

ABLESTIK 50126 FC

October 2016

Key Feature	Benefit
Fast cure at room temperature	Quick handling
1 to 1 mix ratio	Use of static mixer

Product Description :

ABLESTIK 50126 FC is an accelerated version of ABLESTIK 50126. ABLESTIK 50126 FC is an extremely fast curing, two component epoxy adhesive curing in 5 to 6 minutes at room temperature. The desired quantities of part A and part B are mixed together and put on the parts that have to be adhered. Two parts are immediately brought together. Adhesion properties are optimal after a few minutes.

Applications :

ABLESTIK 50126 FC is recommended as an adhesive for metals and for many plastics. Since cure is extremely fast, resulting in high exotherm, using large quantities is not advisable.

Instructions For Use :

- Weigh out the required quantity of Part A and Part B. Mix ratio is 100 parts of Part A by 100 parts of Part B (W/W).
- Mix Part A and Part B homogeneous by using a propeller mixer or static mixer.
- Evacuate only when necessary.
- Pot life is very short, about 4 minutes.

Note : Heat up to maximum 65°C to decrystallise product (maximum of 24 h, depending on packaging).

Properties Of Material As Supplied :

Property	Test Method	Unit	Value
Chemical Type			epoxy
Appearance - Part A - Part B	Visual Visual		Light yellow Amber
Fineness	Hegman	µm	TBD
Density at 25°C - Part A - Part B	ASTM-D-792 ASTM-D-792	g/cm ³ g/cm ³	1,1 - 1,2 1,1 - 1,2
Brookfield Viscosity at 25°C - Part A - Part B	ASTM-D-2393 ASTM-D-2393	Pa.s Pa.s	10 - 15 13 - 18

Cure Schedule :

Full cure is obtained after :

Temperature (°C)	Gel Time	Cure Time
18 to 25	4 min	6 min

Properties Of Material After Application :

Property	Test Method	Unit	Value
Linear Cure Shrinkage	ASTM-D-2566	%	TBD
Hardness	ASTM-D-2240 at 25°C	Shore D	70 minimum
	After 1 h cure at RT		
	After 24 h cure at RT		
	After 4 h cure at 60°C	Shore D	80 minimum
Tensile Lap Shear Strength	ASTM-D-1002 at RT	MPa	13 minimum
Coefficient of Thermal Expansion	ASTM-D-696	$10^{-6} K^{-1}$	TBD
Glass Transition Temperature	ASTM-D-3418	°C	TBD
Thermal Conductivity	ASTM-D-2214	W/m.K	TBD
Dielectric Constant	ASTM-D-150		TBD
Volume Resistivity	ASTM-D-257	Ohm.cm	TBD
Moisture Absorption	ASTM-D-570 at 25°C		TBD
	After 24 h		
	After 1 week	%	TBD
Service Temperature	ASTM-D-794	°C	100

Storage And Handling :

Store in a tightly closed container at temperatures no higher than 25°C.

Health & Safety :

It is recommended to consult the Henkel product literature, including material safety datasheets, prior to using Henkel products.

Storage Temperature (°C)	Usable Shelf Life (months)
18 to 25	12

Attention Specification Writers :

The technical information contained herein is consistent with the properties of the material and should not be used in the preparation of specifications, as it is intended for reference only. For assistance in preparing specifications, please contact HITEK for details.

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