

LOCTITE AA 5251 A

April 2020

PRODUCT DESCRIPTION

LOCTITE AA 5251 A provides the following product characteristics:

Technology	Acrylate
Appearance	Clear yellow liquid
Cure	UV Cure
Application	Sealants & Gasketing Material
Typical Application(s)	Cured in place gasketing, Water/dust sealing (IP67 or higher), Outdoor enclosure sealing and NVH reduction

LOCTITE AA 5251 A acrylate material is formulated to form a low compression set elastomeric cure-in-place gasket when exposed to UV light of sufficient intensity. It is designed for automotive OEM, sub-component, industrial and electronics enclosure applications where a pre-applied and reusable acrylic rubber gasket is desired.

The thixotropic nature of LOCTITE AA 5251 A reduces the migration of liquid product after application to the substrate.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Extrusion Rate @ 25 °C, g/min:	
@ 50 psig, 1/8" orifice	200 to 500
Specific Gravity @ 25°C	1.05
Flash Point - See SDS	
Volatility, ASTM D5403-93 Method A, %	3.56

TYPICAL CURING PERFORMANCE**Recommended UV Cure Condition**

Light Intensity, mW/cm ²	70
Wavelength, nm	365
Exposure Time, seconds	60

Depth of Cure

Depth of Cure, mm	≥10
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The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Sample cured 70 mW/cm² @ 365 nm for 30 seconds per side

Physical Properties

Shore Hardness, Durometer A	23
Elongation, %	≥200

Compression set, %:

22 hours @ 23°C	7
70 hours @ 23°C	8.7
22 hours @ °C	9.35

TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Shear Strength	N/mm ²	2
	(psi)	(290)

GENERAL INFORMATION

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

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

DIRECTIONS FOR USE

1. This product is UV light sensitive; exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling.
2. For best performance, bond surface should be clean and free from grease.

STORAGE

This product is UV light sensitive. Exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container label.

Material removed from the containers may be contaminated during use. Do not return the product to the original container. Henkel 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb/F}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

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.

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