



TECHNICAL DATA SHEET



Henkel Corporation
 Professional and Consumer Adhesives
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Item #	Package	Size
1363118	Carded Syringe	0.85 fl. oz.

DESCRIPTION:

Loctite Plastics Bonder is an acrylic formula that is specially formulated to bond and repair plastic surfaces. The convenient double syringe dispenses equal amounts of each component every time. When mixed in equal volumes, the components react to produce a tough, rigid, high strength bond in 20 to 25 minutes. Loctite Plastics Bonder does not shrink and is resistant to water, most common solvents and shop fluids. It has high impact resistance and can be sanded and drilled.

RECOMMENDED FOR:

Loctite Plastics Bonder can be used for bonding substrates such as: PVC, polycarbonate, acrylic, ABS, FRP, nylon, Mylar®, Delrin®, phenolic, aluminum, stainless steel and many other plastics.

LIMITATIONS:

- Not recommended for polyethylene, polypropylene, non-stick coatings, nylon products or flexible materials.
- Do not use in applications requiring short term heat exposure greater than 180°F (82°C).
- Not suitable for continuously wet areas or water immersion
- Not suitable for potable water systems

FEATURES & BENEFITS:

Feature	Benefits
Machinable.....	Will not crack when drilled
Water and solvent resistant.....	Highly durable
Fuses Plastic.....	Bonds most plastics
20 to 25 minute set time.....	Quick completion of projects
Convenient syringe.....	Dispenses equal amounts of each component

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Typical Uncured Physical Properties		Typical Application Properties	
Color:	Part A: Cream colored opaque paste Part B: Pale Amber paste	Application Temperature:	39°F (4°C) to 70°F (21°C)
Base:	Methyl Methacrylate	Odor:	Sharp
Specific Gravity:	Part A: 1.04 Part B: 1.08	Open Time: (1g:1g)	15 to 18 minutes* (at 70°F / 21°C)
Flashpoint:	Part A: 58°F (14°C) Part B: 58°F (14°C)	Set Time:	20 to 25 minutes* (at 70°F / 21°C)
VOC Content:	0.3% by weight CARB / 2.86 g/L SCAQMD	Full Cure Time:	24 hours*
Shelf Life:	18 months (from date of manufacture, unopened)	*Time is based on temperature, humidity, and thickness of adhesive applied	

Lot Code Explanation:	LB7FAC56 (Example)	A – January	G – July
	7 = Last digit in the year of manufacture	B – February	H – August
	7 = 2017	C – March	J – September (there is no I)
	F = Month produced (see chart on right)	D – April	K – October
	F = June	E – May	L – November
June 2017 is the date of manufacture	F – June	M – December	



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Typical Cured Performance Properties			
Color:	Opaque Amber	Cured form:	Non-flammable, hard, solid.
Paintable:	Yes	Water Resistant:	Yes
Hardness:	85 (+/-1), Shore D	Sandable:	Yes
Service Temperature:	-40°F(-40°C) to 180°F (82°C)		
Test Methods	Cure Time	Data	Substrates
Tensile Shear Strength:	6-hour cure	2903 psi (20.5 N/mm ²)	Cold Rolled Steel, Sandblasted
	24-hour cure	3477 psi (24.0 N/mm ²)	Aluminum Sandblasted
Compressive Shear Strength:	24-hour cure	1713 psi (11.8 N/mm ²)	Polycarbonate, unsanded
		1698 psi (11.7 N/mm ²)	Polycarbonate, sanded
		1224 psi (8.4 N/mm ²)	Acrylic, unsanded
		1875 psi (12.9 N/mm ²)	Acrylic, sanded
		1045 psi (7.2 N/mm ²)	PVC – Hard, unsanded
		2219 psi (15.3 N/mm ²)	PVC – Hard, sanded
		669 psi (4.6 N/mm ²)	Delrin
		1526 psi (10.5 N/mm ²)	Nylon
		2765 psi (19.1 N/mm ²)	Mylar
		1031 psi (7.1 N/mm ²)	ABS, unsanded
1463 psi (10.1 N/mm ²)	ABS, sanded		
2179 psi (15 N/mm ²)	Phenolic, sanded		
1576 psi (10.9 N/mm ²)	Phenolic, unsanded		
Side Impact Resistance:	1" x 1", 7-day cure	35 to 40 kJ/m ²	Aluminum
Solvent and Chemical Resistance:	Resistant to water, salt water, unleaded gasoline, diesel fuel, and motor oil		

DIRECTIONS:

Tools Typically Required

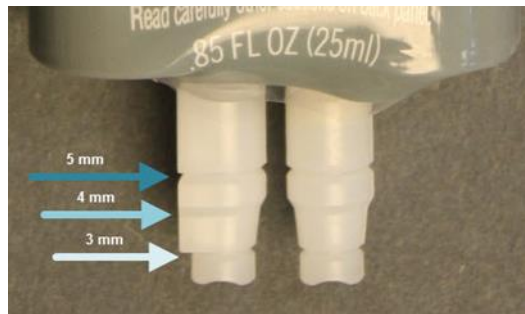
Utility knife, mixing tool/applicator (e.g. small flat plastic or wooden stick), disposable surface (e.g. foil).

Safety Precautions:

Apply and cure in a well-ventilated area. Wear gloves and wash hands after use.

Preparation:

Surfaces must be clean, dry and free from oil, wax, paint, rust, etc. Roughen smooth surfaces for better adhesion by sandblasting or sanding with an emery cloth. Wash surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Remove the plug from between the piston. Cut off the end tips of the syringe at one of the three cut-off points as illustrated below. For easier extrusion, cut at the 4 mm or 5mm opening. For more precise application, cut at 3 mm opening.



Turn syringe dispensing end up and pull plunger back slightly allowing air bubbles to rise to top. Take care to not exert excessive pressure or plunger may pull out of syringes. Press the plunger to expel air. Depress the double piston to dispense equal parts of the two materials on a disposable surface. Mix resin and hardener thoroughly (about 1 minute). Wipe syringe tips clean, retract piston slightly and close with the plug. Ensure that the plug is always placed in the same orientation on the tips.



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DIRECTIONS:

Application: Apply a small amount of mixed adhesive to both surfaces, join and press together. Support until bond sets in approximately 20 to 25 minutes at room temperature. For best results, clamp or secure as required for 20 -30 minutes or until bond sets. Usable strength in 12 hours. Full cure and strength in 24 hours. Moderate heat will speed hardening while cooler temperatures will require a longer set time.

Clean-up: Remove any excess uncured adhesive immediately using mineral spirits, isopropyl alcohol or denatured alcohol. Cured adhesive may be cut away with caution using a sharp blade. Note: Solvents are flammable and not compatible with all surfaces. Follow manufacturer's instructions and test on small area before applying.

STORAGE AND DISPOSAL

Not damaged by freezing. If frozen, warm to room temperature until the resin and hardener become liquid enough to mix. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

WARNING: Flammable. May cause allergic skin reaction. Irritant

DANGER: Contains methyl methacrylate. Flammable liquid and vapor. Causes eye, skin, and respiratory tract irritation. May cause allergic skin reaction. May be harmful if swallowed. Keep away from heat, sparks, and flame. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling. Keep container closed when not in use. Use only with adequate ventilation. **FIRST AID:** If in eyes or on skin, rinse with water for at least 15 minutes. Obtain medical attention if symptoms develop or persist. If inhaled, move to fresh air. If swallowed, do not induce vomiting. Get medical attention. **KEEP OUT OF REACH OF CHILDREN.**



WARNING: Cancer and Reproductive Harm – www.P65Warnings.ca.gov.

Refer to the Safety Data Sheet (SDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.



Trusted Performance. Proven Results.

For over 50 years, Loctite Brand adhesives and sealants have taken on the toughest jobs. Used in race cars, airplanes, and even in the space-shuttle, Loctite provides solutions for the most demanding industrial, professional and consumer applications. Loctite gives you not the specialization, power and performance to not only get your job done, but to get it done right.

For Technical Assistance call : 1-800-624-7767 – Mon-Fri - 9:00a – 4:00p ET
www.loctiteproducts.com



Loctite Brand is part of the Henkel family of brands. Founded in 1876, Henkel is a global leader in the consumer and industrial businesses. Henkel operates worldwide with leading brands and technologies in three business areas: Laundry & Home Care, Beauty Care and Adhesive Technologies.

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