



# LOCTITE® 498

June 2004

## PRODUCT DESCRIPTION

LOCTITE® 498 provides the following product characteristics:

<b>Technology</b>	Cyanoacrylate
<b>Chemical Type</b>	Ethyl cyanoacrylate
<b>Appearance (uncured)</b>	Transparent, colorless to pale yellow liquid <sup>LMS</sup>
<b>Components</b>	One part - requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Humidity
<b>Application</b>	Bonding
<b>Key Substrates</b>	Rubbers, Plastics and Metals

LOCTITE® 498 is a general purpose adhesive suitable for applications where heat resistance is required. LOCTITE® 498 is formulated to resist thermal cycling and also exhibits superior resistance to humidity.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.10  
 Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):  
 Spindle 2, speed 30 rpm 400 to 600<sup>LMS</sup>  
 Flash Point - See MSDS

## 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/mm<sup>2</sup> .

Fixture Time, ISO 4587, seconds:	
Steel (degreased)	20 to 30
Aluminum	2 to 10
ABS	5 to 10
Phenolic	10 to 20

### 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. 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 PROPERTIES OF CURED MATERIAL

After 24 hours @ 22 °C

### Physical Properties:

Coefficient of Thermal Expansion, ASTM D 696, K<sup>-1</sup> 80×10<sup>-6</sup>  
 Coefficient of Thermal Conductivity, ASTM C 177, W/(m·K) 0.10  
 Glass Transition Temperature, ASTM E 228, °C 120

### Electrical Properties:

Dielectric Constant / Dissipation Factor, ASTM D 150:  
 0.05 kHz 2.30 / <0.02  
 1 kHz 2.30 / <0.02  
 1,000 kHz 2.30 / <0.02  
 Volume Resistivity, ASTM D 257, Ω·cm 10×10<sup>15</sup>  
 Dielectric Breakdown Strength, ASTM D 149, kV/mm 25

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:		
Steel (grit blasted)	N/mm <sup>2</sup> (psi)	19 (2,755)
Polycarbonate	N/mm <sup>2</sup> (psi)	10 (1,450)
Phenolic	N/mm <sup>2</sup> (psi)	10 (1,450)

Cured for 24 hours @ 22 °C, followed by 24 hours @ 121 °C, tested @ 121 °C

Lap Shear Strength, ISO 4587:		
Steel (grit blasted)	N/mm <sup>2</sup> (psi)	≥6.90 <sup>LMS</sup> (≥1,000)

Cured for 2 minutes @ 22 °C

Lap Shear Strength, ISO 4587:		
Steel (grit blasted)	N/mm <sup>2</sup> (psi)	≥4.80 <sup>LMS</sup> (≥695)

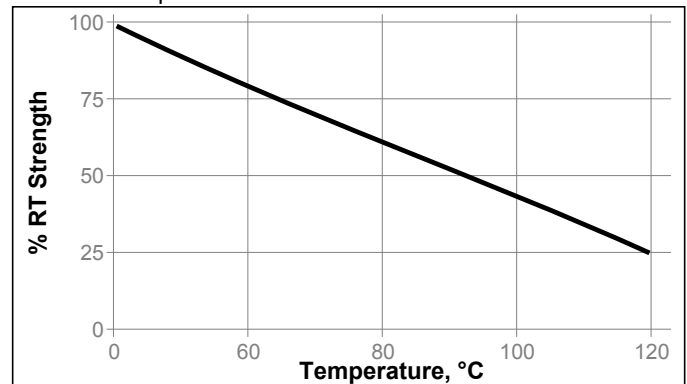
## TYPICAL ENVIRONMENTAL RESISTANCE

After 1 week @ 22 °C

Lap Shear Strength, ISO 4587:	
Mild steel (grit blasted)	

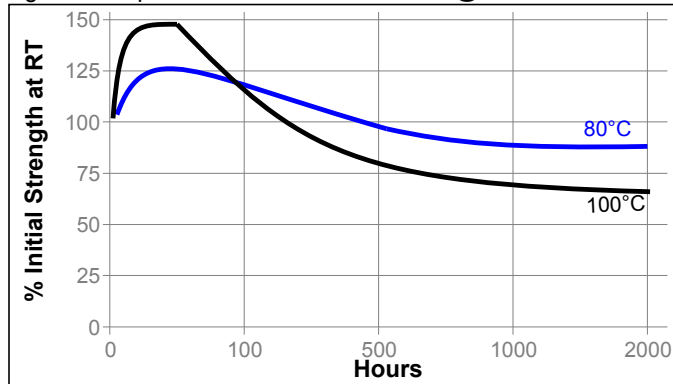
### Hot Strength

Tested at temperature



## Heat Aging

Aged at temperature indicated and tested @ 22 °C



### 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. This product performs best in thin bond gaps (0.05 mm).
3. Excess adhesive can be dissolved with Loctite cleanup solvents, nitromethane or acetone.

### Loctite Material Specification<sup>LMS</sup>

LMS dated November 19, 2002. 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 Loctite 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

### Note

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### Trademark usage

LOCTITE is a trademark of Henkel Corporation

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