Technical Data Sheet

LOCTITE® 410™

March 2008

PRODUCT DESCRIPTION

LOCTITE® 410™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Black liquid[LMS]
Components	One part - requires no mixing
Viscosity	High
Cure	Humidity
Application	Bonding
Key Substrates	Metals , Plastics and Rubbers

LOCTITE® 410™ is a rubber toughened adhesive with increased flexibility and peel strength along with enhanced resistance to shock.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm,	1,700 to 5,000[LMS]
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing 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 the 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/mm² .

Fixture Time, seconds:	
Steel (degreased)	60 to 120
Aluminum	10 to 30
Neoprene	15 to 25
Rubber, nitrile	15 to 25
ABS	20 to 50
PVC	50 to 100
Polycarbonate	30 to 90
Phenolic	20 to 60

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Activator

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

TYPICAL PROPERTIES OF CURED MATERIAL

After 24 hours @ 22 °C

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}	80×10^{-6}
Coefficient of Thermal Conductivity, ISO 8302 , W/(m·K)	0.1
Glass Transition Temperature, ASTM E 228, °C	120

Electrical Properties:

Dielectric Constant / Dissipation Factor, IEC 60250:

0.05 kHz	2.3 / <0.02
1 kHz	2.3 / <0.02
1,000 kHz	2.3 / <0.02

Volume Resistivity, IEC 60093, Ω·cm	10×10^{15}
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	25

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm²	22
	(psi)	(3,190)
Aluminum (etched)	N/mm²	15
	(psi)	(2,175)
ABS	N/mm²	>6
	(psi)	(>870)
PVC	N/mm²	>6
	(psi)	(>870)
Polycarbonate	N/mm²	>5
	(psi)	(>725)
Phenolic	N/mm²	10
	(psi)	(1,450)
Neoprene	N/mm²	>10
	(psi)	(>1,450)
Nitrile	N/mm²	>10
	(psi)	(>1,450)

Tensile Strength, ISO 6922:

Steel (grit blasted)	N/mm²	18.5
	(psi)	(2,680)

After 48 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm²	≥15.8
	(psi)	(≥2,290)

Cured for 24 hours @ 22 °C, followed by 24 hours @ 121 °C, tested @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm²	≥19.3[LMS]
	(psi)	(≥2,800)

TYPICAL ENVIRONMENTAL RESISTANCE

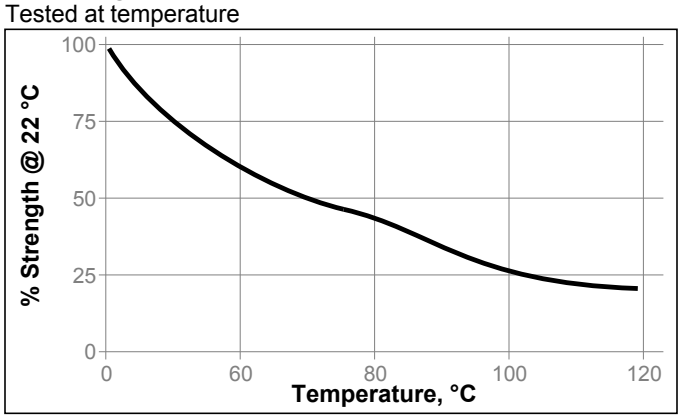
After 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Mild steel (grit blasted)

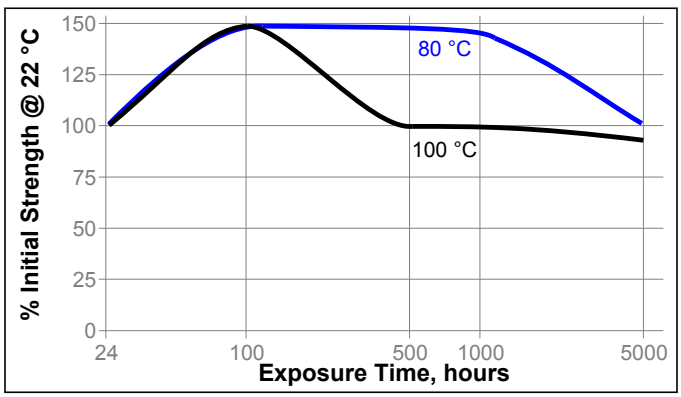
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

		% of initial strength		
Environment	**°C**	**100 h**	**500 h**	**1000 h**
Motor oil (MIL-L-46152)	40	85	85	85
Gasoline	22	90	70	70
Isopropanol	22	75	75	75
Industrial methylated spirits	22	95	95	80
1,1,1 Trichloroethane	22	80	70	50
Freon TA	22	90	90	85
Heat/humidity 95% RH	40	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 oxidizing materials.

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

Directions for use:

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

Loctite Material Specification[LMS]

LMS dated June 13, 2001. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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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