

# LOCTITE ABLESTIK D 275

December 2016

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK D 275 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</li><li>• High strength</li><li>• High tensile lap shear strength</li><li>• Good peel strength</li><li>• Reduced stress</li><li>• Good toughness</li></ul>
<b>Cure</b>	Heat cure
<b>Operating Temperature</b>	-40 to 130 °C
<b>Application</b>	Structural bonding
<b>Substrates</b>	Metals, Plastics and Ceramic

LOCTITE ABLESTIK D 275 is designed for high strength structural bonding applications. LOCTITE ABLESTIK D 275 cures to a semi-rigid material which reduces stress on bonded components and has good toughness.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Density, ASTM D792, g/cm <sup>3</sup>	1.14
Brookfield Viscosity Sp #6, ASTM D2393, mPa·s (cP):	
Speed 5 rpm	70,000
Shelf Life @ 25°C, days	122
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE Cure Schedule**

60 minutes @ 100°C or  
20 minutes @ 120°C or  
6 minutes @ 160°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 120°C in masses up to approximately 15 grams.

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, ASTM D2240:	
Shore D @ 25°C	80
Shore A @ 120°C	75
Water Absorption, ASTM D 570 , %	0.8

**Electrical Properties:**

Volume Resistivity @ 25°C, ASTM D257, ohm-cm	6.0×10 <sup>14</sup>
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**TYPICAL PERFORMANCE OF CURED MATERIAL**

Tensile Lap Shear Strength , ASTM D1002:

Al to Al @ 25°C	N/mm <sup>2</sup>	31
	(psi)	(4,500)

Tensile Peel Strength , ASTM D1876, N/m:

Al to Al @ 25°C	2,100
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**GENERAL INFORMATION**

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

**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 separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be gently but 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

**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 : 25 °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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

## 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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