

LOCTITE UK 8303 B20 / LOCTITE UK 5400

January 2018

PRODUCT DESCRIPTION

LOCTITE UK 8303 B20 / LOCTITE UK 5400 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	6 : 1
Mixing Ratio, by volume Comp. A : Comp. B	4.4 : 1

LOCTITE UK 8303 B20 / LOCTITE UK 5400 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 6 : 1 a hard elastic product 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 8303 B20 / LOCTITE UK 5400 is used for bonding of pretreated metals, wood and plastics with rigid foams.

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

TECHNICAL DATA

Component A

Loctite UK 8303 B20:

Consistency: pasty
Density, g/cm³: 1.6 to 1.7

Component B

Loctite UK 5400:

Consistency: liquid
Density, g/cm³: 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, 25 °C, mPa.s 200,000 to 300,000
Henkel method 11
Pot life (210g, 25°C), min * 17 to 23
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, with stirring application or two-component mixing equipment. The product may be applied by spatula, wheel, pouring or spraying. 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 (water vapour) 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 8303 B20 / LOCTITE UK 5400 can be cured at room temperature above 15°C and elevated temperatures (up to 60°C). The curing time can be reduced by increasing the temperature with the simultaneous reduction of processing time (i.e. pot life, open time) to be observed. While curing there should be adequate contact pressure (load pile, presses, clamps) and fixture 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.

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

Classification:

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

Hazards identification
Transport information
Regulatory information

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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Reference 0.0