

# LOCTITE ABLESTIK NCA 3285

April 2014

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK NCA 3285 provides the following product characteristics:

|                             |                                                                                                                                                                                                                  |
|-----------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Technology</b>           | Epoxy                                                                                                                                                                                                            |
| <b>Appearance</b>           | Black liquid                                                                                                                                                                                                     |
| <b>Product Benefits</b>     | <ul style="list-style-type: none"> <li>• One component</li> <li>• Fast cure at low temperatures</li> <li>• High service temperature reliability</li> <li>• Excellent adhesion</li> <li>• Halogen free</li> </ul> |
| <b>Cure</b>                 | Heat cure                                                                                                                                                                                                        |
| <b>Application</b>          | Non-conductive adhesive                                                                                                                                                                                          |
| <b>Typical Applications</b> | Lens bonding, Image sensors, Multimedia card (MMC) assembly                                                                                                                                                      |

LOCTITE ABLESTIK NCA 3285 is designed for heat sensitive applications requiring a low cure temperature. It cures rapidly providing customers high throughput in applications, such as, bonding of light-diffusing lenses over LEDs and assembly of image sensing devices including camera modules.

LOCTITE ABLESTIK NCA 3285 is formulated to provide higher levels of adhesion at high service temperatures (60°C), while providing sufficient flexibility to survive manufacturing assembly processes.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

|                                                     |        |
|-----------------------------------------------------|--------|
| Viscosity, Cone & Plate, Angle 2°, mPa·s (cP):      |        |
| @ Shear rate of 2 s <sup>-1</sup>                   | 59,000 |
| @ Shear rate of 20 s <sup>-1</sup>                  | 15,300 |
| Thixotropic Index                                   | 4      |
| Specific Gravity @ °C                               | 1.3    |
| Work Life @ 25°C, days                              | >7     |
| Shelf Life @ -20°C (from date of manufacture), days | 365    |
| Flash Point - See SDS                               |        |

## TYPICAL CURING PERFORMANCE

### Cure Schedule

2 minutes @ 80°C

With all curing systems, the time required for cure depends on the rate of heating. Cure rate depends on the mass of material to be heated and intimate contact with the heat source. Use suggested cure conditions as general guidelines. Other cure conditions may yield satisfactory results.

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

Sample cured 30 minutes @ 80°C

### Physical Properties

|                                              |                         |
|----------------------------------------------|-------------------------|
| Hardness, Shore D, ASTM D2240                | 79                      |
| Coefficient of Thermal Expansion, ppm/°C:    |                         |
| Below Tg                                     | 64                      |
| Above Tg                                     | 181                     |
| Glass Transition Temperature (Tg) by TMA, °C | 44                      |
| DMA Modulus @ 25 °C                          | N/mm <sup>2</sup> 3,370 |
|                                              | (psi) (488,777)         |

## TYPICAL PERFORMANCE OF CURED MATERIAL

Sample cured 30 minutes @ 80°C

### Shear Strength

|                                    |                      |
|------------------------------------|----------------------|
| Tensile Strength @ 25 °C:          |                      |
| TS024 75 µm thickness, 1 mg sample | N/mm <sup>2</sup> 20 |
|                                    | (psi) (2,900)        |

## GENERAL INFORMATION

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

### 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 : -20 °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**

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

Reference 0.0

**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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[Loctite:](#)

[1860755](#)