



LOCTITE® ABLESTIK 2332-17U

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PRODUCT DESCRIPTION

LOCTITE® ABLESTIK 2332-17U provides the following product characteristics:

Technology	Epoxy
Appearance	Black
Cure	Heat cure
Product benefits	<ul style="list-style-type: none">• Bonds to a wide variety of substrates• One-component• Slightly thixotropic• Solvent-free
Application	Assembly
Surfaces	Copper, Aluminum, Nickel, FRP, rigid plastics and oily steel

LOCTITE® ABLESTIK 2332-17U is a solventless epoxy adhesive that develops high bond strength when cured at temperatures as low as 100 to 130°C.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25°C, mPa·s (cP)	100,000
Specific gravity @ 25°C	1.16
Shelf life @ 0 to 4°C, days	213
Flash point - see SDS	

TYPICAL CURING PERFORMANCE

Cure schedule
1 hour @ 120°C

Alternate cure schedule
90 minutes @ 100°C
30 minutes @ 120°C
20 minutes @ 150°C

LOCTITE® ABLESTIK 2332-17U may also be cured in paint ovens at temperatures above 130°C.

The above cure profiles are guideline recommendations. These conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical properties
Hardness, Shore D
@ 25°C, minimum

75

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength Aluminum to aluminum		
@25°C	N/mm ² (psi)	24 (3,500)

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. Some separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 0 to 4°C

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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 Henkel representative.

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 the specifications of this product.

Approval and certificate
Please contact Henkel representative for related approval or certificate of this product.

Data ranges
The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.
Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH



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

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