

# LOCTITE ABLESTIK 104

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## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 104 provides the following product characteristics:

Technology	Epoxy
Technology (Part B)	Anhydride
Appearance, Resin (Component A)	Black liquid
Appearance, Hardener (Component B)	White powder
Components	Two component - requires mixing
Mixing Ratio, by weight	100 : 64
Component A: Component B	
Product Benefits	<ul style="list-style-type: none"> <li>Excellent chemical resistance</li> <li>Non-conductive</li> <li>High shear strength</li> <li>High temperature resistance</li> <li>Long pot life</li> </ul>
Cure	Heat cure
Application	Assembly
Key Substrates	Metals, Glass, Ceramic and Thermoset plastic
Operating Temperature	-25 to 230°C

LOCTITE ABLESTIK 104 adhesive is designed for applications requiring very high temperature exposures. This adhesive can withstand continuous exposure at temperatures as high as 230°C. It has also been tested to withstand short term exposures up to 280°C.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Part A Properties

Viscosity @ 25 °C, mPa·s (cP)	25,000
Specific Gravity	1.35
Shelf Life @ 25°C, days	183
Flash Point - See SDS	

### Part B Properties

Shelf Life @ 25°C, days	183
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### Mixed Properties

Working Time, 100 g mass @ 25 °C, hours	>12
Density, g/cm³	1.4

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 1 hour @ 200°C
- 2 hours @ 175°C
- 3 hours @ 150°C
- 6 hours @ 120°C

For optimum performance, follow the initial cure with a post cure of 2 to 4 hours at the highest expected use temperature.

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
Coefficient of Thermal Expansion TMA, ppm/°C	60
Glass Transition Temperature DSC/TMA, °C	>225

### Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	10 <sup>15</sup>
Dielectric Strength, kV/mm	15.7

### Outgassing Properties

Outgassing, per NASA Reference Publication 1124, %:  
sample cured 6 hours @ 120°C

TML	0.52
CVCM	0.08

### Chemical Resistance

Typical Solvent and Chemical Resistance % Weight Change  
After 7days Immersion @ 24°C

Chemical	% Weight Change	Chemical	% Weight Change
30% H <sub>2</sub> SO <sub>4</sub>	+ 0.19	10% NaCl	+ 0.21
3% H <sub>2</sub> SO <sub>4</sub>	+ 0.26	5% Phenol	+ 0.23
10% NaOH	+ 0.11	Distilled H <sub>2</sub> O	+ 0.20
1% NaOH	+ 0.22	10% HNO <sub>3</sub>	+ 0.23
95% C <sub>2</sub> H <sub>5</sub> OH	+ 0.7	10% HCl	+ 0.22
50% C <sub>2</sub> H <sub>5</sub> OH	+ 0.18	5% CH <sub>2</sub> COOH	+ 0.24
Acetone	+ 0.06	10% NH <sub>4</sub> OH	+ 0.76
Ethyl Acetate	+ 0.00	2% Na <sub>2</sub> CO <sub>3</sub>	+ 0.22
CCl <sub>4</sub>	+ 0.04	3% H <sub>2</sub> O <sub>2</sub>	+ 0.23
Toluene	+ 0.04	10% Citric Acid	+ 0.22
Heptane	+ 0.02	Oleic Acid	+ 0.09
JP-4	+ 0	JP-5	0



**TYPICAL PERFORMANCE OF CURED MATERIAL****Shear Strength**

Tensile Lap Shear Strength :

Aluminum to aluminum:

Tested @ 25 °C	N/mm <sup>2</sup>	12.4
	(psi)	(1,800)
Tested @ 150 °C	N/mm <sup>2</sup>	11.7
	(psi)	(1,700)
Tested @ 230 °C	N/mm <sup>2</sup>	9.7
	(psi)	(1,400)

**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. 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.
3. Blend components by hand, using a kneading motion, for 2 to 3 minutes and scrape the bottom and sides of the mixing container frequently to produce a uniform mixture.
4. If possible, power mix for an additional 2 to 3 minutes. Avoid high mixing speeds. This can entrap excessive amounts of air. It can also cause overheating of the mixture, resulting in reduced working life.
5. Apply adhesive to all surfaces to be bonded and join together.
6. 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**

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**

(°C x 1.8) + 32 = °F  
 KV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 psi x 145 = N/mm<sup>2</sup>  
 MPa = N/mm<sup>2</sup>  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = cP

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**Reference 0.0**