

LOCTITE ABLESTIK 293-1.5T

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 293-1.5T provides the following product characteristics:

Technology	Epoxy
Appearance	Black liquid
Components	One-component
Product Benefits	• General purpose
Cure	Heat cure
Application	General assembly
Surfaces	Gold, Nickel, Silver, Copper and Brass

LOCTITE ABLESTIK 293-1.5T epoxy adhesive is designed to provide strong, semi-rigid bonds to a variety of difficult-to-bond substrates, such as gold, nickel, silver, copper, and brass. This version of the 293-series is designed to be more flexible.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Work Life @ 25 °C, hours	8
Shelf Life @ -40 °C, days	365
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Cure Schedule**

24 hours @ 60°C

Alternate Cure Schedule

4 hours @ 75°C or
1.5 hours @ 95°C or
45 minutes @ 120°C

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 PERFORMANCE OF CURED MATERIAL

Tensile Shear Strength @ 25 °C:

Al to Al	N/mm ² 37 (psi) (5,500)
Au to Au	N/mm ² 27 (psi) (4,000)
Ag to Ag	N/mm ² 26 (psi) (3,800)
Brass to brass	N/mm ² 27 (psi) (4,000)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Thaw adhesive to room temperature.
2. Apply adhesive as required.
3. Assemble bonds.
4. Cure at the 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.

AVAILABILITY

1. This adhesive is available in a variety of package sizes, ranging from 1 cc to 1pound.

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 This adhesive is shipped frozen and must be stored continually at -40°C or colder until ready to use.

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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