Technical Data Sheet

LOCTITE ABLESTIK A 304-6

September 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK A 304-6 provides the following product characteristics:

Technology	Epoxy
Appearance	Light blue
Product Benefits	• Non-conductive • One component • Readily pourable • Fast cure • Good toughness • Excellent chemical resistance
Operating Temperature Range	-40 to +155ºC
Cure	Heat cure
Application	Adhesive and Sealant
Typical Package Application	• End cap adhesive for hydraulic oil • High temperature industrial/aerospace filters

LOCTITE ABLESTIK A 304-6 epoxy adhesive and sealant is designed for high throughput assembly operations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	21,500
Density, g/cm³	1.5
Shelf Life @ 25 °C, days	120
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Gel Time

10 minutes @ 120°C
70 seconds @ 160°C
15 seconds @ 180°C

Cure Schedule

1hour @ 120°C
30 minutes @ 160°C
15 minutes @ 180°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 160ºC in masses up to approximately 30 grams.

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 (units):		
@ 25ºC		80
@ 125ºC		50
Thermal Conductivity , W/(m-K)		0.44
Resistance , 200 hours @ 125ºC:		
Skydrol 500		No attack
7808 Hydraulic Oil		No attack
Glass Transition Temperature, 1 hr @ 120ºC, °C		104
Coefficient of Linear Thermal Expansion, 1 hr @ 120ºC, ppm/ºC:		
Below Tg		41
Above Tg		135
Tensile Modulus:		
@ 35°C	N/mm² (psi)	3,833 (555,930)
@ 40°C	N/mm² (psi)	3,810 (552,590)
@ 60°C	N/mm² (psi)	3,603 (522,570)
@ 80°C	N/mm² (psi)	3,032 (439,750)
@ 100°C	N/mm² (psi)	1,794 (260,200)
@ 125°C	N/mm² (psi)	564 (81,800)
@ 150°C	N/mm² (psi)	244 (35,390)
@ 175°C	N/mm² (psi)	123 (17,840)

Electrical Properties

Volume Resistivity, ohms-cm	1×10^{14}
Dielectric Strength, kV/mm	15.3

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength :

Tensile Lap Shear Strength @ 25 °C	N/mm² (psi)	18 (2,610)

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.

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/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

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Reference 0.0