

LOCTITE ABLESTIK G 500

February 2017

PRODUCT DESCRIPTION

LOCTITE ABLESTIK G 500 provides the following product characteristics:

Technology	Epoxy
Appearance	Gray
Product Benefits	• One component • Non-conductive • General purpose • Sag resistant • Low viscosity • Non-abrasive • Excellent dielectric properties • Long shelf life at room temperature • Excellent resistance to heat and water • High adhesion strength at elevated temperatures
Cure	Heat cure
Application	Adhesive and Sealant
Operating Temperature	-40 to +180 °C
Typical Assembly Applications	Insulation of copper and other materials and Attaching leads to coils
Key Substrates	Copper, Rigid plastics and Other metals

LOCTITE ABLESTIK G 500 is a general purpose epoxy adhesive and sealant that cures to a high gloss finish.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Density, g/cm ³	1.45
Sag Resistance, mils	750
Press Flow, seconds	45
Storage Life @ 2 to 8°C, days	167
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

- 60 minutes @ 125°C or
- 20 minutes @ 150°C or
- 5 minutes @ 175°C

For optimum performance, follow the initial cure with a post cure of 2 to 4 hours at the highest expected use temperature.

Alternate cure schedules may also be possible. Contact your Henkel representative for further information.

This product generates high heat during cure. No adverse exotherm effects when cured at 150°C in masses up to about 8 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	86
@ 120°C	70

Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	2×10 ¹⁴
Dielectric Strength, kV/mm	15

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength :	
Aluminum to Aluminum @ 25°C:	
N/mm ²	17.1
(psi)	(2,500)

GENERAL INFORMATION

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

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.

DIRECTIONS FOR USE

1. 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.
2. 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.
3. Apply adhesive to all surfaces to be bonded and join together.
4. In most applications only contact pressure is required.
5. Usable shelf life may vary depending on method of application and storage conditions.

STORAGE:

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

Optimal Storage : 2 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

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

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.

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Reference 2