

LOCTITE CR 3519 / LOCTITE CR 4200

December 2020

PRODUCT DESCRIPTION

LOCTITE CR 3519 / LOCTITE CR 4200 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
Color (Comp. A)	White
Color (Comp. B)	Brown
Mixing Ratio, by weight Comp. A : Comp. B	100 : 80

LOCTITE CR 3519 / LOCTITE CR 4200 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 100 : 80 a hard elastic casting resin is formed through chemical reaction.

As natural raw materials (from different cultivation areas) are used a variation in color between different batches is possible.

Application areas:

LOCTITE CR 3519 / LOCTITE CR 4200 is mainly used for the industrial production process of filters.

TECHNICAL DATA

Component A

Loctite CR 3519:

Consistency	liquid
Density, g/cm ³	0.99 to 1.09
Viscosity, Brookfield - RVT, 20°C, mPa.s *	2,600 to 3,800
Henkel method 10	

Component B

Loctite CR 4200:

Consistency	liquid
Density, g/cm ³	1.17 to 1.27
Viscosity, Brookfield - RVT, 20°C, mPa.s *	3,000 to 4,400
Henkel method 10	

Mixture (Component A + B):

Consistency	liquid
Viscosity, Brookfield - RVT, 25°C, mPa.s *	1,100 to 1,900
Henkel method 11	
Pot life (180g, 25°C), min *	30 to 40
Henkel method 21	
Shore D hardness at 23 °C ISO 868	60 to 70

All technical data based on Henkel test method.

Data with * are specified.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to application 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.

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:

The components of the casting resin can be mixed manually by using an electrical hand mixer or by using a two-component dispensing system and inclusion of air must be prevented. After mixing no streaks must be visible. The casting resin 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. The components should not come into contact with moisture during storage or application. Contact with moisture generates foaming of the casting resin and weakens the bondline. Therefore all packaging should be sealed properly and protected against humidity during storage.

Curing:

LOCTITE CR 3519 / LOCTITE CR 4200 can be cured between 20°C and elevated temperatures (up to 80°C). The curing time will be reduced substantially with increasing temperatures. The addition of chemical catalysts (accelerators) also speeds up the curing reaction (i.e. pot life, open time).

Cleaning:

Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with LOCTITE SF 8040; cured adhesive can only be removed mechanically.

Classification:

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

Hazards identification**Transport information****Regulatory information****Storage:****Component A**

Recommended storage temperature, °C	10 to 30
Shelf-life (in unopened original packaging)	9 months

Component B

Recommended storage temperature, °C	10 to 30
Shelf-life (in unopened original packaging)	9 months

ADDITIONAL INFORMATION**Disclaimer**

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.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.4