

LOCTITE ABLESTIK G 757

April 2023

PRODUCT DESCRIPTION

LOCTITE ABLESTIK G 757 provides the following product characteristics:

| | |
|------------------------------|---|
| Technology | Epoxy |
| Appearance | Gray |
| Product Benefits | <ul style="list-style-type: none"> • One component • Thixotropic • Bonds to a wide variety of substrates • Excellent stress reduction and absorption properties • Flexible over temperature range of -40 to +150°C |
| Cure | Heat cure |
| Application | Assembly |
| Operating Temperature | -40 to +150 °C |
| Key Substrates | Glass, Steel, Copper, Aluminum and FRP |

LOCTITE ABLESTIK G 757 is specially designed to bond automobile headlamp lenses to reflectors.

TYPICAL PROPERTIES OF UNCURED MATERIAL

| | |
|-------------------------------|-----|
| Density, g/cm ³ | 1.2 |
| Sag Resistance, mils | 400 |
| Press Flow, seconds | 100 |
| Storage Life @ 2 to 8°C, days | 210 |
| Flash Point - See SDS | |

TYPICAL CURING PERFORMANCE Cure Schedule

45 minutes @ 140°C or
 20 minutes @ 160°C or
 10 minutes @ 180°C

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured in bond thicknesses <0.125 inches.

For optimum performance at temperatures above 2 to 4°C, a post cure of hours at °C is recommended.

Longer cure times will further improve properties.

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 :

| | |
|-----------------|----|
| Hardness: | |
| Shore D @ 25°C | 35 |
| Shore A @ 120°C | 35 |

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Peel Strength :

| | | |
|-----------------------------|-------------------|-------|
| Aluminum to Aluminum @ 25°C | N/mm ² | 1.75 |
| | (psi) | (250) |

Tensile Lap Shear Strength:

| | | |
|-----------------------------|-------------------|---------|
| Aluminum to Aluminum @ 25°C | N/mm ² | 10 |
| | (psi) | (1,490) |

GENERAL INFORMATION

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

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local Henkel representative for assistance and recommendations on the specifications of this product.

DIRECTIONS FOR USE

1. 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.
2. Apply adhesive to all surfaces to be bonded and join together.
3. In most applications only contact pressure is required.

STORAGE

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

Optimal Storage : 2 to 8 °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 Henkel Representative.

Conversions

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

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

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

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

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

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

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

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

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

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

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

Disclaimer

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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Reference 2