

# LOCTITE ABLESTIK 724-14C

April 2017

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 724-14C provides the following product characteristics:

<b>Technology</b>	Polyurethane
<b>Appearance</b>	Amber
<b>Cure</b>	Room temperature or Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Premixed and frozen</li> <li>• Good adhesion</li> <li>• Good dielectric properties</li> </ul>
<b>Application</b>	Component assembly, Non-conductive adhesive
<b>Substrates</b>	Aluminum, Solder, Nylon, Mylar or Steel

LOCTITE ABLESTIK 724-14C is designed to provide strong, resilient bonds even in cryogenic conditions. It can also be used for tacking wires and as a protective coating. This adhesive contains a fluorescent trace for inspection purposes.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Viscosity, mPa·s (cP)	500,000
Extrusion Rate, 18 Gauge Needle @ 80 psi, g/min	0.25
Specific Gravity, mixed	1.1
Work Life @ 25°C,	30
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 72hours @ 25°C or
- 3 hours @ 74°C or
- 1 hour @ 93°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 :

Hardness, Shore A	90
Tensile Strength:	
N/mm <sup>2</sup>	31.72
(psi)	4,600
Elongation @ break, %	450
Thermal Conductivity, BTU/ (hr.)(Sq. Ft.)(°F/in)	0.917

## TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength, Al to Al	N/mm <sup>2</sup>	12
	(psi)	(1,700)
Peel Strength, lb/in		20

## 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. For pre-mixed and frozen products, thaw adhesive to room temperature. A 25°C water bath is recommended.
3. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
4. Cure at recommended cure schedules.

## 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

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

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Reference 1

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