

LOCTITE CR 3525 / LOCTITE CR 4200

October 2015

PRODUCT DESCRIPTION

LOCTITE CR 3525 / LOCTITE CR 4200 provides the following product characteristics:

Technology	Polyurethane
Product Type	Sealing Compound
Cure	Polyaddition
Condition	Solvent-free
Components	2-component
Component A	Resin
Component B	Hardener
Application	Assembly
Color (Comp. A)	Yellowish
Color (Comp. B)	Yellowish
Mixing Ratio, by weight Comp. A : Comp. B	100 : 75

LOCTITE CR 3525 / LOCTITE CR 4200 is a solvent-free two-component casting resin, 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 : 75 a hard elastic casting resin is formed through chemical reaction.

APPLICATION AREAS

LOCTITE CR 3525 / LOCTITE CR 4200 is used as a casting material for water and food filters.

The product has got the KTW approval.

TECHNICAL DATA

Component A

Loctite CR 3525:

Consistency:	liquid
Density (20°C), g/cm ³	0.93 to 1.03
Viscosity, Brookfield - RVT, 20°C, mPa.s * Henkel method 10	1,000 to 1,600

Component B

Loctite CR 4200:

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

Mixture (Component A + B):

Consistency:	liquid
Viscosity, Brookfield - RVT, 25°C, mPa.s Henkel method 11	900 to 1,700
Pot life (180g, 25°C), min* Henkel method 20	20 to 26
Shore D hardness at 20 °C ISO 868	58 to 68
In service temperature, °C	-40 to 80

All technical data based on Henkel test method.
Data with * are specified.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use 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. Please also refer to the local safety instructions and contact Henkel for analytical support.

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:

Adhesive components 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 adhesive 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. Adhesive components should not come into contact with moisture during storage or application. Contact with moisture generates foaming of the adhesive and weakens the bondline. Therefore all packaging should be sealed properly and protected against humidity during storage.

Curing:

LOCTITE CR 3525 / 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 **Material Safety Data**

Sheets for details on:

Hazardous Information

Transport Regulations

Safety Regulations

Storage

Component A

Recommended Storage Temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	9 months

Component B

Recommended Storage Temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	9 months

ADDITIONAL INFORMATION

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.

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Reference 0.2