Technical Data Sheet

LOCTITE ABLESTIK E 3508 MOD3

January 2015

PRODUCT DESCRIPTION

LOCTITE ABLESTIK E 3508 MOD3 provides the following product characteristics:

Technology	Epoxy
Appearance	Light beige
Product Benefits	• One component, requires no mixing • Fast cure
Operating Temperature	-40 to +150ºC
Cure	Heat
Application	Assembly

LOCTITE ABLESTIK E 3508 MOD3 epoxy adhesive and sealant is designed for high throughput assembly operations. It is also recommended for bonding, sealing or insulating heat sensitive parts.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25ºC, mPa·s (cP):	
Cone 2 cm, Angle 2º @ Shear rate 50 s^{-1}	32,500
Thixotropic Index	2.75
Density , g/cm^3	1.25
Shelf Life, time to triple in viscosity, days:	
@ 0 to 8°C	183
@ 18 to 25°C	91
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Recommended Cure Schedule

20 minutes @ 90 °C
10 minutes @ 120 °C
4 to 5 minutes @ 140 °C

Longer cure times will further improve properties.

This product generates high heat during cure. No adverse exotherm effects when cured at 150°C in masses up to about 10 grams.

The above cure profile is a guideline recommendation. 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

Shore Hardness, Shore D	88
Hegman Fineness (maximum), µm	75
Stroke Cure @ 160ºC, seconds	5 to 20
Glass Transition Temperature, °C:	
by TMA	113
by DMA	84
Coefficient of Linear Thermal Expansion , ppm/°C	51

Young's modulus (E) :

@ 50°C	N/mm²	2,359
	(psi)	(342,000)
@ 100°C	N/mm²	9
	(psi)	(1,310)
@ 150°C	N/mm²	9
	(psi)	(1,310)

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Tensile Lap Shear Strength , Al to Al:

@ 25°C	N/mm²	12.7
	(psi)	(1,840)
@ 125°C	N/mm²	3.2
	(psi)	(464)
@ 150°C	N/mm²	2.4
	(psi)	(348)
@ 180°C	N/mm²	2.5
	(psi)	(362)

Tensile Lap Shear Strength , PBT to PBT:

@ 25°C	N/mm²	2.9
	(psi)	(420)
@ 125°C	N/mm²	1.0
	(psi)	(145)
@ 150°C	N/mm²	1.3
	(psi)	(188)
@ 180°C	N/mm²	1.0
	(psi)	(145)

GENERAL INFORMATION

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

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 : 0 to 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
N/mm² x 145 = psi
MPa = N/mm²
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Reference 0.0

Disclaimer

Note:
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