

# LOCTITE ABLESTIK 2123

December 2016

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2123 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Gray liquid
Mix Ratio, by weight - Resin : Hardener	100 : 10
<b>Cure</b>	Room Temperature or Heat Cure
Product Benefits	<ul style="list-style-type: none"> <li>• Ease of use</li> <li>• Solvent-free</li> <li>• Low shrinkage</li> <li>• Good toughness</li> <li>• Electrically insulating</li> </ul>
<b>Application</b>	Repair
Typical Assembly Applications	Repair, Casting or Bonding
Operating Temperature	-60 to 135 °C
Surfaces	Metals, Wood, Concrete, Glass, Ceramics and Plastics

LOCTITE ABLESTIK 2123 is a steel filled, two component epoxy adhesive that is ideal for the repair and recovery of worn and damaged machinery. This adhesive can be drilled, cut, sawed, and machined with regular working tools. LOCTITE ABLESTIK 2123 bonds offer resistance to water, mild acids and alkalis, salts, salt solutions, lubricating oils, petroleum solvents, gasoline, jet fuel, alcohol and other organic and inorganic compounds.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Viscosity @ 25 °C, mPa·s (cP)	32,000
Specific Gravity, mixed	2.35
Pot Life @ 25°C, minutes	30
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 24 hours @ 25°C or
- 4 hours @ 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 D	88
Thermal Conductivity, W/(m-K)	0.59
Glass Transition Temperature (T <sub>g</sub> ), °C	110
Coefficient of Expansion, ppm/°C	38
Reactive solids contents, %	100
Shrinkage, %	0.08

### Electrical Properties

Dielectric Strength, KV/mm	1.18
Dielectric Constant / Dissipation Factor @ 25°C: @ 1 KHz	65.0/0.2

## 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 2123 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** $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$  $\text{kV/mm} \times 25.4 = \text{V/mil}$  $\text{mm} / 25.4 = \text{inches}$  $\text{N} \times 0.225 = \text{lb}$  $\text{N/mm} \times 5.71 = \text{lb/in}$  $\text{psi} \times 145 = \text{N/mm}^2$  $\text{MPa} = \text{N/mm}^2$  $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$  $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$  $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$  $\text{mPa}\cdot\text{s} = \text{cP}$ **Disclaimer****Note:**

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