



LOCTITE® ABLESTIK E 3508 MOD3

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PRODUCT DESCRIPTION

LOCTITE® ABLESTIK E 3508 MOD3 provides the following product characteristics:

Technology	Epoxy
Appearance	Light beige
Product benefits	- One component – requires no mixing - Fast cure
Operating temperature, °C	-40 to 150°C
Cure	Heat cure
Application	Assembly

LOCTITE® ABLESTIK E 3508 MOD3 epoxy adhesive and sealant is designed for high throughput assembly operations. It is also recommended for bonding, sealing or insulating heat sensitive parts.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25°C, mPa·s (cP)	
Cone 2 cm, Angle 2° @ shear rate 50 s ⁻¹	32,500
Thixotropic index	2.75
Density, g/cm ³	1.25
Shelf life @ 0 to 8°C, days	180
Work life @ 19 to 23°C, days	90
Flash point - see SDS	

TYPICAL CURING PERFORMANCE

Recommended cure schedule

- 20 minutes @ 90°C
- 10 minutes @ 120°C
- 4 to 5 minutes @ 140°C

Longer cure times will further improve properties.

This product generates high heat during cure. No adverse exotherm effects when cured at 150°C in masses up to about 10 grams.

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

Shore hardness, Durometer D	88
Hegman fineness (maximum), µm	75
Stroke cure @ 160°C, seconds	5 to 20
Glass transition temperature, °C	
by TMA	113
by DMA	84
Coefficient of thermal expansion, ppm/°C	51
Young's modulus (E)	
@50°C	N/mm ² 2,359
	(psi) (342,000)
@100°C	N/mm ² 9
	(psi) (1,310)
@150°C	N/mm ² 9
	(psi) (1,310)

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear strength

Tensile lap shear strength, Al to Al	
@25°C	N/mm ² 12.7
	(psi) (1,840)
@125°C	N/mm ² 3.2
	(psi) (464)
@150°C	N/mm ² 2.4
	(psi) (348)
@180°C	N/mm ² 2.5
	(psi) (362)
Tensile lap shear strength, PBT to PBT	
@25°C	N/mm ² 2.9
	(psi) (420)
@125°C	N/mm ² 1.0
	(psi) (145)
@150°C	N/mm ² 1.3
	(psi) (188)
@180°C	N/mm ² 1.0
	(psi) (145)

GENERAL INFORMATION

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



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 8°C. Storage below 0°C or greater than 8°C can adversely affect product properties.

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.

Conversions

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

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