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Technical Data Sheet

Product L-151

Produced by Loctite Corporation
Modified Product, May 2004



TAK PAK BONDING KIT

PRODUCT DESCRIPTION

The Tak Pak Bonding Kit is an adhesive/accelerator system that is fast, neat, and requires no mixing. The accelerator cures the Tak Pak Adhesive to a hard, clear plastic in seconds on a wide variety of substrates. The accelerator contains no salts to affect electrical devices.

TYPICAL APPLICATIONS

- securing jumper wires and coil forms
- Positioning components prior to wave soldering
- Mounting stand-offs, edge guides, board stiffeners and non-standard hardware
- Tamper proofing adjustable components
- Mounting heavy components to relieve strain on soldered connections
- Mounting LED's and photodiodes

PRODUCT BENEFITS

Easy to Use

- no clamping
- no measuring or mixing
- cures at room temperature

Fast, Reliable

- develops strong bonds in seconds, reaches ultimate strength in hours

Versatile

- works on a wide range of materials
- insulates and encapsulates

Easy to Apply

- a variety of dispensing tips can be fitted to the 20g bottle - a complete line of semi and fully automatic equipment is also available

PHYSICAL PROPERTIES

Liquid State

	Tak Pak Adhesive	Tak Pak Accelerator
Color	Clear	Clear
Viscosity	1100-1600	0.4
Shelf Life	1 Year Minimum	1 Year Minimum
On Part Life	-	1 Minutes
Flash Point	>80°C	-17°C
Specific Gravity	1.05	0.79
Drying time	-	<30 Sec

PHYSICAL PROPERTIES OF CURED MATERIAL

Full strength achieved after 12 hours at 22°C on most substrates.

Coefficient of thermal expansion, ASTM D696, 1/K:	100 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177w/m.°K	
Softening point, °C:	165
Recommended gap, mm:	0.05
Maximum gap, mm:	0.30
Cleaning solvent:	nitromethane, Acetone

Electrical properties:

Dielectric constant, ASTM D150-1 kHz:	2 to 3.5
Dissipation factor ASTM D150 -1 kHz:	<0.02
Volume resistivity, ASTM D257 -Ω.cm x 10 ¹⁶ :	0.2 to 1
Surface resistivity -Ω.cm x 10 ¹⁶ :	1 to 8
Dielectric strength, ASTM 149- kV/mm:	25
Bond Strength:	Up to break strength of 28 AWG wire
Continuous Service Temperature Range:	-53°C - 85°C
Barcol Hardness:	65
Thermal Conductivity:	6 x 10 ⁻⁴ calorie/cm-sec °K
Thermal Expansion:	100 x 10 ⁻⁶ cm/cm/°C (-30°C to 30 °C)
Military Specification:	MIL -A-46050C
Melting Point:	165°C

USE AND APPLICATION

Loctite Tak Pak Adhesive rapidly cures to a hard, clear plastic when used in conjunction with Tak Pak Accelerator.

Application Procedure:

- 1) Brush apply Tak Pak Accelerator to the part to be secured.
- 2) Allow Accelerator to dry (10-15 seconds).
- 3) Apply Adhesive within 2 minutes or re-apply Accelerator.

Optimal procedure:

- 1) Apply adhesive to the part to be secured
- 2) Apply a drop of accelerator on the adhesive

Note: To prevent tip clogging, the adhesive applicator **should not** be touched to accelerated surfaces.

Under no circumstances should the Tak Pak Adhesive and Accelerator be mixed. It will cause a rapid, heat-releasing chemical reaction.

PACKAGING

Tak Pak Kit, item number 151, contains 20gr of Tak Pak Adhesive, 52 ml brush top bottle of Tak Pak Accelerator.

Tak Pak Adhesive

20g
500g

Item Number

L 416-20g
L 416-500g

Tak Pak Accelerator

52ml
100ml
500ml

Item Number

L 7452-1.75OZ
L 7452-100M
L 7452-500M

STORAGE

Adhesive:

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

Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °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.

Accelerator:

This activator is classified as HIGHLY FLAMMABLE and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidising agents or combustible materials. The product is light sensitive and accordingly, translucent containers should be kept in a dark place when not in use. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties

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 Technical Service Center or Customer Service Representative.

WARNING

ADHESIVE IS AN EYE IRRITANT. BONDS SKIN IN SECONDS. Contains cyanoacrylate ester. Apply only to surface to be bonded. In case of skin contact, flush with water.

ACCELERATOR VAPOR AND LIQUID IS HARMFUL. Avoid prolonged or repeated contact with skin or breathing of vapors.

Use both products with adequate ventilation. Get medical attention for any eye or internal contact. KEEP BOTH PRODUCTS AWAY FROM CHILDREN.

NOT FOR PRODUCT SPECIFICATIONS THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT ROTAL INDUSTRIES & TRADING LTD FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.