



LOCTITE® HHD 3542™

January 2025

PRODUCT DESCRIPTION

LOCTITE® HHD 3542™ provides the following product characteristics:

Technology	Polyurethane Hot Melt
Chemical type	Reactive polyurethane
Appearance (uncured)	Light yellow to amber solid
Components	One component – requires no mixing
Viscosity	Medium
Cure	Moisture and Solidification
Application	Bonding

LOCTITE® HHD 3542™ is a reactive hotmelt adhesive based on polyurethane prepolymers. It is designed for robotic dispensing and has a relatively long open time. Immediately after solidifying in the bond line, the adhesive provides good initial strength. Then the secondary moisture cure cross-links the bonds for excellent elongation and structural durability. Fully cured product does not remelt.

TYPICAL PROPERTIES OF UNCURED MATERIAL

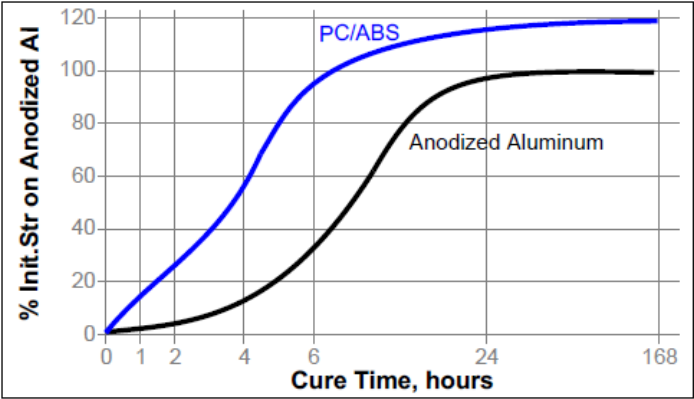
Specific gravity @ 25°C	1.1
Viscosity, Brookfield - Thermosel, 100°C, mPa.s (cP)	
Spindle 27	3,500 to 7,500
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Open time @ 25°C, 1 mm bead, minutes	< 4
Application temperature, °C	90 to 110

Cure speed vs. time

The graph below shows the cross bond tensile strength developed over time @ 22°C / 50% RH on the substrates noted.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical properties

Glass transition temperature, ISO 11359-2, °C	-39
Coefficient of thermal expansion, ISO 11359-2, K ⁻¹ :	
Pre Tg	130 x 10 ⁻⁶
Post Tg	340 x 10 ⁻⁶
Hardness, Shore ISO 868, Durometer D	30
Coefficient of thermal conductivity ASTM E 1530, W/(m.K)	0.21
Elongation at break, ISO 527-2, %	860
Tensile modulus, ISO 527-2, %	N/mm ² 91
	(psi) (13,225)
Tensile strength, ISO 527-2, %	N/mm ² > 8
	(psi) (>1,225)

Electrical properties

Dielectric constant, IEC 60250 @ 1,000 KHz	3.48
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TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 7 days @ 22°C

Lap shear strength, ISO 4587	
Aluminum (anodised)	N/mm ² 7.2
	(psi) (1,045)
PC/ABS	N/mm ² 4.8
	(psi) (695)



Cross bond performance is determined by stressing a bonded assembly with the application of force perpendicular to the bond area and to the major axis of the test specimen.

Cross bond tensile loading strength

Aluminum (anodised)	N/mm ² (psi)	4.8 (695)
PC/ABS	N/mm ² (psi)	5.8 (840)

TYPICAL ENVIRONMENTAL RESISTANCE

Cross bond tensile loading strength

Aluminum (anodised)		
After 7 days @ 85°C / 85% RH	N/mm ² (psi)	3.9 (570)
After thermal cycling*	N/mm ² (psi)	7.2 (1,040)
After heat shock**	N/mm ² (psi)	6.0 (865)

Chemical/solvent resistance

Aged under conditions indicated and tested @ 22°C.

Environment	°C	% of initial strength	
		500 h	1000 h
Air	87	150	150
Motor oil	87	115	110
Isopropanol	22	90	85
Water	22	115	150
Water/glycol	87	130	140

Cross bond tensile loading strength

PC/ABS		
After 7 days @ 85°C / 85% RH	N/mm ² (psi)	4.5 (800)
After thermal cycling*	N/mm ² (psi)	6.4 (935)
After heat shock**	N/mm ² (psi)	5.3 (775)

Chemical/solvent resistance

Aged under conditions indicated and tested @ 22°C.

Environment	°C	% of initial strength	
		300 h	500 h
Air	87	115	120
Motor oil	87	100	105
Isopropanol	22	60	60
Water	22	60	55
Water/glycol	87	60	55

*Thermal cycle resistance

27 cycles: 25°C / 95% RH to 65°C / 95%RH (1.5 hr ramp), dwell 4hours, 65°C / 95% RH to 30°C / 95% RH (1.5 hour ramp), dwell 1 hour

**Heat shock resistance

20 cycles: 1 hour 85°C then 1 hour at -40°C (ramp <3 min)

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

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.

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 the specifications of this product.

Directions for use

1. For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
2. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
3. After heating to recommended application temperature, apply an adequate amount of adhesive to one of the bond surfaces.
4. Join the substrates within the specified open time.
5. Keep parts from moving until adhesive is adequately set. For high strength, allow to cure at 22°C for 24 hours.

Storage:

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

Optimal Storage: 8 to 28°C. Storage below 8°C or above 28°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return 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 Henkel representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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