

**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK 71-2 provides the following product characteristics:

<b>Technology</b>	Polyamide
<b>Appearance</b>	Brown liquid
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"><li>• Electrically Insulating</li><li>• Continuous operating temperature of 250°C</li><li>• Low outgassing</li></ul>
<b>Application</b>	Non-conductive adhesive
<b>Typical Assembly Applications</b>	Chip coating, Alpha particle protection

LOCTITE ABLESTIK 71-2 adhesive is designed for high temperature applications. It features a unique polyimide resin that provides higher adhesion and bond strength than competitive polyimides. LOCTITE ABLESTIK 71-2 adhesive exhibits low outgassing after imidizing at 275 °C.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Shelf Life @ -40°C (from date of manufacture), days 365

**TYPICAL CURING PERFORMANCE****Cure Schedule**

30 minutes @ 150°C plus 30 minutes @ 275°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 PERFORMANCE OF CURED MATERIAL**

Die Shear Strength @ 25 °C:

Al to Al	N/mm <sup>2</sup> 17 (psi) (2,500)
Au to Au	N/mm <sup>2</sup> 17 (psi) (2,500)

**GENERAL INFORMATION**

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

**THAWING:**

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. Refer to the Syringe Thaw time chart for the thaw time recommendation.
4. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
5. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.

**DIRECTIONS FOR USE**

1. Apply adhesive as required.
2. Assemble bonds.
3. Cure at the recommended cure schedule.
4. The initial cure cycle will drive off the solvent, while the higher temperature cure cycle will imidize the resin.
5. In handling and applying LOCTITE ABLESTIK 71-2 adhesive, care must be exercised to prevent premature evaporation of the solvent. Should such evaporation occur, the adhesive will thicken. It can be stored to its original consistency at any time prior to cure by stirring in a small quantity of N-Methylpyrrolidone (NMP).
6. Placing an airtight enclosure over the stamping or screening equipment with an open container of NMP inside may significantly reduce the evaporation rate of the NMP from the adhesive during application.

**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: -40 °C. Storage below minus (-)40 °C or greater than minus (-)40 °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 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/mm<sup>2</sup> x 145 = psi  
MPa = N/mm<sup>2</sup>  
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

**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



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