LOCTITE® 455™

(TDS for new formulation of Loctite® 455™) May 2012

PRODUCT DESCRIPTION

LOCTITE® 455™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Alkoxyethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to light yellow, cloudy gel[LMS]
Components	One part - requires no mixing
Viscosity	High
Cure	Humidity
Application	Bonding
Key Substrates	Metals , Plastics and Elastomers

This Technical Data Sheet is valid for LOCTITE® 455™ manufactured from the dates outlined in the "Manufacturing Date Reference" section.

LOCTITE® 455™ is a general purpose cyanoacrylate adhesive gel with low odor and low blooming properties and is particularly suitable for applications where vapor control is difficult. The gel consistency prevents adhesive flow even on vertical surfaces.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Flash Point - See MSDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle TC, speed 20 rpm, , Helipath	10,000 to 26,000[LMS]

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 22 °C / 50 % relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm² .

Fixture Time, seconds:	
Steel	75 to 120
Aluminum	20 to 30
Zinc dichromate	45 to 90
Neoprene	75 to 90
Rubber, nitrile	1 to 10
ABS	5 to 10
PVC	10 to 30
Polycarbonate	150 to 180
Phenolic	5 to 10
Wood (pine)	45 to 60
Leather	5 to 20
Paper	<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 40% to 60% at 22°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 @ 22 °C		
Tensile Strength, ISO 6922:		
Buna-N	N/mm²	13.3
	(psi)	(1,930)
Cured for 24 hours @ 22 °C		
Lap Shear Strength, ISO 4587:		
Steel (grit blasted)	N/mm²	≥9.7[LMS]
	(psi)	(≥1,405)
Aluminum (etched)	N/mm²	16.2
	(psi)	(2,350)
Zinc dichromate	N/mm²	2.2
	(psi)	(320)
ABS	* N/mm²	4.0
	* (psi)	(580)
PVC	* N/mm²	6
	* (psi)	(880)
Polycarbonate	N/mm²	3.7
	(psi)	(530)
Phenolic	* N/mm²	3.9
	* (psi)	(560)
Neoprene	* N/mm²	0.7
	* (psi)	(103)
Nitrile	N/mm²	0.2
	(psi)	(30)

* substrate failure

Block Shear Strength, ISO 13445:

Polycarbonate	N/mm²	4.5
	(psi)	(650)
PVC	N/mm²	2.4
	(psi)	(350)

Tensile Strength, ISO 6922:

Steel pin to steel pin	N/mm²	31.5
	(psi)	(4,560)

TYPICAL ENVIRONMENTAL RESISTANCE

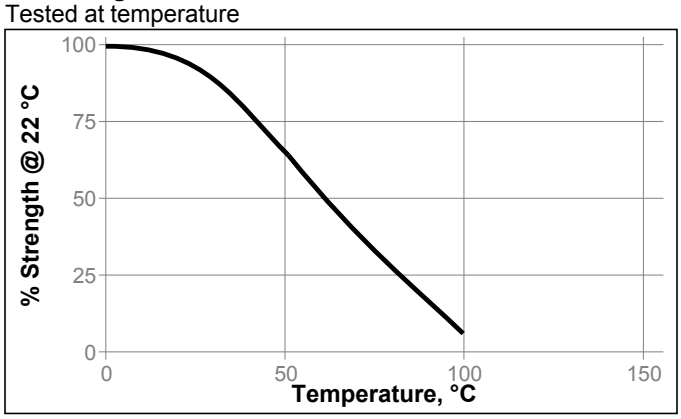
Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)

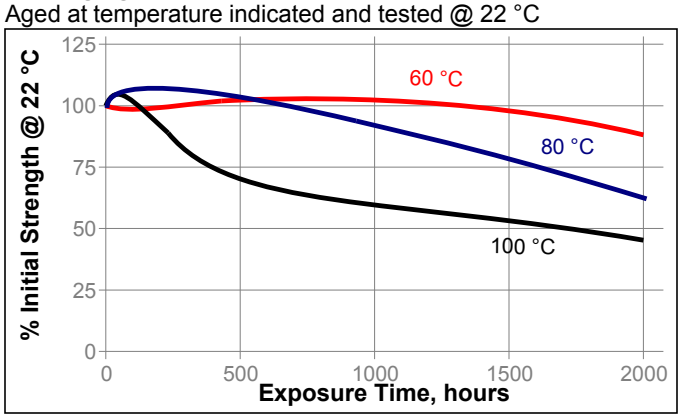
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

		% of initial strength		
Environment	**°C**	**100 h**	**500 h**	**1000 h**
Motor oil	40	115	70	120
Gasoline	22	95	90	75
Ethanol	22	95	100	85
Isopropanol	22	105	105	105
Water	22	90	35	40
Heat/humidity 95% RH	40	60	40	70
Water/glycol	25	100	100	90

Lap Shear Strength, ISO 4587:

Polycarbonate

		% of initial strength		
Environment	**°C**	**100 h**	**500 h**	**1000 h**
Air	25	110	110	80
Heat/humidity 95% RH	40	90	85	75

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).

Directions for use:

1. For best performance bond surfaces should be clean and free from grease.
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).

Loctite Material Specification[LMS]
LMS dated December 22, 2011. 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: 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 Technical Service Center or Customer Service Representative.

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

Manufacturing Date Reference

This Technical Data Sheet is valid for LOCTITE® 455™ manufactured from the dates below:

Made in:	**First manufacturing date**:
EU	Pending
China	April 2012
India	Pending
U.S.A.	March 2012

The manufacturing date can be determined from the batch code on the pack. For assistance please contact your local Technical Service Center or Customer Service Representative.

Note
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Reference 1.4