Technical Data Sheet

LOCTITE ABLESTIK 816H02 BIPAX

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK 816H02 BIPAX provides the following product characteristics:

Technology	Epoxy
Appearance	Blue
Components	Two components - requires mixing
Product Benefits	• Thermally conductive • Electrically Insulating • Thixotropic
Cure	Room Temperature or Heat Cure
Application	Thermally conductive adhesive
Surfaces	Metals, Silica, Steatite, Alumina, Sapphire, Ceramics, Glass and Plastics

LOCTITE ABLESTIK 816H02 BIPAX adhesive is used for staking transistors, diodes, resistors, integrated circuits and other heat-sensitive componenets to printed circuit boards. This adhesive develops strong, durable, high-impact bonds at room temperature. This improves heat transfer while maintaining electrical isolation. LOCTITE ABLESTIK 816H02 BIPAX bonds offer resistance to salt solutions, mild acids and alkalis, petroleum solvents, lubricating oils, alcohol and other chemicals.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties:

Mixed Viscosity, Brookfield SSA, 25 °C, mPa·s (cP):	
Speed 5 rpm	212,000
Pot Life , minutes:	
@ 25 grams	45
@ 100 grams	35
Work Life, minutes:	
@ 25 grams	90
@ 100 grams	75
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE Cure Schedule

24 hours @ 25°C or
2 to 4 hours @ 65°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 PROPERTIES OF CURED MATERIAL

Physical Properties :

Hardness, Shore D 1 hour @ 65°C	91
Glass Transition Temperature (Tg), °C	63.0

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength

Al to Al :		
1 hour @ 65°C	N/mm²	22.8
	(psi)	(3,300)
:		
Al to Al :		
1 hour @ 65°C	N/mm²	22.8
	(psi)	(3,300)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded.
2. Remove clamp and thoroughly mix the LOCTITE ABLESTIK 816H02 BIPAX epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout.
3. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
4. Some separation of components 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.
5. Some ingredients in this formulation provided in BIPAX, TRA-PAX and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 52ºC for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results.

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 : ≤27 °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/mm²
MPa = N/mm²
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
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