

LOCTITE® ABLESTIK NCA 2360AB

September 2020

PRODUCT DESCRIPTION

LOCTITE® ABLESTIK NCA 2360AB provides the following product characteristics:

Technology	Epoxy hybrid
Appearance	Black liquid
Product Benefits	<ul style="list-style-type: none"> • Non-conductive • One component • Low temperature cure • High speed dispensing • Minimal RBO • Good adhesion • High elongation • Low modulus • Reworkable
Cure	Heat cure
Application	Electronic Material, Component assembly
Typical Assembly Applications	Camera module and FPS assembly
Key Substrates	Most plastics and Ni

LOCTITE® ABLESTIK NCA 2360AB single component epoxy adhesive is formulated to provide high elongation, increasing drop test performance of the assembled device. It is designed to cure at low temperatures required in the assembly of heat sensitive components.

LOCTITE® ABLESTIK NCA 2360AB is reworkable. The cured bondline is reworked using a hot plate at 120°C or a hot air blower at 200°C.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):	
Speed 5 rpm	7,500
Thixotropic Index (0.5/5 rpm)	3.5
Work Life @ 25°C, days	3
Shelf Life @ -20°C, days	180
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Recommended Heat Cure Schedule

60 minutes @ 80°C

Weight Loss

Weight Loss on Cure, by TGA, %	0.1
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The above cure profile 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	70
Coefficient of Thermal Expansion, ppm/°C:	
Below Tg	60
Above Tg	170
Glass Transition Temperature (Tg) by TMA, °C	30
Extractable Ionic Content, ppm:	
Sodium (Na+)	4
Potassium (K+)	1
Chloride (Cl-)	50
Elongation @ break by Texture, 1 mm/s, %	120
DMA Modulus @ 25°C	N/mm ² 2,000
	(psi) (290,000)

Adhesive Properties

Sample cured 60 minutes @ 80°C

Die Shear Strength, kg-f:

2 x 2 mm Si Die on:	
LCP	8.9
Ni	13.5
PA9T	11.4
PC	15.5

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
4. DO NOT re-freeze. Once thawed to 25°C, the adhesive should not be re-frozen.

DIRECTIONS FOR USE

1. Thawed material should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminations and/or air into the adhesive.
3. Adhesive must be completely used within the products recommended work life.
4. Alternate dispense amounts may be used depending on the application requirements.
5. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.

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: -20°C. Storage below -25°C or greater than -15°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 Henkel Representative.

Conversions

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

Disclaimer

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