



LOCTITE® 408™

June 2007

PRODUCT DESCRIPTION

LOCTITE® 408™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Alkoxyethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to straw colored liquid ^{LMS}
Components	One part - requires no mixing
Viscosity	Very low
Cure	Humidity
Application	Bonding
Key Substrates	Metals, Plastics and Elastomers

LOCTITE® 408™ has low odor and low blooming properties and is particularly suitable for applications where vapor control is difficult. The product provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. LOCTITE® 408™ is particularly suited for bonding porous or absorbent materials such as wood, paper, leather and fabric.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Flash Point - See MSDS	
Viscosity, Cone & Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 3,000 s ⁻¹	4 to 10 ^{LMS}
Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):	
Spindle 1, speed 60 rpm	4 to 10

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	30 to 120
Aluminum	<3
Zinc dichromate	10 to 20
Neoprene	<5
Rubber, nitrile	<5
ABS	5 to 10
PVC	15 to 30
Polycarbonate	10 to 15
Phenolic	5 to 15
Wood (pine)	10 to 20
Leather	5 to 10

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 PROPERTIES OF CURED MATERIAL

Cured for 1 week @ 22 °C

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹	476×10 ⁻⁶
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.26
Glass Transition Temperature, ISO 11359-2, °C	172

Electrical Properties:

Volume Resistivity, IEC 60093, Ω·cm	130×10 ¹⁵
Surface Resistivity, IEC 60093, Ω	11.9×10 ¹⁵
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	25
Dielectric Constant / Dissipation Factor, IEC 60250:	
1 kHz	4.57 / 0.03
1 MHz	4.08 / 0.03
10 MHz	3.97 / 0.04

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 10 seconds @ 22 °C

Tensile Strength, ISO 6922:	
Buna-N	N/mm ² ≥4.5 ^{LMS} (psi) (≥652)

Cured for 72 hours @ 22 °C

Tensile Strength, ISO 6922:	
Buna-N	N/mm ² 9 to 15 (psi) (1,300 to 2,200)
Steel (grit blasted)	N/mm ² 12 to 20 (psi) (1,700 to 2,900)

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ² 17 to 23 (psi) (2,500 to 3,300)
Aluminum (etched)	N/mm ² 4 to 17 (psi) (580 to 2,500)
Zinc dichromate	N/mm ² 0.5 to 3 (psi) (70 to 440)
ABS	N/mm ² 8 to 11 (psi) (1,200 to 1,600)
PVC	N/mm ² 1 to 5 (psi) (150 to 730)

Phenolic	N/mm ²	1 to 3
	(psi)	(150 to 440)
Polycarbonate	N/mm ²	6 to 11
	(psi)	(870 to 1,600)
Nitrile	N/mm ²	0.5 to 1.5
	(psi)	(70 to 220)
Neoprene	N/mm ²	0.5 to 1.5
	(psi)	(70 to 220)

TYPICAL ENVIRONMENTAL RESISTANCE

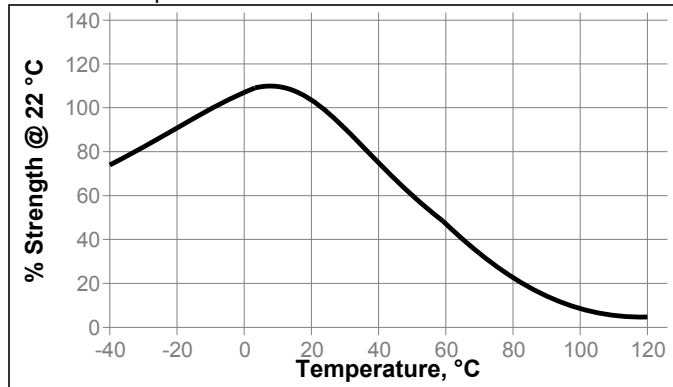
Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)

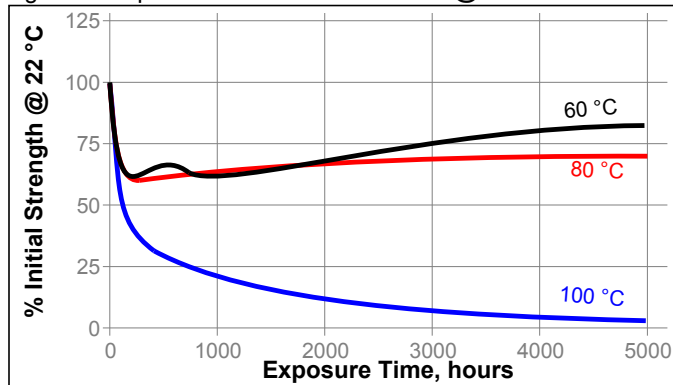
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength			
		100 h	500 h	1000 h	5000 h
Motor oil	40	85	75	60	55
Unleaded gasoline	22	90	80	75	65
Ethanol	22	100	90	110	110
Isopropanol	22	95	100	100	120
Water	22	65	30	30	5
98% RH	40	45	40	35	0

Lap Shear Strength, ISO 4587:

Polycarbonate

Environment	°C	% of initial strength			
		100 h	500 h	1000 h	5000 h
Air	22	75	60	65	75
98% RH	40	85	70	80	85

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. Bond areas should be clean and free from grease. Clean all surfaces with a Loctite® cleaning solvent and allow to dry.
2. 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 the LOCTITE® Activator 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 May 30, 2003. 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note

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Reference 2.1