

LOCTITE CR 3700 / LOCTITE CR 4200

September 2019

PRODUCT DESCRIPTION

LOCTITE CR 3700 / LOCTITE CR 4200 provides the following product characteristics:

Technology	Polyurethane
Product Type	PU Adhesive
Cure	Polyaddition
Condition	Solvent-free
Components	2-component
Component A	Resin
Component B	Hardener
Application	Casting compound
Color (Comp. A)	Yellowish
Color (Comp. B)	Yellowish
Mixing Ratio, by volume Comp. A : Comp. B	2 : 1
Mixing Ratio, by weight Comp. A : Comp. B	100 : 61

LOCTITE CR 3700 / 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 weight ratio of 100 : 61 a hard elastic two-component structural adhesive 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 3700 / LOCTITE CR 4200 is used for the industrial production of filters.

TECHNICAL DATA

Component A:

Consistency	liquid
Density (20°C), g/cm ³	0.95 to 1.05
Viscosity, Brookfield - RVT, 20°C, mPas *	8,500 to 12,500
Henkel method 10	

Component B:

Consistency	liquid
Density (20°C), g/cm ³	1.17 to 1.27
Viscosity, Brookfield - RVT, 20°C, mPa.s *	2,800 to 3,800

Mixture (Component A + B):

Consistency	liquid
Viscosity at 25 °C, mPas	4,000 to 6,000
Pot life (180g, 25 °C) , min*	20 to 30
Shore A hardness	80 to 90

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

Certificates and Approvals

LOCTITE CR 3700/CR 4200 is certified to NSF 61.
A food contact statement with further details is available on request.

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. 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 3700 / LOCTITE CR 4200 can be cured between 15°C and elevated temperatures (up to 60 °C). The curing time will be reduced substantially with increasing temperatures.

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 0 to 40

Component B

Recommended storage temperature, °C 10 to 30

ADDITIONAL INFORMATION

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Reference 0.0

