

LOCTITE[®] ABLESTIK KS 4014

November 2020

PRODUCT DESCRIPTION

LOCTITE[®] ABLESTIK KS 4014 provides the following product characteristics:

Technology	Epoxy
Appearance - Part A	Silver paste
Appearance - Part B	Gray/black paste
Appearance (Mixed)	Silver gray paste
Components	Two components - requires mixing
Mix Ratio, by weight - Part A: Part B	100 : 32
Product Benefits	<ul style="list-style-type: none"> Fast cure at room temperature
Cure	Room temperature cure
Application	Electronic Adhesives & Solder, Component assembly

LOCTITE[®] ABLESTIK KS 4014 is a two-part conductive epoxy fairing compound.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties LOCTITE[®] ABLESTIK KA 4014

Filler Content %	67
Shelf Life @ 25°C (from date of shipment), days	180

Part B Properties LOCTITE[®] ABLESTIK KB 4014

Filler Content %	60
Shelf Life @ 25°C (from date of shipment), days	180

Mixed Properties LOCTITE[®] ABLESTIK KS 4014

Pot Life @ 25°C, 100 gram mass, minutes	45
Shelf Life @ 25°C, days	365

TYPICAL CURING PERFORMANCE

Cure Schedule

4 hours @ 25°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Filler Content, %	65.3
Hardness, , Shore D	74

Electrical Properties

Volume Resistivity, ohm-cm	0.003
Surface Resistivity, ohms/sq	1.0

Adhesion Properties

Tensile Shear Strength	N/mm ² 6.89 (psi) (1,000)
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GENERAL INFORMATION

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

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidizing materials unless otherwise specifically stated.

Directions for Use

- Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
- Some filler settling is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use. Power mixing is preferred to ensure homogeneous product.
- Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
- Blend components by hand, using a kneading motion, for 2 to 3 minutes. Scrape the bottom and sides of the mixing container frequently to produce a uniform mixture.
- If possible, power mix for an additional 2 to 3 minutes. Avoid high mixing speeds. This can entrap excessive amounts of air. It can also cause overheating of the mixture, resulting in reduced working life.
- If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
- Adhesive must be completely used within the products recommended work life.

Storage

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

Optimal Storage: 25°C. Storage below 25°C or above 25°C can adversely affect product properties.

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 Henkel 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb/F}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N} \cdot \text{m} \times 8.851 = \text{lb} \cdot \text{in}$

$\text{N} \cdot \text{m} \times 0.738 = \text{lb} \cdot \text{ft}$

$\text{N} \cdot \text{mm} \times 0.142 = \text{oz} \cdot \text{in}$

$\text{mPa} \cdot \text{s} = \text{cP}$

Disclaimer

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Reference 1