

**ABLESTIK 532**

April 2014

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK 532 provides the following product characteristics:

|                         |  |
|-------------------------|--|
| <b>Technology</b>       | Epoxy Film   |
| <b>Appearance</b>       | White  |
| <b>Cure</b>             | Heat cure  |
| <b>Product Benefits</b> | <ul style="list-style-type: none"><li>• Non-conductive</li><li>• Tack Free</li></ul> |
| <b>Application</b>      | Assembly   |
| <b>Carrier Type</b>     | Glass fabric   |

LOCTITE ABLESTIK 532 non-conductive adhesive film is designed for package sealing applications. This tack-free adhesive eliminates messy handling and clean up associated with liquid epoxy adhesives.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

|   |     |
|---|-----|
| Work Life @ 25°C, days                              | 60  |
| Shelf Life @ -40°C (from date of manufacture), days | 365 |

**TYPICAL CURING PERFORMANCE****Cure Schedule**

2 hours @ 121°C

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****Electrical Properties:**

|  |                       |
|--|-----------------------|
| Volume Resistivity, ohm-cm             | $1.36 \times 10^{14}$ |
| Dielectric Constant/Dissipation Factor | 0.0025/4.59           |

**TYPICAL PERFORMANCE OF CURED MATERIAL****Shear Strength, Lap Shear Strength**

|                 |                   |         |
|-----------------|-------------------|---------|
| Al to Al @ 25°C | N/mm <sup>2</sup> | 17.24   |
|                 | (psi)             | (2,500) |

**GENERAL INFORMATION**

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

**THAWING:**

1. Allow container to reach room temperature before use.
2. 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.
3. DO NOT re-freeze. Once thawed, the adhesive should not be re-frozen.

**DIRECTIONS FOR USE**

1. Place precut adhesive film between clean surfaces to be bonded.
2. Assemble components.

3. Apply spring loaded clamp or dead weight to provide continuous pressure of at least 1 to 5 psi during cure cycle.
4. Place assembly in a preheated oven and cure at the recommended cure schedule.

**AVAILABILITY**

1. LOCTITE ABLESTIK 532 adhesive is available in sheet stock or die cut preforms.
2. LOCTITE ABLESTIK 532 adhesive can be die cut to customer specifications.
3. Tolerances are as close as  $\pm 0.005$  inch in length or width and  $\pm 0.001$  inch in thickness.
4. This adhesive film can be supplied on 1/2-mil or 1-mil polyester film.

**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: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °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 Technical Service Center or Customer Service Representative.

**Conversions**

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



**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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