

SEALANTS

A20

LOCTITE 406



Steel (degreased)	20 to 45
Aluminum (etched)	<5
Neoprene	<5
Rubber, nitrile	<5
ABS	<5
PVC	<5
Polycarbonate	10 to 20
Phenolic	<5

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

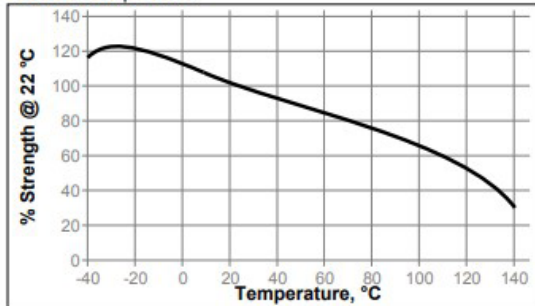
The rate of cure will depend on the ambient relative humidity. The best results are achieved when the relative humidity in the working environment is 40% to 60% at 22°C. Lower humidity leads to slower cure. Higher humidity accelerates it, but may impair the final strength of the bond.

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.

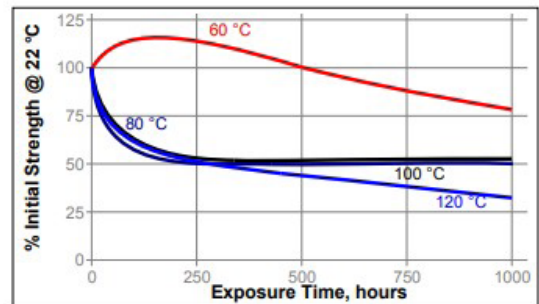
Technology	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to straw colored liquid ^{LMS}
Components	One part - requires no mixing
Viscosity	Low
Cure	Humidity
Application	Bonding
Key Substrates	Plastics and Rubbers

Hot Strength
Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



PART NO.	NAME	DESCRIPTION
LT406633	Loctite 406 super bonder 25ml	Bonds most plastics, elastomers & rubbers, Rapid bonding of plastic & rubber



WA Store: 148 Welshpool Road, Welshpool 6106
 QLD Store: 17 Alexandra Place, Murarrie 4172
 Email: websales@indrub.com.au

www.indrub.com.au