

LOCTITE UK 8306 B5 / LOCTITE UK 5401

November 2015

PRODUCT DESCRIPTION

LOCTITE UK 8306 B5 / LOCTITE UK 5401 provides the following product characteristics:

Technology	Polyurethane
Product Type	PU Adhesive
Cure	Polyaddition
Condition	Solvent-free
Components	Two-components
Component A	Resin
Component B	Hardener
Application	Assembly
Appearance (Comp. A)	beige
Appearance (Comp. B)	brown
Mixing Ratio, by weight Comp. A : Comp. B	5 : 1
Mixing Ratio, by volume Comp. A : Comp. B	4.2 : 1

LOCTITE UK 8306 B5 / LOCTITE UK 5401 is a solvent-free two-component adhesive, based on polyurethane. The resin part (component A) contains organic compounds with hydroxyl groups, the hardener (component B) is based on isocyanates.

By mixing both components in a mix ratio of 5 : 1 a hard elastic adhesive is formed through chemical reaction. After curing the product exhibits no measurable change in volume.

As natural raw materials (from different cultivation areas) are used a variation in color between different batches is possible.

Application Areas

LOCTITE UK 8306 B5 / LOCTITE UK 5401 is used for the adhesion of pretreated metals, plastics and rigid foams.

The main application is the production and assembly of sandwich elements, e.g. for vehicles, containers and the construction industry.

TECHNICAL DATA

Component A

Loctite UK 8306 B5:

Consistency:	pasty
Density, g/cm ³	1.41 to 1.51

Component B

Loctite UK 5401:

Consistency:	liquid
Density, g/cm ³	1.17 to 1.27
Viscosity - Brookfield - RVT, 20°C, mPa.s *	250 to 350
Henkel method 10	

Mixture (Component A + B):

Consistency:	pasty
Viscosity - Brookfield - RVT, 20°C, mPa.s *	250,000 to 280,000
Henkel method 11	
Pot life (240g, 20 °C), min*	4 to 6
Henkel method 21	
Tensile shear strength, MPa *	>12
EN 1465 / Henkel method 40	

All technical data based on Henkel test method.

Data with * are specified.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Pretreatment:

The substrate should be clean, dry, free of dust, oil, grease and other contaminants. The usage of suitable primers on metal surfaces can improve the adhesion and/or the long-term bond stability. The surface of plastic materials should be cleaned, so as to remove any kind of release agents present on the substrate surface. An improvement of the adhesion can be achieved by grinding or sandblasting the surface.

Application:

Adhesive components can be mixed manually by using an electrical hand mixer or by using a two-component dispensing system. After mixing no streaks must be visible. The adhesive is only to be used within a limited time (pot life). After this time the mixture gels up and is not suitable for use. Therefore only the amount that can be applied within the time of pot life should be mixed. The pot life depends on the quantity and temperature of the mixed batch. With larger quantities and an increase in temperature, the pot life decreases. Lower temperatures extend the pot life. Adhesive

components should not come into contact with moisture during storage or application. Contact with moisture generates foaming of the adhesive and weakens the bondline. Therefore all packaging should be sealed properly and protected against humidity during storage.

Curing:

LOCTITE UK 8306 B5 / LOCTITE UK 5401 can be cured between 15°C and elevated temperatures (up to 60 °C). The curing time will be reduced substantially with increasing temperatures. While curing there should be adequate contact pressure (load pile, presses, clamps) and fixtures to hold the joint in place. An adhesive squeeze out along the bond line is a good indication of sufficient adhesive in the joints.

Cleaning:

Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with LOCTITE SF 8040; cured adhesive can only be removed mechanically.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

Storage

Component A:

Recommended Storage Temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	12 months

Component B:

Recommended Storage Temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	12 months

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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