

PRODUCT DESCRIPTION

LOCTITE[®] 402[™] provides the following product characteristics:

| | |
|----------------------|---|
| Technology | Cyanoacrylate |
| Chemical Type | Ethyl / allyl Cyanoacrylate |
| Appearance (uncured) | Transparent, colorless to straw colored liquid |
| Components | One part - requires no mixing |
| Viscosity | Low |
| Cure | Humidity |
| Application | Bonding |
| Specific Benefits | <ul style="list-style-type: none"> • Fast fixture time • Good thermal performance • High humidity resistance |

LOCTITE[®] 402[™] is an instant adhesive that provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. LOCTITE[®] 402[™] shows a good heat aging and hot strength performance, on all substrates, especially on stainless steel. LOCTITE[®] 402[™] is also suited for bonding porous materials such as wood, paper, leather and fabric.

TYPICAL PROPERTIES OF UNCURED MATERIAL

| | |
|---|-----|
| Specific Gravity @ 23 °C | 1.1 |
| Viscosity, Cone & Plate, mPa·s (cP): Shear Rate: 3,000 s ⁻¹ | 110 |

TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 23°C / 50 % relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm².

| | |
|---------------------------|----|
| Fixture Time, seconds: | |
| Mild Steel (Grit Blasted) | 20 |
| Aluminum | 5 |
| Stainless steel | 45 |
| Zinc dichromate | 45 |
| Neoprene | 5 |
| Rubber, nitrile | 60 |
| ABS | 5 |
| PVC | 20 |
| Polycarbonate | 5 |
| Phenolic | 5 |
| Leather - calf skin | 45 |
| Wood (oak) | 45 |
| Wood (pine) | 30 |
| Chipboard | 20 |
| Fabric | 30 |

| | |
|-------|----|
| Paper | 10 |
| Balsa | 5 |

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Humidity

The rate of cure will depend on the ambient relative humidity. The best results are achieved when the relative humidity in the working environment is 50% at 23°C. Lower humidity leads to slower cure. Higher humidity accelerates it, but may impair the final strength of the bond.

Cure Speed vs. Activator

Where cure speed is unacceptably long due to large gaps, applying activator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

| | |
|---|--|
| Cured for 10 seconds @ 23°C | |
| Tensile Strength, ISO 6922, cord: Buna-N | N/mm ² 8.6 (psi) (1,200) |

| | |
|---|--------------------------------------|
| Cured for 72 hours @ 23°C | |
| Tensile Strength, ISO 6922, cord: Buna-N | N/mm ² 9 (psi) (1,300) |

| | |
|---|---------------------------------------|
| Tensile Strength, ISO 6922, pin: Mild Steel (Grit Blasted) | N/mm ² 33 (psi) (4,800) |
|---|---------------------------------------|

| | |
|--|---------------------------------------|
| Lap Shear Strength, ISO 4587: Mild Steel (Grit Blasted) | N/mm ² 22 (psi) (3,200) |
|--|---------------------------------------|

| | |
|-------------------|---------------------------------------|
| Aluminum (etched) | N/mm ² 20 (psi) (2,900) |
|-------------------|---------------------------------------|

| | |
|-----------------|--------------------------------------|
| Zinc Dichromate | N/mm ² 4.5 (psi) (650) |
|-----------------|--------------------------------------|

| | |
|-----|--------------------------------------|
| ABS | N/mm ² 8 (psi) (1,200) |
|-----|--------------------------------------|

| | |
|-----|------------------------------------|
| PVC | N/mm ² 6 (psi) (870) |
|-----|------------------------------------|

| | |
|----------|---------------------------------------|
| Phenolic | N/mm ² 10 (psi) (1,500) |
|----------|---------------------------------------|

| | |
|---------------|--|
| Polycarbonate | N/mm ² 7.6 (psi) (1,100) |
|---------------|--|

| | |
|---------|--------------------------------------|
| Nitrile | N/mm ² 1.7 (psi) (250) |
|---------|--------------------------------------|

| | |
|----------|--------------------------------------|
| Neoprene | N/mm ² 1.3 (psi) (190) |
|----------|--------------------------------------|

| | |
|-----------------|---|
| Stainless Steel | N/mm ² 17.5 (psi) (2,500) |
|-----------------|---|



Block Shear Strength, ISO 13445:

ABS

N/mm² 20
(psi) (2,900)

Polycarbonate

N/mm² 13.5
(psi) (2,000)

Phenolic

N/mm² 12
(psi) (1,800)

TYPICAL ENVIRONMENTAL RESISTANCE

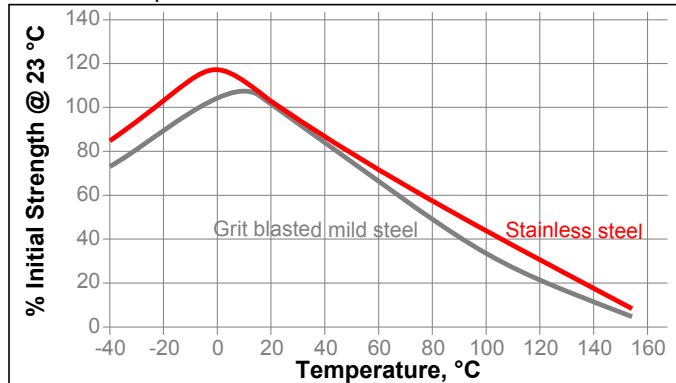
Cured for 1 week @ 23°C / 50% RH

Lap Shear Strength ISO 4587:

Mild steel (grit blasted)

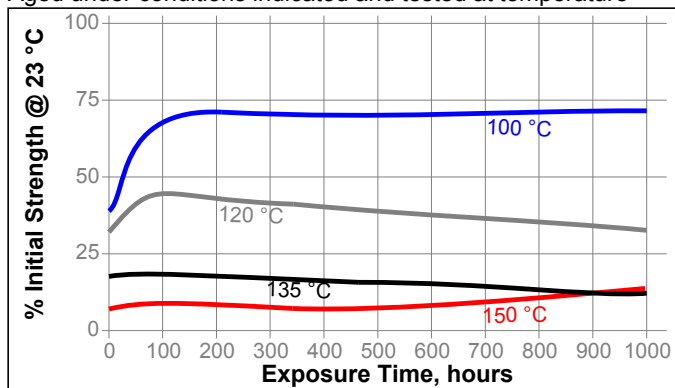
Hot Strength

Tested at temperature

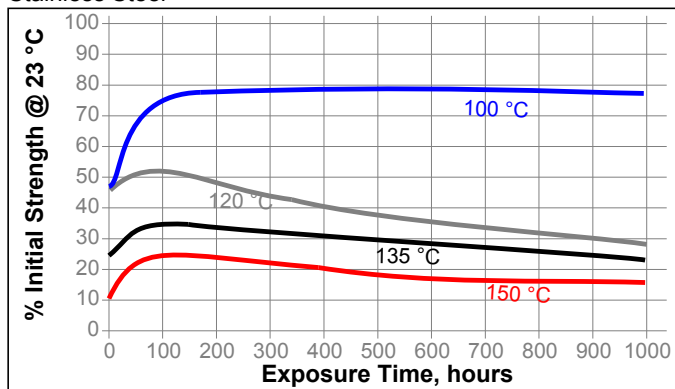


Heat Aging/Hot Strength

Aged under conditions indicated and tested at temperature

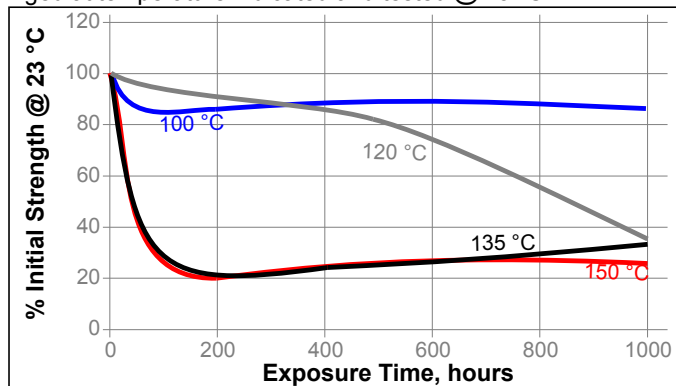


Stainless Steel

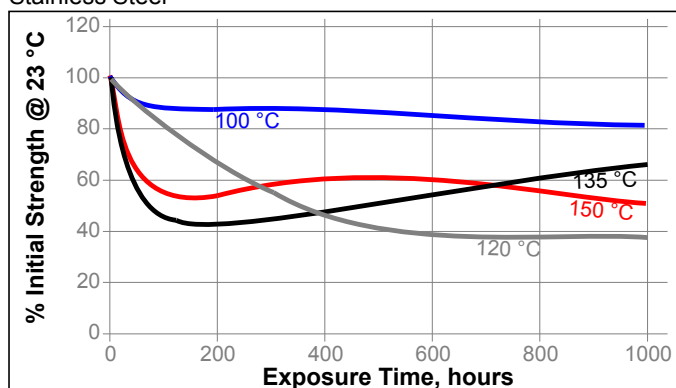


Heat Aging

Aged at temperature indicated and tested @ 23 °C



Stainless Steel



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 23 °C

| Environment | °C | % of initial strength | | |
|--------------------|----|-----------------------|-------|--------|
| | | 100 h | 500 h | 1000 h |
| Motor oil | 40 | 130 | 140 | 130 |
| Unleaded gasoline | 23 | 110 | 110 | 110 |
| Ethanol | 23 | 115 | 115 | 120 |
| Isopropanol | 23 | 110 | 120 | 130 |
| Water | 23 | 80 | 70 | 65 |
| Water/glycol 50/50 | 23 | 95 | 80 | 80 |
| 98% RH | 40 | 70 | 70 | 70 |
| 95% RH | 65 | 70 | 45 | 45 |

Polycarbonate

| Environment | °C | % of initial strength | | |
|-------------|----|-----------------------|-------|--------|
| | | 100 h | 500 h | 1000 h |
| Air | 23 | 90 | 115 | 120 |
| 98% RH | 40 | 135 | 115 | 120 |

Stainless Steel

| Environment | °C | % of initial strength | | |
|--------------------|----|-----------------------|-------|--------|
| | | 100 h | 500 h | 1000 h |
| Motor oil | 40 | 115 | 120 | 130 |
| Unleaded gasoline | 23 | 110 | 110 | 110 |
| Ethanol | 23 | 100 | 110 | 95 |
| Isopropanol | 23 | 115 | 110 | 115 |
| Water | 23 | 75 | 50 | 30 |
| Water/glycol 50/50 | 23 | 90 | 60 | 40 |
| 98% RH | 40 | 50 | 40 | 35 |
| 95% RH | 65 | 40 | 25 | 20 |



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 Safety Data Sheet (SDS).

Directions for use

1. Bond areas should be clean and free from grease. Clean all surfaces with a LOCTITE® cleaning solvent and allow to dry.
2. To improve bonding on low energy plastic surfaces, LOCTITE® Primer may be applied to the bond area. Avoid applying excess Primer. Allow the Primer to dry.
3. LOCTITE® Activator may be used if necessary. Apply it to one bond surface (do not apply activator to the primed surface where Primer is also used). Allow the Activator to dry.
4. Apply adhesive to one of the bond surfaces (do not apply the adhesive to the activated surface). Do not use items like tissue or a brush to spread the adhesive. Assemble the parts within a few seconds. The parts should be accurately located, as the short fixture time leaves little opportunity for adjustment.
5. LOCTITE® Activator can be used to cure fillets of product outside the bond area. Spray or drop the activator on the excess product.
6. Bonds should be held fixed or clamped until adhesive has fixtured.
7. Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

Storage

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 Henkel representative.

Product Specification

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate

Please contact your local Henkel representative for related approval or certificate of this product.

Data Ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50 ±5% RH

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

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.

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