



# LOCTITE® 5188™

December 2008

## PRODUCT DESCRIPTION

LOCTITE® 5188™ provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Dimethacrylate ester
<b>Appearance (uncured)</b>	Red viscous product <sup>LMS</sup>
<b>Fluorescence</b>	Positive under UV light
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	High
<b>Cure</b>	Anaerobic
<b>Application</b>	Sealing
<b>Strength</b>	Medium
<b>Specific Benefit</b>	Highly flexible, Maintains flexibility after exposure to high temperature

LOCTITE® 5188™ is a form-in-place gasketing product. It is designed for use on rigid metal flanged connections, such as gearboxes and engine casings, particularly where minor oil contamination of the flange surfaces can occur. It cures between close fitting metal surfaces in the absence of air and is particularly suitable for use on aluminum substrates where very good adhesion is achieved. It also provides resistance to low pressures immediately after assembly (instant seal). This product may be dispensed by hand or robotically with the appropriate LOCTITE® product conditioning and dispensing systems.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.1  
 Flash Point - See MSDS  
 Viscosity, Cone & Plate, 25 °C, mPa·s (cP):  
 PK 100, PK 1, 2° Cone @ 20 s<sup>-1</sup> 11,000 to 32,000<sup>LMS</sup>

## Instant Sealing Capability

Anaerobic sealants have the ability to resist low on-line test pressures while uncured. This test was performed with uncured product immediately after assembly of a glass plate and an annular zinc dichromate flange before cure occurred. The pressure was maintained for 1 minute.

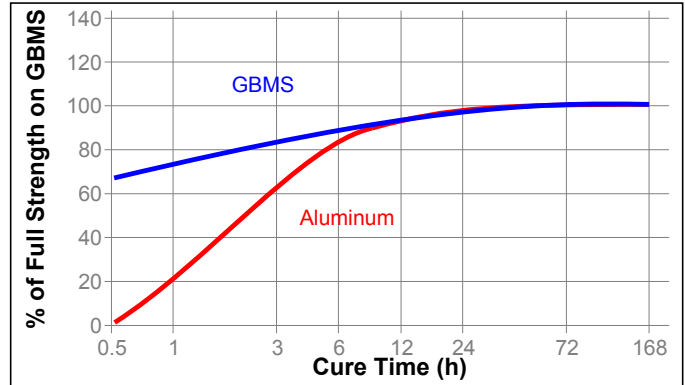
Pressure Resistance, MPa:

Induced Gap 0.0 mm	0.05
Induced Gap 0.125 mm	0.03
Induced Gap 0.25 mm	0.01

## TYPICAL CURING PERFORMANCE

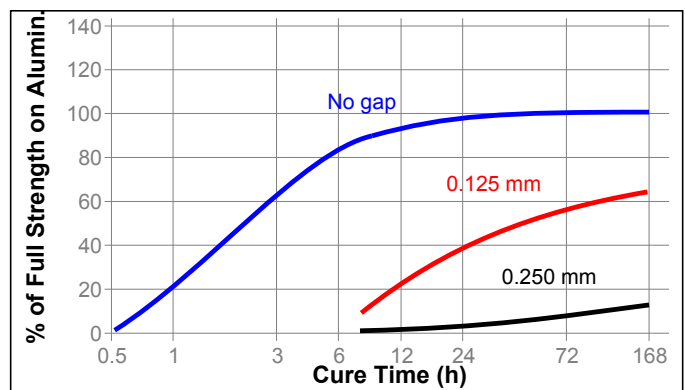
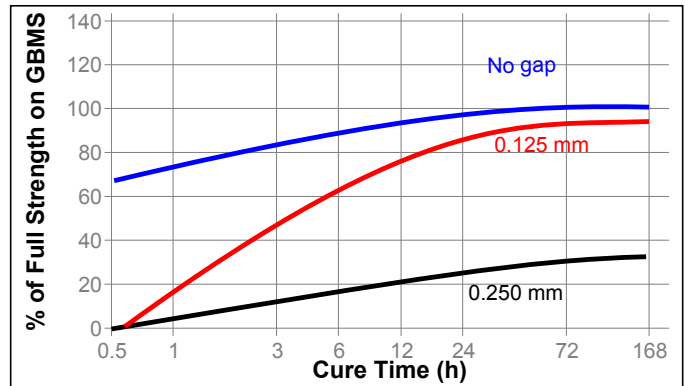
### Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted mild steel lap shears compared to different materials and tested according to ISO 4587.



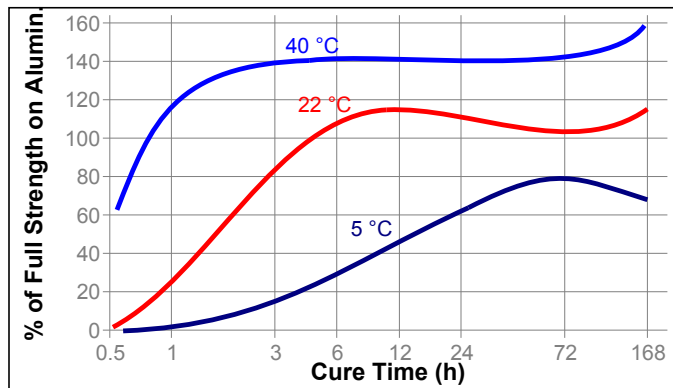
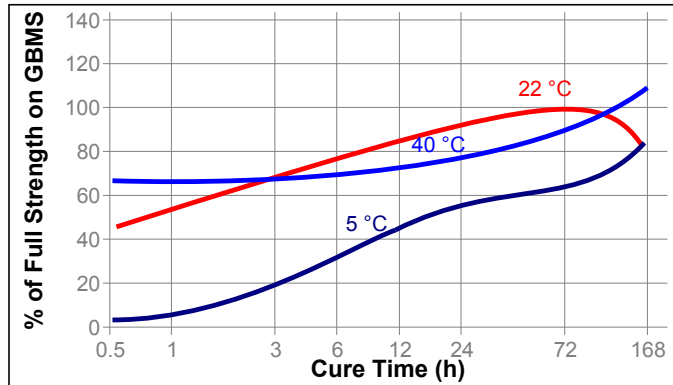
### Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graphs show the shear strength developed with time on grit blasted mild steel and aluminum lap shears at different controlled gaps and tested according to ISO 4587.



### Cure Speed vs. Temperature

The rate of cure will depend on the ambient temperature. The graphs below show the shear strength developed with time at different temperatures on grit blasted mild steel and aluminum lap shears and tested according to ISO 4587.



Cured for 72 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Grit Blasted Mild Steel (GBMS)	N/mm <sup>2</sup>	9.2
	(psi)	(1,330)
Aluminum	N/mm <sup>2</sup>	7.0
	(psi)	(1,010)

Cured for 168 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Grit Blasted Mild Steel (GBMS)	N/mm <sup>2</sup>	7.8
	(psi)	(1,130)
Aluminum	N/mm <sup>2</sup>	8.0
	(psi)	(1,160)

### Sealing Capability

An annular shaped gasket with an inner diameter of 50 mm and an external diameter of 70 mm was tested up to 1.3 MPa for leakage (immersion in water for 1 minute).

Sealed to Maximum Induced Gap, mm:

Mild steel	0.25
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### TYPICAL ENVIRONMENTAL RESISTANCE

The following tests refer to the effect of environment on strength. This is not a measure of sealing performance.

Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587

### TYPICAL PROPERTIES OF CURED MATERIAL

#### Physical Properties:

Coefficient of Thermal Expansion, K<sup>-1</sup>:

Pre Tg	145×10 <sup>-6</sup>
Post Tg	160×10 <sup>-6</sup>

Glass Transition Temperature, °C

105

Elongation, at break, %

186

Tensile Strength, at break

N/mm<sup>2</sup> 4.24  
(psi) (610)

Tensile Modulus

N/mm<sup>2</sup> 4.17  
(psi) (600)

### TYPICAL PERFORMANCE OF CURED MATERIAL

#### Adhesive Properties

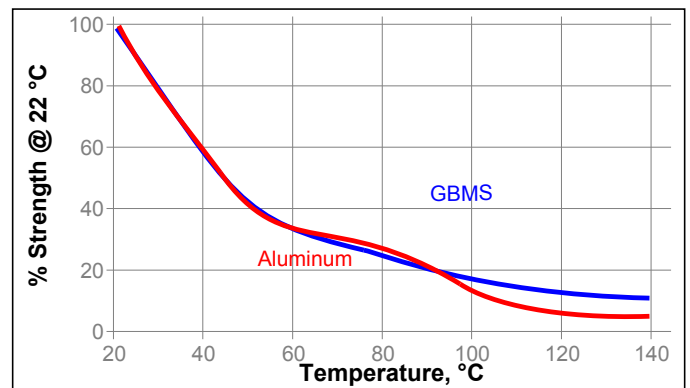
Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Grit Blasted Mild Steel (GBMS)	N/mm <sup>2</sup>	≥2.0 <sup>LMS</sup>
	(psi)	(≥290)
Aluminum	N/mm <sup>2</sup>	≥3.0 <sup>LMS</sup>
	(psi)	(≥435)

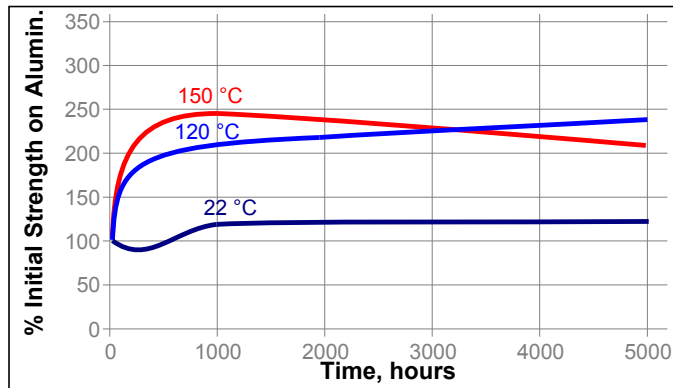
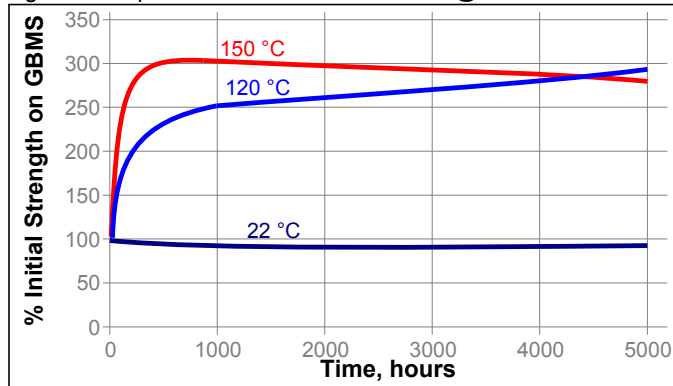
### Hot Strength

Tested at temperature



**Heat Aging**

Aged at temperature indicated and tested @ 22 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C

**Grit Blasted Mild Steel (GBMS)**

Environment	°C	% of initial strength			
		100 h	500 h	1000 h	5000 h
Auto trans. fluid	120	140	190	215	260
Auto trans. fluid	150	165	270	250	270
Motor oil	120	170	210	250	185
Motor oil	150	190	245	270	185
Unleaded gasoline	22	80	50	65	30
Water/glycol	87	85	90	65	60

**Aluminum**

Environment	°C	% of initial strength			
		100 h	500 h	1000 h	5000 h
Auto trans. fluid	120	125	150	150	160
Auto trans. fluid	150	135	125	170	195
Motor oil	120	155	170	190	125
Motor oil	150	160	185	190	160
Unleaded gasoline	22	90	45	20	15
Water/glycol	87	35	25	35	30

**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).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

**Directions for use:**

1. For best performance bond surfaces should be clean and free from grease.
2. The product is designed for close fitting flanged parts.
3. LOCTITE® automatic dispensing equipment is recommended for best results. Application by screen printing, roller coating or bead dispense can also be achieved manually.
4. To obtain best results, each application should be evaluated under the specific conditions anticipated for dispensing, performance and durability of the parts.
5. Low pressures (<0.05 MPa) may be used when testing to confirm a complete seal immediately after assembly and before curing.
6. Flanges should be tightened as soon as possible after assembly to avoid shimming.

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

LMS dated November 18, 2008. 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: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °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**

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

**Note**

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Reference 0.1