

Description

LOCTITE® EA 9462 is a toughened, two component epoxy adhesive formulated for a good balance of shear and peel properties in an easy to use, smooth paste. Its medium viscosity, 1:1 ratio and non-sag features make it easy to apply.

Recommend Substrates: metals, plastics and wood.

Features

Excellent Strength
 Impact Resistant
 Non-Sag
 Room Temperature or Heat Cure
 1:1 Mix Ratio
 Neutral Color

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 100 grams mins	--	--	55
Color	White	Dark Amber	Beige
Viscosity, cP	70,000 to 95,000	40,000 to 65,000	60,000 to 80,000
Specific Gravity	1.25	1.10	1.17
Mix Ratio			
By weight	100	85	--
By volume	1	1	--

Shear Strength, psi, ASTM D 1002 Cure Schedule 3 Days @ 77°F		
	Test Temp °F	Typical Value
Etched Aluminum	77	3500
	180	600
	250	150
CR Steel, MEK wiped	77	3500
PVC	77	225
Acrylic, ABS, SMC	77	400

Peel Test

Floating roller peel strength on etched aluminum tested per ASTM D3167

Cure Schedule	Test Temp °F	Typical Value pli
3 Days @ 77°F	77	22

T-peel strength on etched aluminum tested per ASTM D1876.

Cure Schedule	Test Temp °F	Typical Value pli
3 Days @ 77°F	77	10

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).

Handling

Mixing: This product requires mixing two components together just prior to the application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be at room temperature.

Application

Mixing – Bulk: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly until the color and consistency are uniform. Ratios given above can be used for measuring larger amounts. Mixing the adhesive just prior to use is recommended. Heat build-up during or after mixing is normal. Do not mix quantities greater than two pounds as dangerous heat build-up can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat build-up.

Mixing – Cartridges: Place cartridge in proper dispenser. To begin using a new cartridge, remove cartridge cap and dispense a small amount of adhesive, making sure Part A and Part B are extruding. Attach nozzle and dispense approximately 1-2" before applying onto the part being bonded. Partially used cartridges can be stored with mixing nozzle attached. To reuse, remove and discard the old nozzle, attach new nozzle and begin dispensing.

Application: Bonding surfaces should be clean and dry. Once the adhesive is applied, the bonded parts should be held in contact until the part has developed handling strength. This will occur in 4-8 hours at 77 °F after which the pressure used during cure may be removed. Since full bond has not yet been attained, load application should be small at this time. It is not necessary to clamp the parts unless movement during curing is likely.

Cure: LOCTITE® EA 9462 may be cured for 3-5 days at 77 °F to achieve normal performance. Accelerated cures up to 200 °F (for small masses only) may be used as an alternative. For example 1 hour at 180 °F will give complete cure.

Clean up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

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