

LOCTITE ABLESTIK CE 3520-3

April 2014

PRODUCT DESCRIPTION

LOCTITE ABLESTIK CE 3520-3 provides the following product characteristics:

Technology	Epoxy
Appearance	Dark gray paste
Filler Type	Nickel
Product Benefits	<ul style="list-style-type: none"> • One component • Electrically conductive • Low stress • Flexible epoxy • Flexible for Bonding Mismatched Adherends
Cure	Heat cure
Operating Temperature	-45 to 125 °C
Application	Electrically Conductive Adhesive
Typical Assembly Applications	Component attach and Heat sink bonding

LOCTITE ABLESTIK CE 3520-3 adhesive combines a high elasticity with a good adhesion on a variety of surfaces, making it suitable for applications with mismatched CTE.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity at 25°C, mPa·s (cP) (Plate 2 cm at 15 s ⁻¹)	73,000
Work Life @ 18 to 25°C, days	3
Shelf Life @ -25 to -18°C, days	183
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE
Cure Schedule

- 60 minutes @ 120°C or
- 30 minutes @ 150°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	40 to 60
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Electrical Properties

Volume Resistivity, ohms-cm	0.2
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TYPICAL PERFORMANCE OF CURED MATERIAL
Miscellaneous

Tensile Lap Shear Strength	N/mm ² 9 (psi) (1,305)
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GENERAL INFORMATION

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

Thawing:

1. Allow container to reach room temperature before use.

DIRECTIONS FOR USE

1. The surfaces on which the adhesive has to be applied should be clean, dry and free from all dust.

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 to -18 °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

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

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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