

# LOCTITE ABLESTIK NCA 2350

April 2019

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK NCA 2350 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>Fast cure at low temperature</li> <li>One component</li> <li>Good adhesion</li> </ul>
<b>Cure</b>	Heat cure
<b>Application</b>	Adhesive and Sealant
<b>Typical Assembly Applications</b>	Camera module housing assembly

LOCTITE ABLESTIK NCA 2350 is designed for use in heat sensitive devices.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield CP51, 25 °C, mPa·s (cP):	
Speed 5 rpm	13,670
Thixotropic Index	3.7
Pot Life @ 25°C, days	3
Shelf Life @ -20 °C, days	183
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Recommended Cure

2 minutes @ 80 °C in hot plate

30 minutes @ 80°C in conventional oven

### Weight Loss on Cure

Weight Loss on Cure, % 0.21

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Hardness, Shore D	75
Coefficient of Thermal Expansion, ppm/°C:	
Below Tg	66
Above Tg	180
Glass Transition Temperature (Tg) by TMA, °C	28
Volumetric Shrinkage on Cure, %	2.8
Elongation, at break, %	110
Tension Modulus :	
@ 25°C	N/mm <sup>2</sup> 2,533 (psi) (367,380)
@ 85°C	N/mm <sup>2</sup> 30 (psi) (4,351)

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Shear Strength

Lap Shear Strength	N/mm <sup>2</sup> 18 (psi) (2,610)
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## GENERAL INFORMATION

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

### 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

- 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.
- 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.
- Apply adhesive to all surfaces to be bonded and join together.
- In most applications only contact pressure is required.
- 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

(°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/mm<sup>2</sup>  
 MPa = N/mm<sup>2</sup>  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = 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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