



Technical Data Sheet

LOCTITE ABLESTIK 342-3.5

August 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 342-3.5 provides the following product characteristics:

Technology	Epoxy
Appearance	Amber
Cure	Room Temperature or Heat Cure
Product Benefits	<ul style="list-style-type: none"> Two component Room temperature cure Good adhesion Excellent thermal shock
Application	General assembly

LOCTITE ABLESTIK 342-3.5 epoxy adhesive is designed for general purpose applications. This adhesive cures at room temperature, while providing a reasonable work life. LOCTITE ABLESTIK 342-3.5 adhesive may be used to bond semi-porous materials such as ferrites, where a physical rather than a chemical bond is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Brookfield Viscosity CP51, mPa·s (cP):

@ Speed 5 rpm, @ 25°C 5,000

Work Life @ 25°C, (25% increase in viscosity), hours 8

Shelf Life (from date of manufacture):

@ 25°C, in kits, days 365

@ -40°C, pre-mixed or frozen syringes, days 365

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Cure Schedule

48 hours @ 25°C

Alternate Cure Schedule

4 hours @ 75°C or

2 hours @ 95°C or

1 hour @ 120°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

Hardness, Shore D 86

Glass Transition Temperature (T_g), °C 71

Coefficient of Thermal Expansion, TMA:

Below T_g, ppm/°C 35

Above T_g, ppm/°C 180

TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength :

Al to Al @ 25°C

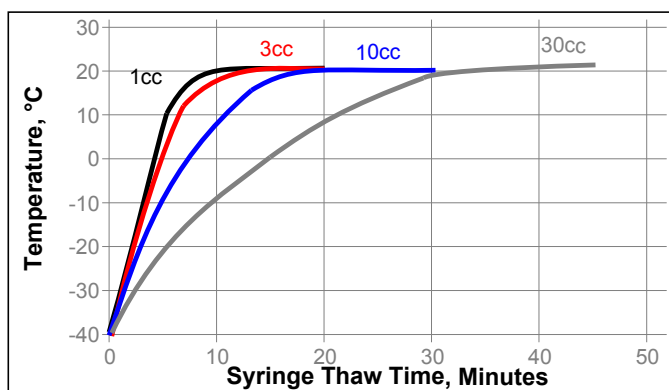
N/mm² 29.0
 (psi) (4,200)

GENERAL INFORMATION

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

THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. Refer to the Syringe Thaw time chart for the thaw time recommendation.
4. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
5. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.



DIRECTIONS FOR USE

1. Thawed adhesive should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Adhesive must be completely used within the product's recommended work life.
4. Apply enough adhesive to achieve a μ m wet bondline thickness, dispensed with approximately % filleting on all sides of the die.
5. Alternate dispense amounts may be used depending on the application requirements.



6. Star or crossed shaped dispense patterns will yield fewer bondline voids than the matrix style of dispense pattern.
7. Please contact your Henkel Technical Service representative for details on directions for use regarding your specific application.
8. For kits, follow mixing instructions included in kit.

AVAILABILITY

1. LOCTITE ABLESTIK 342-3.5 this adhesive is available premixed and frozen in a variety of sizes or in pound kits.

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: 25°C in kits and -40°C pre-mixed or frozen syringes. Storage below or above 25°C in kits and -40°C pre-mixed or frozen syringes 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

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

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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