



LOCTITE UK 1367 B60 / LOCTITE UK 5452

November 2017

PRODUCT DESCRIPTION

LOCTITE UK 1367 B60 / LOCTITE UK 5452 provides the following product characteristics:

Technology	Polyurethane
Product Type	Structural Adhesive
Cure	Polyaddition
Condition	Solvent-free
Components	Two-components
Component A	Resin
Component B	Hardener
Application	General assembly
Color (Comp. A)	Beige
Color (Comp. B)	Green
Mixing Ratio, by weight Comp. A : Comp. B	100 : 21.6
Mixing Ratio, by volume Comp. A : Comp. B	4 : 1

LOCTITE UK 1367 B60 / LOCTITE UK 5452 is a solvent-free two-component adhesive, based on polyurethane. The resin part (component A) contains organic compounds with hydroxyl groups, the hardener (component B) is based on isocyanates.

By mixing both components a hard elastic adhesive is formed through chemical reaction. After curing the product exhibits no measurable change in volume.

The adhesives are not abrasive, since high-quality raw materials are used.

In addition, the product group is outstanding for its low exothermic reaction while curing.

As natural raw materials (from different cultivation areas) are used a variation in color between different batches is possible.

Application Areas:

LOCTITE UK 1367 B60 / LOCTITE UK 5452 is used for the adhesion of pretreated metals, plastics and rigid foams.

TECHNICAL DATA

Component A

LOCTITE UK 1367 B60:

Consistency (20°C):	pasty
Density (20°C), g/cm ³	1.39 to 1.47

Component B

LOCTITE UK 5452:

Consistency (20°C):	pasty
Density (20°C), g/cm ³	1.21 to 1.26

Mixture (Component A + B):

Consistency (20°C):	pasty
Viscosity, Brookfield - RVT, 20°C, mPas * Henkel method 11	350,000 to 550,000
Pot life (280g, 20°C), min* Henkel method 21	55 to 85
Tensile shear strength at 20 °C, MPa* EN 1465 / Henkel method 40	>10

All technical data based on Henkel test method.
Data with * are specified.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Pretreatment:

The substrate should be clean, dry, free of dust, oil, grease and other contaminants. The usage of suitable primers on metal surfaces can improve the adhesion and/or the long-term bond stability. The surface of plastic materials should be cleaned, so as to remove any kind of release agents present on the substrate surface. An improvement of the adhesion can be achieved by grinding or sandblasting the surface.

Application:

Adhesive components are mixed by using a Static mixer (10mm diameter with 24 mixing elements) or by two-component mixing equipment mixed in the specified mixing ratio. The inclusion of air should be avoided. After mixing no streaks should be visible (Initial 10cm should be discarded). The adhesive is only to be used within a limited time (pot life). After this time the mixture gels up and is not suitable for use. Therefore only the amount that can be applied within the time of pot life should be mixed. The pot life depends on the quantity and temperature of the mixed batch. With larger quantities and an increase in temperature, the pot



life decreases. Lower temperatures extend the pot life. Adhesive components should not come into contact with moisture during storage or application. Contact with moisture generates foaming of the adhesive and weakens the bondline. Therefore all packaging should be sealed properly and protected against humidity during storage.

Cleaning:

Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with LOCTITE SF 8040; cured adhesive can only be removed mechanically.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification

Transport information

Regulatory information

Storage:

Component A

Recommended storage temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	12 months

Component B

Recommended storage temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	12 months

ADDITIONAL INFORMATION

Disclaimer

Note:

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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