

LOCTITE UK 8326 B30 / LOCTITE UK 5450

February 2021

PRODUCT DESCRIPTION

LOCTITE UK 8326 B30 / LOCTITE UK 5450 provides the following product characteristics:

Technology	Polyurethane
Product Type	Structural Adhesive
Cure	Polyaddition
Condition	Solvent-free
Components	Two-components
Component A	Resin
Component B	Hardener
Application	General Assembly
Appearance (Comp. A)	Beige
Appearance (Comp. B)	Brown
Mix Ratio by volume Comp A: Comp. B	4 : 1

LOCTITE UK 8326 B30 / LOCTITE UK 5450 is a solvent-free, two-component structural 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 volume ratio of 4 : 1, a hard elastic two-component structural adhesive is formed through chemical reaction. After curing the product does not show any measurable change in volume. Due to the use of natural raw materials (depending on cultivation areas), a variation in color between different batches is possible.

Application Areas:

LOCTITE UK 8326 B30 / LOCTITE UK 5450 is used for bonding pretreated metals, plastics, and hard foams.

The main application is the production and assembly of sandwich elements, e.g. for vehicles, containers and the construction industry.

TECHNICAL DATA

Component A

LOCTITE UK 8326 B30

Consistency	pasty
Density, g/cm ³	1.41 to 1.51

Component B

LOCTITE UK 5450

Consistency	pasty
Density, g/cm ³	1.21 to 1.26

Mixture (Component A + B)

Consistency	pasty
Viscosity, Brookfield - RVT, 20°C, mPa.s *	450,000 to 550,000
Henkel Method M-11	550,000
Pot life (240g, 20°C), min*	20 to 30
M-21	
Open Time(4g, 22°C, 50% RH), min*	45 to 60
Test M-98004301	
Curing time (23°C), days	5 to 7
Tensile shear strength, MPa *	>12
DIN EN ISO 1465 / M-40	
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.

Certificates and Approvals

Test certificates of Danish Institute of Fire and Security Technology, DK-2650, for low flammability in ship building according to IMO Resolution FTPC part 5, based on an applied quantity of 200g/m².

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:

LOCTITE UK 8326 B30 / LOCTITE UK 5450 is processed from a side-by-side cartridge using commercially available compressed-air guns. Since the material is thixotropic, it is advisable to use geared compressed-air guns. The two components are mixed with a static mixer, e.g. spiral mixers with no less than 24 mixing elements, 10 mm diameter. Striation must not be visible. The first and the last 10 cm of material mixed and dispensed with a static mixer need to be disposed of (do only use thoroughly mixed material, consider the color of the mixture). In case of manual mixing, the thixotropic formulation of resin/hardener involves high risk to the quality, such as the inclusion of air.

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 in contact with moisture during storage or application. Contact with moisture (water vapour) generates foaming of the adhesive and weakens the bondline. Therefore all packaging should be sealed properly and protected against humidity during storage.

Curing:

LOCTITE UK 8326 B30 / LOCTITE UK 5450 can be cured between 15°C and elevated temperatures (up to 60°C). The curing time will be reduced substantially with increasing temperatures. While curing there should be adequate contact pressure (load pile, presses, clamps) and fixtures to hold the joint in place.

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	15 to 30
Shelf-life (in unopened original packaging), months	12

Component B

Recommended storage temperature, °C	15 to 30
Shelf-life (in unopened original packaging), months	12

ADDITIONAL INFORMATION**Disclaimer**

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 1