

### PRODUCT DESCRIPTION

LOCTITE® Product 454 is fast curing, single component gel cyanoacrylate adhesive. It is specifically formulated for difficult to bond substrates. The gel consistency prevents adhesive flow even on vertical surfaces.

### TYPICAL APPLICATIONS

Rapid bonding of a wide range of metal, plastic or elastomeric materials, particularly suited for bonding porous or absorbent materials such as wood, paper, leather or fabric.

### PROPERTIES OF UNCURED MATERIAL

	Value	Typical Range
Chemical Type	Ethyl cyanoacrylate	
Appearance	Clear, translucent	
Specific Gravity @ 25°C	1.1	
Viscosity @ 25°C, mPa.s (cP)	Gel	
Flash Point (TCC), °C	>80	

### TYPICAL CURING PERFORMANCE

Under normal conditions, the surface moisture initiates the hardening 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 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> (14.5 psi) tested according to ASTM D1002.

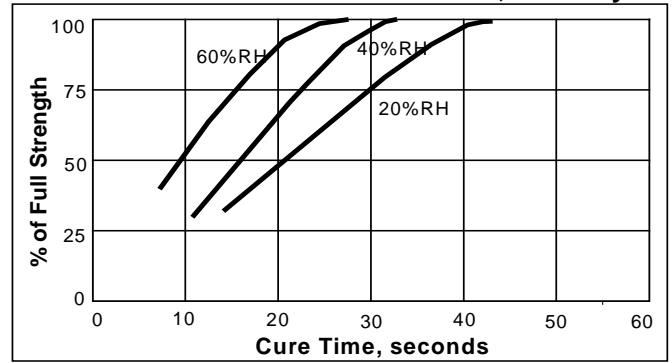
Substrate	Fixture Time, seconds
Steel (degreased)	5 to 20
Aluminium	2 to 10
Zinc dichromate	10 to 20
Neoprene	<5
Nitrile rubber	<5
ABS	2 to 10
PVC	2 to 10
Polycarbonate	10 to 40
Phenolic materials	2 to 10

### Cure speed vs. bond gap

The rate of cure will depend on the bondline gap. High cure speed is favoured by thin bond lines. Increasing the bond gap will slow down the rate of cure.

### Cure speed vs. humidity

The rate of cure will depend on the ambient relative humidity. The following graph shows the tensile strength developed with time on Buna N rubber at different levels of humidity.



### Cure speed vs. activator

Where cure speed is unacceptably long due to large gaps or low relative humidity applying activator to the surface will improve cure speed. However, this can reduce the ultimate strength of the bond, therefore testing is recommended to confirm effect.

### TYPICAL PROPERTIES OF CURED MATERIAL

#### Physical Properties

Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	80 x 10 <sup>-6</sup>
Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1
Glass transition temperature, ASTM, E228, °C	120

#### Electrical Properties

	Constant	Loss	
Dielectric constant & loss, 25°C, ASTM D150 measured at	100Hz	2.65	<0.02
	1kHz	2.75	<0.02
	10kHz	2.65	<0.02
	Volume resistivity, ASTM D257, Ω.cm		1 x 10 <sup>16</sup>
Surface resistivity, ASTM D257, Ω		1 x 10 <sup>16</sup>	
Dielectric strength, ASTM D149, kV/mm		25	

### PERFORMANCE OF CURED MATERIAL

(After 24 hr at 22°C)

	Value	Typical Range	
Shear Strength, ASTM D1002/DIN 53283	Grit Blasted Steel, N/mm <sup>2</sup> (psi)	22 (3200)	18 to 26 (2600 to 3800)
		15 (2200)	11 to 19 (1600 to 2800)
	Etched Aluminium, N/mm <sup>2</sup> (psi)	7 (1000)	4 to 10 (600 to 1450)
		13 (1900)	6 to 20 (900 to 3000)
	Zinc dichromate, N/mm <sup>2</sup> (psi)	13 (1900)	6 to 20 (900 to 3000)
		12.5 (1800)	5 to 20 (700 to 3000)
	ABS, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)
		10 (1450)	5 to 15 (700 to 2200)
	PVC, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)
		10 (1450)	5 to 15 (700 to 2200)
	Polycarbonate, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)
		10 (1450)	5 to 15 (700 to 2200)
Phenolic, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)	
	10 (1450)	5 to 15 (700 to 2200)	
Neoprene rubber, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)	
	10 (1450)	5 to 15 (700 to 2200)	
Nitrile rubber, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)	
	10 (1450)	5 to 15 (700 to 2200)	
Tensile Strength, ASTM D2095, DIN 53282	Grit Blasted Steel, N/mm <sup>2</sup> (psi)	18.5 (2700)	12 to 25 (1700 to 3600)
		10 (1450)	5 to 15 (700 to 2200)
Buna N rubber, N/mm <sup>2</sup> (psi)	10 (1450)	5 to 15 (700 to 2200)	
	10 (1450)	5 to 15 (700 to 2200)	

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.

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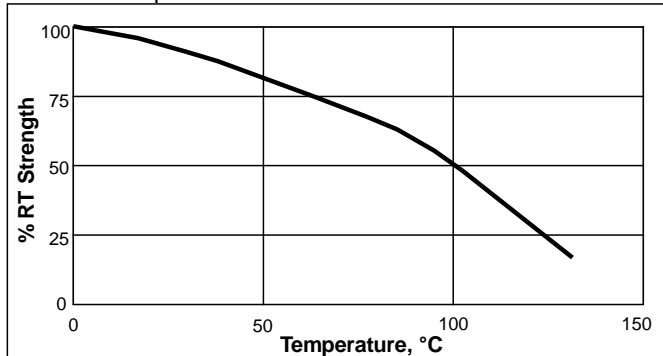
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**TYPICAL ENVIRONMENTAL RESISTANCE**

Test Procedure : Shear Strength ASTM D1002/DIN 53283  
 Substrate: Grit blasted mild steel laps  
 Cure procedure: 1 week at 22°C

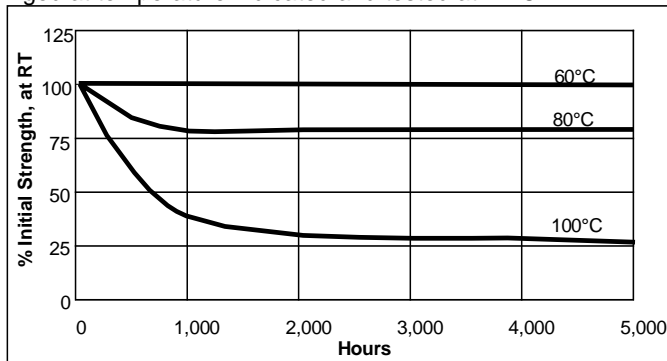
**Hot Strength**

Tested at temperature.



**Heat Ageing**

Aged at temperature indicated and tested at 22°C.



**Chemical / Solvent Resistance**

Aged under conditions indicated and tested at 22°C.

Solvent	Temp.	%Initial strength retained at		
		100 hr	500 hr	1000 hr
Motor Oil	40°C	85	85	75
Leaded Petrol	22°C	100	100	100
Ethanol	22°C	100	100	100
Isopropanol	22°C	100	100	100
Freon T.A.	22°C	100	100	100
Humidity 95% RH	40°C	65	55	50
Humidity 95% RH polycarbonate	40°C	100	100	100

**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 oxidising materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

**Directions for use**

For best performance surfaces should be clean and free of grease. This product performs best in thin bond gaps, (0.05mm). Excess adhesive can be dissolved with Loctite clean up solvents, nitromethane or acetone.

**Storage**

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 21°C (46°F to 70°F) unless otherwise labelled. Optimal storage conditions for unopened containers of cyanoacrylate products are achieved with refrigeration: 2°C to 8°C (36°F to 46°F). Refrigerated packages shall be allowed to return to room temperature prior to opening and use. To prevent contamination of unused product, do not return any material to its original container. For specific shelf life information contact your local Technical Service Centre.

**Data Ranges**

The data contained herein may be reported as a typical value and/or range (based on the mean value ±2 standard deviations). Values are based on actual test data and are verified on a periodic basis.

**Note**

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