

# LOCTITE HHD 3573

December 2018

**PRODUCT DESCRIPTION**

LOCTITE HHD 3573 provides the following product characteristics:

<b>Technology</b>	Polyurethane Hot Melt
Appearance	Black Solid
Odor	Slight
Solids Content, %	100
Components	One part - requires no mixing
<b>Cure</b>	Solidification and Moisture
<b>Application</b>	Device assembly
Typical Assembly Applications	Light shielding, Sealing

LOCTITE HHD 3573 is a reactive, black polyurethane hotmelt adhesive formulated to cure with moisture. This material is pressure sensitive, providing instant high initial strength after joining the parts. It has good basic bonding performance and suitable open time for automatic or manual assembly line production.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, Brookfield - Thermosel, 110 °C, mPa·s (cP):  
Spindle 27 3,500  
Density @ 25°C, g/cm<sup>3</sup> 1.15  
Flash Point - See SDS

**TYPICAL CURING PERFORMANCE**

Open Time @ 25 °C, minutes 3 to 7  
Preheating Schedule 20 to 30 mins @ 100°C  
Application Temperature, °C 90 to 110

Open time is the bonding range of a 1 mm bead of molten adhesive on substrate. It is based on room temperature environment. Higher temperature will lengthen the open time while lower environmental temperatures will shorten the open time.

LOCTITE HHD 3573 cures exclusively by moisture and gains its final strength in 1-5 days. This material, however, exhibits high handling strength instantly after bonding.

Curing is a chemical reaction depending on the following parameters:

- Humidity in the rooms of application and storage
- Moisture content on the substrates
- Permeability of the substrates to be bonded
- Application volume / layer of the adhesive film

The above cure profile is a guideline recommendation. 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.

**GENERAL INFORMATION**

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

**Pretreatment:**

1. The bonding surfaces must be clean, dry and free of oil and grease.
2. Substrate temperature should not fall below 20°C during application.
3. Lower temperatures will lead to early solidification of the adhesive and to a reduced open time, the adhesive might even flake off.
4. The substrates may be preheated if necessary.

**Application:**

1. LOCTITE HHD 3573 can be applied from heating cartridge guns, from usual syringe type melting equipment.
2. At longer rest periods, melting and application temperatures should be decreased. Longer exposure to higher temperatures can lead to a viscosity increase.

**STORAGE:**

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

**Optimal Storage : 5 to 25 °C**

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

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

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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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