

LOCTITE ABLESTIK 50126FC

December 2016

PRODUCT DESCRIPTION

LOCTITE ABLESTIK 50126FC provides the following product characteristics:

Technology	Epoxy
Appearance - Part A	Light yellow
Appearance - Part B	Amber
Product Benefits	<ul style="list-style-type: none"> • Two component • Fast cure • Easy mix ratio
Mix Ratio, by weight - Part A: Part B	100 : 100
Cure	Room temperature cure
Application	Assembly
Service Temperature	100°C
Substrates	Metals and Many plastics

LOCTITE ABLESTIK 50126FC is a fast curing version of ECCOBOND 50126.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Viscosity, Brookfield @ 25 °C, mPa·s (cP)	12,500
Density @ 25°C, g/cm ³	1.15
Shelf Life @ 18 to 25°C, days	365
Flash Point - See SDS	

Part B Properties

Viscosity, Brookfield @ 25 °C, mPa·s (cP)	12,500
Density @ 25°C, g/cm ³	1.15
Shelf Life @ 18 to 25°C, days	365
Flash Point - See SDS	

Mixed Properties

Pot Life, minutes	4
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TYPICAL CURING PERFORMANCE

Gel Time

4 minutes @ 18 to 25°C

Cure Schedule

6 minutes @ 18 to 25°C

Since cure is extremely fast, resulting in high exotherm, using large quantities is not advisable.

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 @ 25°C:	
After 1 hour cure @ 25°C	70
After 2 hour cure @ 25°C	75
After 2 hour cure @ 60°C	80
Coefficient of Thermal Expansion, ppm/°C	50
Thermal Conductivity, W/(m-K)	0.2

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength @ 25°C:

N/mm ²	13
(psi)	(1,890)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Accurately weigh out the required amount of part A and part B as stated in the mix ratio
2. Power mixing is preferred to ensure a homogeneous product
3. When necessary, entrapped air can be removed by vacuum deairing
4. Heat up to 65°C to decrystallise product (maximum 24 hours, depending on packaging)

STORAGE:

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

Optimal Storage : $\leq 25^{\circ}\text{C}$

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.

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.

Conversions

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

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