

**LOCTITE**<sup>®</sup>



# LOCTITE<sup>®</sup> HHD 3544F

**BIOBASED\* ELECTRONICS  
ASSEMBLY ADHESIVE**

**SUSTAINABLE, LOW EMISSION PRODUCT**

\* Biobased content measurement: Henkel defines biobased products as containing > 50% of the organic content derived from bio/renewable sources



Industry's first biobased polyurethane reactive (PUR) hotmelt structural adhesive that offers a high-performance, sustainable alternative for consumer electronics assembly.



› 60% biobased carbon content directly derived from biomass proven by 14C-analysis



› CO<sub>2</sub> footprint reduction through low emission raw material

**Henkel**

Henkel Adhesive Technologies

Product Characteristics	LOCTITE® HHD 3544F	LOCTITE® HHD 3546F	LOCTITE® HHD 3542
Biobased Raw Material Content	60%	20%	0%
Feature	<ul style="list-style-type: none"> <li>• Good basic bonding performance</li> <li>• Long open time</li> <li>• Dispensing stability and jetting performance</li> </ul>	<ul style="list-style-type: none"> <li>• Good basic bonding performance</li> <li>• Fast fixture and high green strength within 10 minutes</li> </ul>	<ul style="list-style-type: none"> <li>• Good initial strength</li> <li>• Relatively long open time</li> <li>• Excellent elongation and structural durability</li> </ul>
Technology	Polyurethane hot melt	Polyurethane hot melt	Polyurethane hot melt
Appearance	Beige solid	Beige solid	Light yellow to amber solid
Cure	Moisture	Moisture	Solidification and moisture
Open Time at 25°C	4 min. (1.75 mm bead)	2 min. (1.75 mm bead)	< 4 min. (1 mm bead)
Application Temperature, °C	90 – 120	90 – 120	90 – 110
Tensile Modulus, MPa	190	125	115
Tensile Strength, MPa	11	9.24	14.36
Elongation at Break, %	1,070	1,143	860
Cross Tensile Strength, 24 hr., PC/SUS, MPa	> 3	> 3	> 3



**Features and Benefits:**

- › Complete reformulation optimizing the balance between excellent performance and high renewable carbon content
- › Possess desirable mechanical and chemical properties
- › Align with high-volume production objectives, enabling deposition of narrow bond lines via jetting or needle dispensing
- › Integrated fluorescence for in-line automatic optical inspection (AOI)
- › Easy processing
- › Excellent bonding to plastics, metal and glass
- › Long open time and work life while dispensing or jetting

**Want to find out more?**

Contact our technology specialists to learn about our portfolio of sustainable PUR hotmelt structural adhesives.

[henkel-adhesives.com/electronics](https://henkel-adhesives.com/electronics)



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Scan the QR code above to access the technical product information.

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