

LOCTITE ABLESTIK CE 8500-S39

August 2018

PRODUCT DESCRIPTION

LOCTITE ABLESTIK CE 8500-S39 provides the following product characteristics:

Technology	Modified epoxy
Appearance	Silver
Cure	Heat cure
Product Benefits	• One component • Low stress • 39 µm spacers for bondline thickness control
Application	Component assembly, Electrically Conductive Adhesive
Operating Temperature	up to 200°C

LOCTITE ABLESTIK CE 8500-S39 is a solventless epoxy adhesive that combines low stress with good adhesion on nearly all surfaces. This adhesive is suitable for use on applications with mismatched CTE.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield, 25 °C, mPa·s (cP):

Speed 10 rpm, #TD	130,000
Density, g/cm ³	3.12
Shelf Life @ -25 to -18°C, days	122
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Cure Schedule**

2 hours @ 110°C
90 minutes @ 120°C
40 minutes @ 150°C
15 minutes @ 175°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 :**

Glass Transition Temperature, °C	24
Extractable Ionic Content, ppm:	
Chloride (Cl-)	150
Sodium (Na+)	10
Potassium (K+)	10
Ammonium (NH ₄ ⁺)	10

Electrical Properties:

Volume Resistivity, ohm-cm	1 x 10 ⁻³
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TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength	N/mm ² 3
	(psi) (435)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. The surfaces on which the adhesive has to be applied should be clean, dry and free from all dust.
2. Refrigeration between -25 to -18°C is required to maintain viscosity.
3. Allow unopened container to reach room temperature before use.

STORAGE:

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: -18 °C to -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

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

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