

# LOCTITE CR 3502 / LOCTITE CR 4620

(Draft - product on hold) March 2014

## PRODUCT DESCRIPTION

LOCTITE CR 3502 / LOCTITE CR 4620 provides the following product characteristics:

<b>Technology</b>	Polyurethane
Product Type	PU Adhesive
<b>Cure</b>	Polyaddition
Condition	Solvent-free
<b>Components</b>	Two-components
Component A	Resin
Component B	Hardener
<b>Application</b>	Casting compound
Color (Comp. A)	Yellowish
Color (Comp. B)	Yellowish
Mixing Ratio, by weight Comp. A : Comp. B	100 : 62

LOCTITE CR 3502 / LOCTITE CR 4620 is a solvent-free two-component casting resin, 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 100 : 62 a hard elastic casting resin is formed through chemical reaction.

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

**LOCTITE CR 3502 / LOCTITE CR 4620 is a testing product. Technical data are subject to change.**

## APPLICATION AREAS

LOCTITE CR 3502 / LOCTITE CR 4620 is used as a casting material for dialyzing units.

## TECHNICAL DATA

### Component A

#### Loctite CR 3502:

Consistency:	liquid
Density, g/cm <sup>3</sup>	0.91 to 1.01
Viscosity, Brookfield - RVT, 20°C, mPa.s *	800 to 1,600
Henkel method 10	

### Component B

#### Loctite CR 4620:

Consistency:	liquid
Density, g/cm <sup>3</sup>	1.16 to 1.26
Viscosity, Brookfield - RVT, 20°C, mPa.s *	1,150 to 1,650
Henkel method 10	

### Mixture (Component A + B):

Consistency:	liquid
Viscosity at 25°C, mPas Henkel method 11	600 to 1,400
Pot life (180g, 25 °C), sec* Henkel method 21	420 to 540
Shore A hardness (23 °C) ISO 868	87 to 97

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 and inclusion of air must be prevented. 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 CR 3502 / LOCTITE CR 4620 can be cured between 20°C and elevated temperatures (up to 80°C). The curing time will be reduced substantially with increasing temperatures. The addition of chemical catalysts (accelerators) also speeds up the curing reaction (i.e. pot life, open time).

#### **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 25
Shelf-life (in unopened original packaging)	9 months

##### **Component B**

Recommended Storage Temperature, °C	10 to 40
Shelf-life (in unopened original packaging)	9 months

Storage < 10°C or > 40°C can cause irreversible damage to product.

## **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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

#### **Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.