LOCTITE

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Product Description Sheet

Hysol® Product 9460F

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Description

Loctite® Hysol® 9460F is a faster cure version of 9460. The handling strength and pot life, are reduced by approximately 50% while maintaining most of the performance of Hysol 9460.

Recommend Substrates: metals, phenolic plastics, polyester, hard boards and forestry products, ceramics rubber, masonry materials and other construction materials.

Features

Shortened Pot Life
Fast Handling Strength
Good Peel Strength
Non-Sag Slump Resistant
Good Tensile Sheer Strength
Easily Mixed/Easily Dispensed

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 250 grams mins	--	--	15 to 20
Color	White	Black	Grey
Viscosity, cP	150,000 to 300,000	100,000 to 250,000	150,000 to 250,000
Mix Ratio			
By weight	100	100	--
By volume	1	1	--

Typical Properties	Typical Value
Hardness, Shore D	80

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	**Test Temp °F**	**Typical Value**
6 Hours @ RT	77	2000
18 Hours @ RT	77	3500
3 Days @ RT	77	4000
	180	400

Peel Strength ASTM D 3167	Etched Aluminum, pli
3 Days @ 77oF	40

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 oxidizing materials.

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

Handling

Mixing: This product requires mixing two components together just prior to the application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be at room temperature.

Application

Mixing – Bulk: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly. Continue to mix until all white and black streaks are gone and mix is uniformly grey. This is important! Heat build-up during or after mixing is normal. Do not mix quantities greater than two pounds as dangerous heat build-up can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat build-up.

Mixing – Cartridges: Place cartridge in proper dispenser. To begin using a new cartridge, remove cartridge cap and dispense a small amount of adhesive, making sure Part A and Part B are extruding. Attach nozzle and dispense approximately 1-2" before applying onto the part being bonded. Partially used cartridges can be stored with mixing nozzle attached. To reuse, remove and discard the old nozzle, attach new nozzle and begin dispensing.

Application: Bonding surfaces should be clean and dry. Once the adhesive is applied, the boned parts should beheld in contact until the part has developed handling strength. It is not necessary to clamp the parts unless movement during curing is likely.

Cure: Hysol 9460F is formulated for fast cure and handling time. Parts can be handled in 3-4 hours at room temperature Ultimate properties are achieved in 3 days at room temperature. Hysol 9460F can also be cured for 2 hours @ 140°F or 1 hour @ 180°F

Clean-up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

Packaging

50 ml and 200 ml EPS Cartridges
One and Five Gallon Systems

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

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