Technical Data Sheet

LOCTITE® ABLESTIK NCA 2350

April 2025

Product description

LOCTITE® ABLESTIK NCA 2350 provides the following product characteristics:

Technology	Epoxy
Appearance	Black liquid
Product benefits	• Fast cure at low temperatures • One component • Good adhesion
Cure	Heat cure
Application	Adhesive and sealant
Typical application	Camera module housing assembly

LOCTITE® ABLESTIK NCA 2350 is designed for use in heat sensitive devices.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield CP51, 25°C, mPa.s (cP)	
Speed 5 rpm	13,670
Thixotropic index (0.5/5 rpm)	3.7
Pot life @ 25°C, days	3
Shelf life, days	365
Flash point - see SDS	

TYPICAL CURING PERFORMANCE

Recommended cure condition

2 minutes @ 80°C in hot plate

30 minutes @ 80°C in conventional oven

Weight loss on cure

Weight loss on cure, %	0.21

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical properties

Hardness, Shore D		75
Coefficient of thermal expansion, ppm/°C		
Below Tg		66
Above Tg		180
Glass transition temperature, °C		
by TMA		28
Volumetric shrinkage, on cure, %		2.8
Elongation at break, %		110
Tension modulus		
@ 25°C	N/mm^2 (psi)	2,533 (367,380)
@ 85°C	N/mm^2 (psi)	30 (4,351)

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear strength

Lap shear strength	N/mm^2 (psi)	18 (2,610)

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

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 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. Some filler settling is common during shipping and storage.
3. Some separation of components 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.
4. Apply adhesive to all surfaces to be bonded and join together.
5. In most applications only contact pressure is required.
6. Usable shelf life may vary depending on method of application and storage conditions.

Storage

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

Optimal storage: Refer to package label for proper storage condition.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
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

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