

# LOCTITE ABLESTIK 2332HF

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## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 2332HF 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>• Excellent adhesion</li> <li>• Non-conductive</li> <li>• Low temperature cure</li> <li>• High strength</li> <li>• Low halogen content (total Cl &amp; Br &lt;1500 ppm)</li> </ul> |
| <b>Application</b>           | Non-conductive adhesive                                                                                                                                                                                                                            |
| <b>Operating Temperature</b> | -40 to 150 °C                                                                                                                                                                                                                                      |
| <b>Surfaces</b>              | Copper, Aluminum, Nickel, FRP and Rigid plastics                                                                                                                                                                                                   |

LOCTITE ABLESTIK 2332HF is a solventless epoxy adhesive that develops high bond strength when cured at temperatures as low as 100°C. This product combines toughness at low temperatures plus high peel and tensile shear strengths over a very broad temperature range.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP) 75,000

Specific Gravity 1.2

Shelf Life @ 0 to 8°C, days 183

Flash Point - See SDS

## TYPICAL CURING PERFORMANCE Cure Schedule

1 hour @ 120°C

## Alternative Curing Conditions

90 minutes @ 100°C or

30 minutes @ 120°C or

20 minutes @ 150°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

### Physical Properties :

Coefficient of Thermal Expansion , K<sup>-1</sup> 100×10<sup>-6</sup>

Glass Transition Temperature (Tg) by TMA, °C 105

Hardness, Shore D @ 25°C 78

Tensile Modulus, DMTA :

@ 30 °C N/mm<sup>2</sup> 1,253  
(psi) (181,732)

@ 100 °C N/mm<sup>2</sup> 513  
(psi) (74,404)

Linear Shrinkage, % 2.3

### Electrical Properties:

Volume Resistivity, ohm-cm @ 25°C 6×10<sup>14</sup>

## TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Aluminum:

Tested @ 25 °C N/mm<sup>2</sup> 32.9  
(psi) (4,771)

Tested @ 90 °C N/mm<sup>2</sup> 26.5  
(psi) (3,843)

Tested @ 125 °C N/mm<sup>2</sup> 14.1  
(psi) (2,045)

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
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

## 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: 0 to 8°C. Storage greater than or below 0 to 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 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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