

# LOCTITE ABLESTIK 3119

August 2016

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 3119 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Chemical Type</b>	Epoxy
<b>Appearance (uncured)</b>	Black viscous liquid <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Cure</b>	Heat cure
<b>Cure Benefit</b>	Production - high speed curing at low temperature
<b>Application</b>	Bonding

LOCTITE ABLESTIK 3119 cures rapidly at relatively low temperature and provides excellent adhesion on a wide range of substrates. Typical applications include the assembly of electronics components which are heat sensitive.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1 to 1.3 <sup>LMS</sup>
Yield Point, 25 °C, mPa·s	10,000 to 38,000 <sup>LMS</sup>
Cone & Plate Rheometer	
Casson Viscosity @ 25 °C, mPa·s (cP)	7,000 to 23,000 <sup>LMS</sup>
Cone & Plate Rheometer	
Pot life @ 25 °C, weeks	3

## TYPICAL CURING PERFORMANCE

### Recommended Curing Conditions

60 minutes @ 100 °C bondline temperature  
120 minutes @ 75 °C bondline temperature

Note: Sufficient time must be added to allow the bond location to reach the desired cure temperature. Curing profiles should be developed for each device.

## TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 60 minutes @ 100 °C

### Physical Properties:

Density @ 25 °C, g/cm <sup>3</sup>	1.2
Shore Hardness, ISO 868, Durometer D	87
Glass Transition Temperature, °C: (T <sub>g</sub> ) via DMA, ASTM E 1640	110
Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup> :	
alpha 1	65×10 <sup>-6</sup>
alpha 2	210×10 <sup>-6</sup>
Water Absorption, ISO 62, %:	
24 hours in water @ 23 °C	0.36
Elongation, at break, ISO 527-3, %	3.3
Tensile Strength, at break, ISO 527-3	N/mm <sup>2</sup> 56 (psi) (8,100)

Tensile Modulus, ISO 527-3

N/mm<sup>2</sup> 2,300  
(psi) (330,000)

### Electrical Properties:

Volume Resistivity, IEC 60093, Ω·cm	3.6×10 <sup>16</sup>
Surface Resistivity, IEC 60093, Ω	1.7×10 <sup>16</sup>
Dielectric Constant / Dissipation Factor, IEC 60250:	
10 kHz	4.0 / 0.01
1 MHz	3.8 / 0.02
10 MHz	3.7 / 0.03

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 60 minutes @ 100 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm <sup>2</sup> 24 (psi) (3,500)
Epoxyglass (thickness 1.6 mm)	N/mm <sup>2</sup> ≥10 <sup>LMS</sup> (psi) (≥1,450)

## TYPICAL ENVIRONMENTAL RESISTANCE

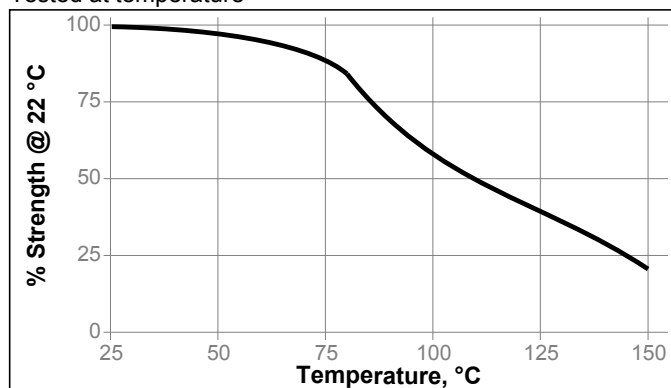
Cured for 60 minutes @ 100 °C

Lap Shear Strength, ISO 4587:

Epoxy glass (thickness 1.6 mm)

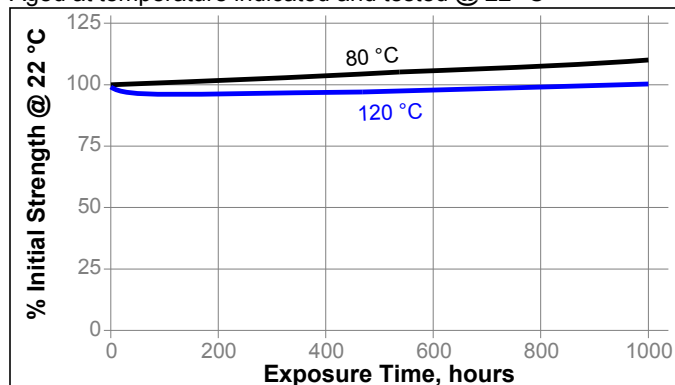
### Hot Strength

Tested at temperature



**Heat Aging**

Aged at temperature indicated and tested @ 22 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
90% RH	60	95	95	90
90% RH	40	95	95	95

**GENERAL INFORMATION**

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

**Handling Information****1. Receiving Frozen Shipments**

All shipments of this product are shipped frozen with dry ice.

**2. Thawing**

After shipping on dry ice, the material should be stored at -15 °C to -25 °C for optimum shelf life and to minimize the occurrence of freeze thaw voids.

**Loctite Material Specification<sup>LMS</sup>**

LMS dated January 29, 2004. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**Storage**

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

**Optimal Storage: -15 °C to -25 °C. Storage below minus (-)25 °C or greater than minus (-)15 °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**

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

**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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