



TECHNICAL DATA SHEET



Henkel Corporation
 Professional and Consumer Adhesives
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Item #	Package	Size
1360788	Carded Syringe	0.85 fl. oz.

DESCRIPTION:

Loctite® Epoxy Plastic is a two-part adhesive consisting of an epoxy resin and a hardener. When mixed in equal volumes, the resin and hardener react to produce a tough, rigid, high strength bond in 5 minutes for most projects. Available in a convenient dual syringe which delivers equal parts of both components every time. Loctite Epoxy Plastic can be used as an adhesive for a wide range of plastic materials or as a versatile filler for gap filling, surface repairs and laminating. Loctite Epoxy Plastic does not shrink and is resistant to water and most common solvents. It can be tinted with earth pigments, cement or sand for color matching. It can be sanded and drilled.

RECOMMENDED FOR:

Loctite Epoxy Plastic can be used for bonding ABS, fiberglass, hard plastics, PVC & many other plastics.

LIMITATIONS:

- Not recommended for polyethylene, polypropylene, non-stick coatings, nylon products or flexible materials.
- Do not use in applications requiring short term heat exposure greater than 302°F (150°C).
- Do not use in applications where the bonds will be exposed to continuous water immersion or continuously wet areas.
- Do not use in potable water systems.

FEATURES & BENEFITS:

Feature	Benefits
Machinable.....	Will not crack when drilled
Water resistant.....	Great for interior and exterior projects
Sets in 4 to 10 minutes.....	Quick completion of projects
Convenient syringe.....	Dispenses equal amounts of each component

TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
Color:	Hardener: Light yellow Resin: Colorless	Application Temperature:	39°F (4°C) to 95°F (35°C)
Base:	Epoxy resin / Polymercaptan hardener	Odor:	Mild amine
Specific Gravity:	Hardener: 1.04 Resin: 1.17	Gel Time: (5g:5g)	4 to 10 minutes*
Flashpoint:	Hardener: >200°F (93°C) Resin: >480°F (249°C)	Usable Strength:	1 hour*
VOC Content:	0.1% by weight, CARB (resin & hardener)	Full Cure Time:	24 hours*
Shelf Life:	24 months (from date of manufacture, unopened)	*Time is based on temperature, humidity, and thickness of epoxy applied	

Lot Code Explanation:	LB7FAC56 (Example)	A – January	G – July
	7 = Last digit in the year of manufacture	B – February	H – August
	7 = 2017	C – March	J – September (there is no I)
	F = Month produced (see chart on right)	D – April	K – October
	F = June	E – May	L – November
	June 2017 is the date of manufacture	F – June	M – December



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Typical Cured Performance Properties			
Color:	Translucent Yellow	Cured form:	Non-flammable, hard, solid.
Paintable:	No	Water Resistant:	Yes
Hardness:	80 (+/-1), Shore D	Sandable:	Yes
Service Temperature:	-10°F(-23°C) to 120°F (49°C) -10°F(-23°C) to 302°F (150°C)	Long term exposure	Short term exposure

Test Methods	Cure Time	Data	Substrates
Compressive Shear Strength:	24 hour cure	1081 ± 199 psi (7.45 ± 1.37 N/mm ²) 958 ± 268 psi (6.61 ± 1.85 N/mm ²)	Sanded, Hard PVC (White) Sanded, Acrylite FF

DIRECTIONS:

Tools Typically Required

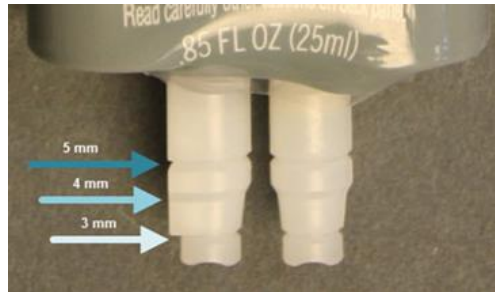
Utility knife, mixing tool/applicator (e.g. small flat plastic or wooden stick), disposable surface (e.g. foil).

Safety Precautions:

Apply and cure in a well-ventilated area. Wear gloves and wash hands after use.

Preparation:

Surfaces must be clean, dry and free from oil, wax, paint, rust, etc. Roughen smooth surfaces for better adhesion by sandblasting or sanding with an emery cloth. Wash glass and ceramic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Remove the plug from between the piston. Cut off the end tips of the syringe at one of the three cut-off points as illustrated below. For easier extrusion, cut at the 4 mm or 5mm opening. For more precise application, cut at 3 mm opening.



Turn syringe dispensing end up and pull plunger back slightly allowing air bubbles to rise to top. Take care to not exert excessive pressure or plunger may pull out of syringes. Press the plunger to expel air. Depress the double piston to dispense equal parts of the two materials on a disposable surface. Mix resin and hardener thoroughly (about 1 minute). Wipe syringe tips clean, retract piston slightly and close with the plug. Ensure that the plug is always placed in the same orientation on the tips.

Application: Apply a small amount of mixed adhesive to both surfaces, within one or two minutes of mixing and press together. Placing parts together close to the 5 minute set time will reduce adhesion. Remove any excess glue immediately by wiping with acetone. Support bond for at least 10 minutes at room temperature. Usable strength achieved in 1 hour. Full cure and strength in 24 hours.

Clean-up: Clean excess glue immediately with acetone before adhesive sets. Cured adhesive may be cut away with caution using a sharp blade. Prolonged immersion in paint stripper will soften the cured adhesive to aid removal. Note: Acetone is highly flammable and not compatible with all surfaces. Follow manufacturer's instructions and test on small area before applying.

STORAGE AND DISPOSAL

Not damaged by freezing. If frozen, warm to room temperature until the resin and hardener become liquid enough to mix. Use an approved hazardous waste facility for disposal.



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LABEL PRECAUTIONS

DANGER: Corrosive. Causes eye and skin burns. May cause allergic skin reaction. May be harmful if swallowed or absorbed through skin. Vapor harmful.

DANGER: Contains epoxy resin, polymercaptan, and amine curing agents. Do not get in eyes or on skin. Do not breath vapors. **FIRST AID:** For eye contact, flush with water for 15 minutes, call a physician if symptoms persist. For skin contact wash thoroughly with soap and water call a physician if symptom persist. If swallowed, **DO NOT** induce vomiting, call a physician. **KEEP OUT OF REACH OF CHILDREN.**



WARNING: Cancer and Reproductive Harm – www.P65Warnings.ca.gov

Refer to the Safety Data Sheet (SDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.



Trusted Performance. Proven Results.

For over 50 years, Loctite Brand adhesives and sealants have taken on the toughest jobs. Used in race cars, airplanes, and even in the space-shuttle, Loctite provides solutions for the most demanding industrial, professional and consumer applications. Loctite gives you not the specialization, power and performance to not only get your job done, but to get it done right.

For Technical Assistance call : 1-800-624-7767 – Mon-Fri - 9:00a – 4:00p ET
www.loctiteproducts.com



Loctite Brand is part of the Henkel family of brands. Founded in 1876, Henkel is a global leader in the consumer and industrial businesses. Henkel operates worldwide with leading brands and technologies in three business areas: Laundry & Home Care, Beauty Care and Adhesive Technologies.

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