

LOCTITE ABLESTIK A 312E

October 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK A 312E provides the following product characteristics:

Technology	Epoxy
Appearance	Black
Cure	Heat cure
Product Benefits	<ul style="list-style-type: none"> • One component • Fast cure • Unfilled • Solvent-free
Application	Encapsulant

LOCTITE ABLESTIK A 312E epoxy encapsulant is designed for insulating applications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm	3,000
Density, g/cm ³	1.14
Shelf Life (from date of manufacture):	
@ 0 to 8°C, days	180
@ 18 to 25°C, days	60
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

40 minutes @ 100°C
15 minutes @ 120°C
7 minutes @ 160°C

Alternate cure schedules may also be possible. Contact your Henkel representative for further information.

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 (minimum)	80
Glass Transition Temperature, °C	100
Coefficient of Linear Thermal Expansion, ppm/°C	69
Thermal Conductivity, W/(m·K)	0.25
Stroke Cure @ 160°C, seconds	50

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Tensile Lap Shear Strength	N/mm ² 13	(psi) (1,885)
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GENERAL INFORMATION

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

Storage

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

Optimal Storage : 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

(°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/mm ²
MPa = N/mm ²
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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Reference 1

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