

# LOCTITE ABLESTIK A 312-20

December 2016

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK A 312-20 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Black
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"><li>• One component</li><li>• Semi flexible</li><li>• Slightly thixotropic</li><li>• 100% Solids material</li><li>• Insulating epoxy adhesive</li><li>• Excellent chemical resistance</li><li>• Excellent heat resistance</li><li>• Excellent moisture resistance</li><li>• Good dielectric properties</li></ul>
<b>Service Temperature</b>	130°C
<b>Application</b>	Encapsulant

LOCTITE ABLESTIK A 312-20 epoxy encapsulant is designed for general potting applications.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity @ 25 °C 20,000, ASTM D2393	20,000
Density, ASTM D792, g/cm <sup>3</sup>	1.21
Shelf Life, days:	
@ 0 to 8 °C	182
@ 18 to 25 °C	122
@ 40 °C	14

Flash Point - See SDS

**TYPICAL CURING PERFORMANCE****Gel Time**

15 minutes @ 100°C
10 minutes @ 120°C
40 seconds @ 160°C

**Cure Schedule**

30 minutes @ 100°C
15 minutes @ 120°C
3 minutes @ 160°C

This product generates low heat during cure. No adverse exotherm effects are obtained when cured at 100°C in masses up to approximately 20 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 PERFORMANCE OF CURED MATERIAL**

Tensile Lap Shear Strength, ASTM D1002:

Al to Al:

Cured 1 hour @ 100°C

N/mm<sup>2</sup> 12  
(psi) (1,740)

**GENERAL INFORMATION**

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

**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. Complete cleaning of the components and substrates should be performed to remove contamination such as dust, moisture, salt and oils which can cause electrical failure, poor adhesion or corrosion in an embedded part.
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.
3. To ensure a void-free embedment, vacuum deairing or degassing should be performed to remove any entrapped air introduced during the mixing operation.
4. Pump-down or pull vacuum on the mixture to achieve an ultimate vacuum or absolute pressure of 1 to 5 torr or mm Hg. The foam will rise several times in the liquid height and then subside.
5. Continue vacuum deairing until most of the bubbling has ceased. This usually takes 3 to 10 minutes.
6. Pour mixture into cavity or mold.
7. Gentle warming of the mold or assembly reduces the viscosity. This improves the flow of the material into the unit having intricate shapes or tightly packed coils or components.
8. Further vacuum deairing in the mold may be required for critical applications.

**STORAGE:**

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

**Optimal Storage: 0 °C to 8°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** $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$  $\text{kV/mm} \times 25.4 = \text{V/mil}$  $\text{mm} / 25.4 = \text{inches}$  $\text{N} \times 0.225 = \text{lb}$  $\text{N/mm} \times 5.71 = \text{lb/in}$  $\text{psi} \times 145 = \text{N/mm}^2$  $\text{MPa} = \text{N/mm}^2$  $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$  $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$  $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$  $\text{mPa}\cdot\text{s} = \text{cP}$ 

Reference 1

**Disclaimer****Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage:** [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.