

LOCTITE ABLESTIK A329-1J

August 2013

PRODUCT DESCRIPTION

LOCTITE ABLESTIK A329-1J provides the following product characteristics:

Technology	Epoxy
Appearance	beige
Product Benefits	<ul style="list-style-type: none"> • Non-conductive • Thixotropic • One component • Sag resistant • Chemical resistant • Good thermal stability • High temperature performance
Service Temperature	Class F (155°C)
Filler Type	Oxide
Cure	Heat cure
Application	Assembly
Typical Assembly Applications	bonding/insulating metals and for bonding FRP and molded phenolic parts

LOCTITE ABLESTIK A329-1J adhesive is designed for insulating applications. It is made thixotropic to prevent sag during heat cure. LOCTITE ABLESTIK A329-1J bonds offer resistance to water, freon, solvents, acids and strong bases.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	330,000
Press Flow, 3 Kg/cm ² , seconds	37
Density, g/cm ³	1.3
Shelf Life:	
@ 0 to 8°C, days	183
@ 18 to 25°C, days	90
@ 40°C, days	21
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Gel Time

60 seconds @ 160°C

Cure Schedule

30 minutes @ 120°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 120°C in masses up to approximately 15 grams.

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:	
@ 25°C	91
@ 120°C	87
Glass Transition Temperature, °C	126
Coefficient of Thermal Expansion :	
Alpha 1, ppm/°C	59
Alpha 2, ppm/°C	158

Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	5×10 ¹⁵
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TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous

Tensile Strength Al to Al	N/mm ²	18.6
	(psi)	(2,700)

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

DIRECTIONS FOR USE

1. Bring LOCTITE ABLESTIK A329-1J to room temperature before using.
2. 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.
3. Some filler settling 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.
4. Apply adhesive to all surfaces to be bonded and join together.
5. In most applications only contact pressure is required.

Storage

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

Optimal Storage: 0 to 8 °C or between 18 to 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.

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.

Conversions

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

Reference 0.0

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