

LOCTITE HHD 5425

March 2018

PRODUCT DESCRIPTION

LOCTITE HHD 5425 provides the following product characteristics:

Technology	Acrylate
Appearance	Translucent light blue
Product Benefits	<ul style="list-style-type: none">• Rapid cure
Cure	Ultraviolet (UV) light or Moisture cure
Application	Device assembly, Structural adhesive

LOCTITE HHD 5425 dual cure adhesive is designed for use in the assembly of electronic components.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity by Rheometer, mPa·s (cP):

@ 5 s ⁻¹	9,000
@ 50 s ⁻¹	2,000
Shelf Life @ 5°C, days	180
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Recommended UV Cure**

Light Source and Condition

Metal halide doped spectrum UV lamp	
Lamp Power, W/in	300
Distance between lamp to substrate, inches	4
Irradiance UVA, EIT puck radiometer, mW/cm ²	566
Recommended Dose, seconds	5 to 25
Light Dose:	
@ 5 seconds, J/cm ²	2.8
@ 25 seconds, J/cm ²	14.1

Moisture cure occurs at ambient temperature and humidity.

Depth of Cure

Depth of Cure, inch	>0.25
Cures at least 0.25 inch under optimum conditions.	

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

TYPICAL PROPERTIES OF CURED MATERIAL**Physical Properties**

Hardness, Shore D, After initial UV dose of 6.4 J/cm², moisture cure condition of 100%RH @ room temperature:

Initial, after UV Cure	15
+ 1 day moisture cure	20
+ 2 days moisture cure	30
+ 3 days moisture cure	50
+ 4 days moisture cure	67
+ 8 days moisture cure	76

Hardness increases with additional moisture cure.

Hardness, Shore A, After 25 seconds UV Cure 68

GENERAL INFORMATION

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

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 specifications for this product.

STORAGE:

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

Optimal Storage : 2 to 8 °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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