Technical Data Sheet

LOCTITE ABLESTIK G 909

August 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK G 909 provides the following product characteristics:

Technology	Epoxy
Appearance	gray
Cure	Heat cure
Product Benefits	• One component • High strength • Non-sag • Thixotropic • Excellent peel strength • High tensile shear strength over a broad temperature range
Application	Assembly
Surfaces	Copper, Aluminum, Fiberglass reinforced plastics and Oily steel
Operating Temperature	-40 to 150 °C

LOCTITE ABLESTIK G 909 is designed for very high strength structural bonding especially for dissimilar substrates that will be exposed to a wide range of operating temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity	1.15
Press Flow, seconds	65
Sag Resistance, mm	12.7
Shelf Life @ 0 to 4°C (from date of manufacture), months	4.5
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

90 minutes @ 100°C or
30 minutes @ 120°C or
20 minutes @ 150°C

For optimum performance, follow the initial cure with a post cure of 2 to 4 hour at the highest expected use temperature.

Cure schedules are "the time at cure temperature to achieve full product cure". The times does not include the time required to ramp-up to cure temperature.

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

Hardness, Shore D:	
@ 25ºC	78
@ 120ºC	35

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous

Tensile Lap Shear Strength:

Aluminium @ 25°C	N/mm² (psi)	40 (5,800)
Aluminum @ 100°C	N/mm² (psi)	20.3 (2,950)
Steel @ 25°C	N/mm² (psi)	32.4 (4,700)

Peel Strength - Hysol

"T" Peel Strength, ISO 11339:

Aluminum	N/mm (lb/in)	5.25 (30)

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

1. 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.
2. Apply adhesive to all surfaces to be bonded and join together.
3. In most applications only contact pressure is required.

Storage

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

Optimal Storage: 4°C. Storage greater than or below 4°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

(°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

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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