

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 7 days @ 22 °C

Lap Shear Strength , ISO 4587:

Steel (grit blasted)	N/mm ² 20 to 25 (psi) (2,900 to 3,600)
Stainless steel (grit blasted)	N/mm ² 9 to 12 (psi) (1,300 to 1,740)
Zinc dichromate	N/mm ² 7 to 12 (psi) (1,000 to 1,700)
Aluminum (abraded)	N/mm ² 8 to 12 (psi) (1,200 to 1,700)
Aluminum (etched)	N/mm ² 12 to 16 (psi) (1,700 to 2,300)
Galvanized Steel (HD)	N/mm ² 9.4 (psi) (1,400)
Brass	N/mm ² 8 to 11 (psi) (1,200 to 1,600)
Glass-reinforced plastic (GRP)	N/mm ² 0.5 to 2 (psi) (70 to 290)
Phenolic	N/mm ² 2.5 to 4.5 (psi) (360 to 650)
ABS	N/mm ² 0.5 to 1 (psi) (70 to 150)
Hardwood (Mahogany)	N/mm ² 6 to 15 (psi) (870 to 2,200)
Softwood (Red Deal)	N/mm ² 8 to 10 (psi) (1,200 to 1,500)
Polycarbonate	N/mm ² 2.5 to 4 (psi) (360 to 580)

Tensile Strength , ISO 6922:

Mild steel pin (grit blasted) to Soda glass	N/mm ² 13 to 18 (psi) (1,900 to 2,600)
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180° Peel Strength, ISO 8510-2:

Steel (grit blasted)	N/mm 2 to 3 (lb/in) (11 to 17)
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TYPICAL ENVIRONMENTAL RESISTANCE

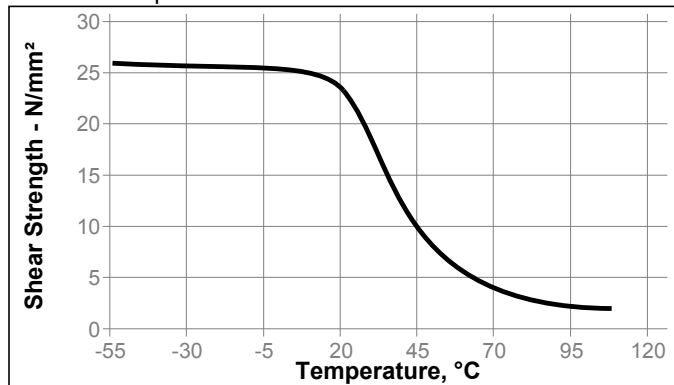
Cured for 7 days @ 22 °C

Lap Shear Strength , ISO 4587:

Steel (grit blasted)

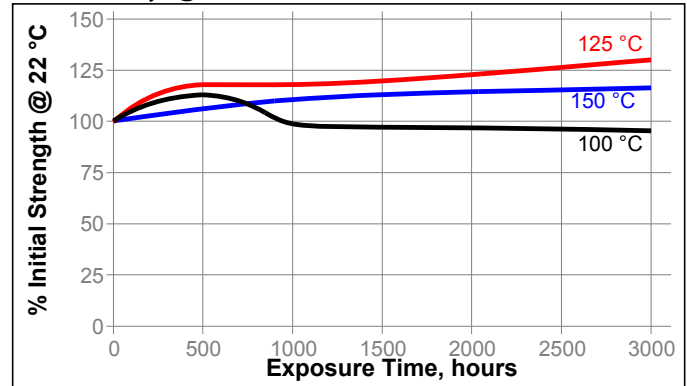
Hot Strength

Tested at temperature



Heat Aging

Cured for 5 days @ 22 °C, tested at 22 °C.



Chemical/Solvent Resistance

Immersed in conditions indicated and tested at 22 °C.

Environment	°C	% of initial strength		
		100 h	400 h	1000 h
Motor oil	22	100	100	50
Acetic Acid, 10%	22	70	70	60
Sulfuric Acid, 6.5%	22	100	100	100
Sodium Chloride, 7.5%	22	100	100	55
Water	60	100	90	90
Water	90	75	75	90
Humidity, 98% RH	40	100	100	100

Chemical/Solvent Resistance

Aged under conditions indicated and tested at 22 °C

Tensile Strength , ISO 6922:

Steel (grit blasted) to Soda glass

Environment	°C	% of initial strength	
		400 h	1000 h
Humidity, 98% RH	40	100	100

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

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

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive.

Directions for use

1. For best performance surfaces for bonding should be clean, dry and free of grease. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
2. To use, resin and hardener must be blended. Product can be applied directly from dual cartridges by dispensing through the mixer head supplied. Discard the first 3 to 5 cm of bead dispensed. Using bulk containers, mix thoroughly by weight or volume in the proportions specified in the Product Description Matrix. For hand

mixing, weigh or measure out the desired amount of resin and hardener and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.

3. It is recommended that this product is not mixed and cured in bulk quantities of greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimize the heat build-up.
4. Apply the adhesive as quickly as possible after mixing to one surface to be joined. For maximum bond strength apply adhesive evenly to both surfaces. Parts should be assembled immediately after mixed adhesive has been applied.
5. For working life please see section 'Typical Properties of Uncured Material'. Higher temperatures and larger quantities will shorten this working time.
6. Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
7. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
8. After use and before adhesive hardens, mixing and application equipment should be cleaned with hot soapy water.

Loctite Material Specification^{LMS}

LMS dated May 18, 2005. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

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

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 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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Reference 1.0