

LOCTITE ABLESTIK CE 3513

November 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK CE 3513 provides the following product characteristics:

Technology	Epoxy
Appearance	Silver
Product Benefits	<ul style="list-style-type: none">• Electrically conductive• One component• Low viscosity• No bleed• Good dispense behavior• Fast cure at high temperatures• Long shelf life at room temperature• High bond strength• Heat resistant after cure
Operating Temperature	150°C
Cure	Heat cure
Filler Type	Silver
Application	Assembly

LOCTITE ABLESTIK CE 3513 adhesive is designed for use in automated assembly and in-line curing operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, 10 rpm @ 25°C, mPa·s (cP)	40,000
Density, g/cm ³	3
Pot life @ 18 to 25°C, days	>14
Shelf Life @ -40 to -18°C (from date of manufacture), 183 days	
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE Cure Schedule**Convection Oven:**

1hour @ 100°C
45minutes @ 120°C
20minutes @ 150°C

Hot Plate:

60seconds maximum @ 180 to 190°C

Properties of the cured material will depend upon the cure schedule used. Low temperature cure will reduce electrical conductivity.

The above cure profile is a guideline recommendation. 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, ohms-cm:	
Cure @ 180°C	2×10 ⁻⁴
Cure @ 100°C	1×10 ⁻³

TYPICAL PERFORMANCE OF CURED MATERIAL**Miscellaneous:**

Tensile Lap Shear Strength	N/mm ² 12
	(psi) (1,740)

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 : -40 to -18 °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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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