

LOCTITE ABLESTIK KS 0004 KIT

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PRODUCT DESCRIPTION

LOCTITE ABLESTIK KS 0004 KIT provides the following product characteristics:

Technology	Epoxy
Appearance	Silver
Components	Two-component
Product Benefits	• High volume conductivity • High bond strength • High reliability performance
Cure	Heat cure or Room temperature
Application	Encapsulation, Potting
Solids Content, %	100
Mix Ratio, by weight - Resin : Hardener	100 : 8

LOCTITE ABLESTIK KS 0004 KIT is a two component 100% solids epoxy putty having high volume conductivity. LOCTITE ABLESTIK KS 0004 KIT has characteristic epoxy high bond strength to most materials. It is used successfully to make electrical bonds where the heat of soldering is impractical. It is used to ensure high reliability of electrical connections, to bond RF shields and prepare conductive surface. A 4-ounce kit of LOCTITE ABLESTIK KE 4238 with sufficient hardener LOCTITE STYCAST HD 3475 is available as LOCTITE ABLESTIK KS 0004 KIT.

TYPICAL PROPERTIES OF UNCURED MATERIAL**Part A Properties LOCTITE ABLESTIK KE 4238**

Filler Content, %	73
Specific Gravity @ 25°C	3.025
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 5, speed 4 rpm	Paste
Shelf Life @ 25°C (from date of shipment), days	365
Flash Point - See SDS	

Part B Properties LOCTITE STYCAST HD 3475

Specific Gravity @ 25 °C	1.1
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 5, speed 4 rpm	7,000
Color, maximum	Gardner 10
Shelf Life @ 25°C (from date of shipment), days	365
Flash Point - See SDS	

Mixed Properties LOCTITE ABLESTIK KS 0004

Density, lb/cu in	0.105
Pot Life @ 25°C, 20 gram mass, minutes	35
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE AS MIXED**Recommended Cure Schedule**

2 hours @ 60°C

Alternate Cure

24 hours @ 25°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 AS MIXED**Physical Properties**

Flammability	Pass
Thermal Conductivity :	
BTU x in/(hrs x sq ft x °F)	145
Cal x cm/(sec x sq cm x °C)	500×10 ⁻⁴
Guide to Operating Class, IEEE °C	105

Electrical Properties

Volume Resistivity @ 25°C, ohm-cm	0.01
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A thin strip of adhesive is drawn down on a glass slide and cured. Approximate dimensions are 2.0" x 0.25" x .0035". Minimum cure temperature of 60°C is required for maximum electrical conductivity.

TYPICAL CURED PERFORMANCE AS MIXED**Miscellaneous**

Tensile Shear Strength, aluminium to aluminium:	
Cured 2 hours @ 60°C	N/mm ² 13.1
	(psi) (1,900)
Cured 36 hours @ 25°C	N/mm ² 9.65
	(psi) (1,400)

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. Mix LOCTITE ABLESTIK KE 4238 thoroughly in its container before measuring.

STORAGE:

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

Optimal Storage : 8 to 28 °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

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

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