties:

Thermal Conductivity, W/(m-K)	8.40×10 <sup>-1</sup>
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## TYPICAL PERFORMANCE OF CURED MATERIAL

### Lap Shear Strength :

Al to Al at 65°C for 2 hours	N/mm <sup>2</sup>	23.4
	(psi)	(3,400)

## 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. Remove clamp and thoroughly mix the LOCTITE ABLESTIK 2156 BIPAX 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 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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