

# LOCTITE UR 7398

April 2013

## PRODUCT DESCRIPTION

LOCTITE UR 7398 provides the following product characteristics:

<b>Technology</b>	Polyurethane
Product Type	PU Adhesive
Condition	Solvent-free
Components	One-component
<b>Application</b>	General assembly
Color	Brown

LOCTITE UR 7398 is an unfilled solvent-free, moisture curing one component adhesive based on polyurethane. At room temperature and the required humidity in the joint sufficient strength will be obtained after approximately 12 to 15 minutes.

For faster curing LOCTITE UR 7398 can be cured in a heated press. Maximum temperature must not exceed 70°C.

### Application Areas

LOCTITE UR 7398 is used for the manufacture of sandwich elements with porous substrates (e.g. wood) which contain humidity.

The substrates can be bonded to one another or to metals, laminated panels, various plastics, rigid foam made of polystyrene, polyurethane, PVC and others.

Main application area is the industrial / machinery manufacture of sandwich elements such as partition walls (thermal insulation, sound protection) having mineral fiber panels or mats bonded to primed sheet metal or compression moulding compounds and plaster boards.

## TECHNICAL DATA

### Loctite UR 7398:

Density, g/cm <sup>3</sup>	1.08 to 1.18
Consistency:	liquid
Viscosity, Brookfield - RVT, 20°C, mPa.s * Henkel method 10	3,000 to 6,000
Open Time, at 23°C, 50% rh, min	5 to 7
Initial strength (23°C), min	12 to 15
Initial strength (40°C), min	7.5 to 9.5
Final strength (23°C), days	5 to 7
Consumption, g/m <sup>2</sup>	120 to 150
Tensile shear strength, MPa*	>4
Application Temperature, °C	10 to 35
In service temperature, °C	-40 to 80
Short exposure (up to 1 h), °C	100

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.

### 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:

Application Temperature : 10 to 35 °C.

LOCTITE UR 7398 is applied to one-sided by spatula or doctor blade, but can also be applied by spraying. When bonding substrates without sufficient humidity or substrates which are not moisture permeable, the required amount of moisture has to be provided by other methods. A proven procedure is the combined spraying of the adhesive simultaneously with water in a fine mist.

In case of separate adhesive and water mist application the water must not be sprayed onto the bare metal but to the other substrate or even better to the adhesive. While curing the adhesive slightly foaming. Therefore it is absolutely necessary that there is adequate contact pressure during curing, preferably in a press.

Since LOCTITE UR 7398 cures by reaction with humidity open containers must always be properly sealed tight against moisture immediately after taking out the needed amount. For the same reason we recommend to use up opened containers as soon as possible.

### 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 **Material Safety Data Sheets** for details on:

**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

**Storage:**

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 6 months.

Recommended Storage: 15°C to 25°C. A constant storage temperature >35°C leads to irreversible gelification.  
LOCTITE UR 7398 is Frost-sensitive.

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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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