

PRODUCT DESCRIPTION

LOCTITE® Product 406 is a low viscosity, fast curing, single component cyanoacrylate adhesive. It is specifically formulated for difficult to bond substrates.

TYPICAL APPLICATIONS

Rapid bonding of a wide range of metal, plastic or elastomeric materials. Particularly suitable for bonding plastic or rubber (EPDM) parts where very fast fixturing is required.

PROPERTIES OF UNCURED MATERIAL

	Value	Typical Range
Chemical Type	Ethyl Cyanoacrylate	
Appearance	Clear liquid	
Specific Gravity @ 25°C	1.05	
Viscosity @ 25°C, mPa.s (cP)		
Brookfield LVF		
Spindle 1 @ 30 rpm	20	10 to 30
Flash Point (TCC), °C	>80	

TYPICAL CURING PERFORMANCE

Under normal conditions, the surface moisture initiates the hardening process. Although functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure speed vs. substrate

The rate of cure will depend on substrate used. The table below shows the fixture time achieved on different materials at 22°C, 50% relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm² (14.5 psi) tested on specimens according to ASTM D1002.

Substrate	Fixture Time, seconds
Steel (degreased)	10 to 20
Aluminium	2 to 10
Zinc dichromate	30 to 90
Neoprene	<5
Nitrile rubber	<5
ABS	2 to 10
PVC	2 to 10
Polycarbonate	15 to 50
Phenolic materials	5 to 15

Cure speed vs. bond gap

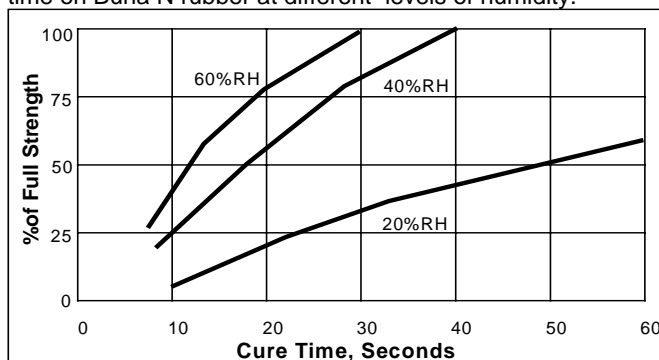
The rate of cure will depend on the bondline gap. High cure speed is favoured by thin bond lines. Increasing the bond gap will slow down the rate of cure.

Cure speed vs. activator

Where cure speed is unacceptably long due to large gaps or low relative humidity applying activator to the surface will improve cure speed. However, this can reduce the ultimate strength of the bond, therefore testing is recommended to confirm effect.

Cure speed vs. humidity

The rate of cure will depend on the ambient relative humidity. The graph below shows the tensile strength developed with time on Buna N rubber at different levels of humidity.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Coefficient of thermal expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1
Glass transition temperature, ASTM E228, °C	120

Electrical Properties

	Constant	Loss
Dielectric constant & loss, 25°C, ASTM D150, measured at		
100Hz	2.65	<0.02
1kHz	2.75	<0.02
10 kHz	2.75	<0.02
Volume resistivity, ASTM D257, Ω.cm		1 x 10 ¹⁶
Surface resistivity, ASTM D257, Ω		1 x 10 ¹⁶
Dielectric strength, ASTM D149, kV/mm		25

PERFORMANCE OF CURED MATERIAL

(After 24 hr at 22°C)

	Value	Typical Range
Shear Strength, ASTM D1002, DIN 53283		
Grit Blasted Steel, N/mm ²	22	18 to 26
(psi)	(3200)	(2600 to 3800)
Etched Aluminium, N/mm ²	15	11 to 19
(psi)	(2200)	(1600 to 2800)
Zinc dichromate, N/mm ²	10	6 to 14
(psi)	(1450)	(870 to 2000)
ABS, N/mm ²	5*	4 to 6
(psi)	(700)	(600 to 800)
PVC, N/mm ²	5*	4 to 6
(psi)	(700)	(600 to 800)
Polycarbonate, N/mm ²	4*	3.5 to 4.5
(psi)	(600)	(550 to 650)
Phenolic, N/mm ²	10	5 to 15
(psi)	(1450)	(730 to 2900)
Neoprene rubber, N/mm ²	10	5 to 15
(psi)	(1450)	(730 to 2200)
Nitrile rubber, N/mm ²	10	5 to 15
(psi)	(1450)	(730 to 2200)

Tensile Strength, ASTM D2095, DIN 53282

Grit Blasted Steel, N/mm ²	18.5	12 to 25
(psi)	(2680)	(1740 to 3630)
Buna N rubber, N/mm ²	10	5 to 15
(psi)	(1450)	(730 to 2200)

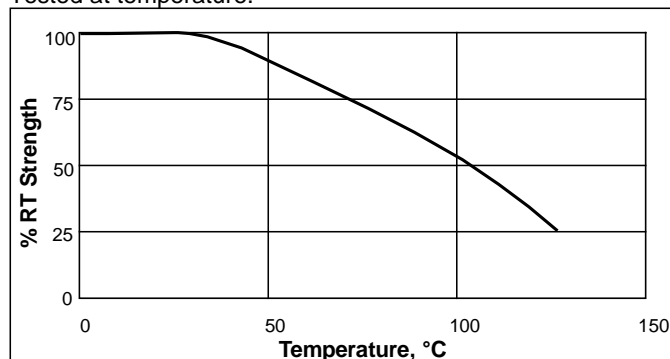
* Adhesive exceeds strength of bonded material

TYPICAL ENVIRONMENTAL RESISTANCE

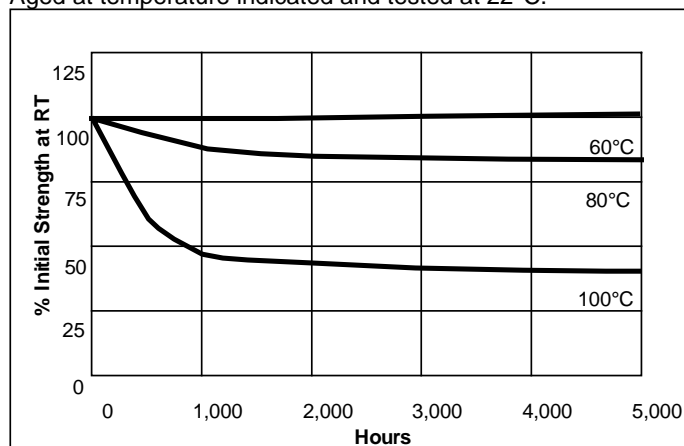
Test Procedure : Shear Strength ASTM D1002/DIN 53283
 Substrate: Grit blasted mild steel laps
 Cure procedure: 1 week at 22°C

Hot Strength

Tested at temperature.

**Heat Ageing**

Aged at temperature indicated and tested at 22°C.

**Chemical / Solvent Resistance**

Aged under conditions indicated and tested at 22°C.

Solvent	Temp.	%Initial strength retained at		
		100 hr	500 hr	1000 hr
Motor Oil	40°C	100	100	95
Leaded Petrol	22°C	100	100	100
Water/Glycol (50%/50%)	22°C	100	100	100
Ethanol	22°C	100	100	100
Isopropanol	22°C	100	100	100
Freon TA	22°C	100	100	100
Humidity 95% RH	40°C	80	75	65
Humidity 95% RH polycarbonate	40°C	100	100	100

GENERAL INFORMATION

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 oxidising materials.

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

Directions for use

For best performance surfaces should be clean and free of grease. This product performs best in thin bond gaps, (0.05mm). Excess adhesive can be dissolved with Loctite clean up solvents, nitromethane or acetone.

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 21°C (46°F to 70°F) unless otherwise labelled. Optimal storage conditions for unopened containers of cyanoacrylate products are achieved with refrigeration: 2°C to 8°C (36°F to 46°F). Refrigerated packages shall be allowed to return to room temperature prior to opening and use. To prevent contamination of unused product, do not return any material to its original container. For specific shelf life information contact your local Technical Service Centre.

Data Ranges

The data contained herein may be reported as a typical value and/or range (based on the mean value ± 2 standard deviations). Values are based on actual test data and are verified on a periodic basis.

Note

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, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite 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 licence under any Loctite 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.