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Technical Data Sheet

LOCTITE® 85H™

May 2005

PRODUCT DESCRIPTION

LOCTITE® 85H™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Methyl cyanoacrylate
Appearance (uncured)	Transparent to slightly hazy liquid
Components	One part - requires no mixing
Cure	Humidity
Application	Bonding
Key Substrates	Plastics, Elastomers and Metals

LOCTITE® 85H™ is a methyl cyanoacrylate for bonding metals to rubber as well as ceramic and ferrite materials. It is resistant to many solvents and chemicals, this adhesive features a low viscosity for easy handling and is suited for close fitting parts.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Cone & Plate, mPa·s (cP):	
Temperature: 22 °C, Shear Rate: 3,000 s^{-1}	8 to 30
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing process. Although full 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 the substrate used.

Fixture Time, ISO 4587, seconds:	
EPDM	≤15

TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 24 hours @ 22 °C

Physical Properties:	
Coefficient of Thermal Expansion, K^{-1}	227×10^{-6}
Softening Point, DIN EN 1427, °C	165
Refractive Index, nD20	1.49
Electrical Properties:	
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	12.9
Dielectric Constant , IEC 60250:	
1kC	5.4

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24 hours @ 22 °C

Tensile Strength, ISO 6922:		
Aluminum to Aluminum	N/mm^2 (psi)	26.8 (3,885)

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 oxidizing materials.

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

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 °C to 8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties.
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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm^2 x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note

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