Technical Data Sheet

LOCTITE® 407™

May 2009

PRODUCT DESCRIPTION

LOCTITE® 407™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to straw colored liquid[LMS]
Components	One part - requires no mixing
Viscosity	Low
Cure	Humidity
Application	Bonding
Key Substrates	Rubbers, Plastics and Metals

LOCTITE® 407™ is a general purpose adhesive suitable for applications where heat resistance is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.05
Viscosity, Cone & Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 3,000 s^{-1}	20 to 50[LMS]
Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):	
Spindle 1, speed 30 rpm,	25 to 55
Vapour Pressure, hPa	≤1
Flash Point - See SDS	

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. 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 .

Fixture Time, seconds:	
Mild Steel (degreased)	10 to 30
Aluminum (degreased)	5 to 15
Zinc dichromate	30 to 90
Neoprene	≤5
Rubber, nitrile	≤5
ABS	10 to 30
PVC	3 to 10
Polycarbonate	20 to 60
Phenolic	5 to 20

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Activator

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

TYPICAL PROPERTIES OF CURED MATERIAL

After 24 hours @ 22 °C

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}	100×10^{-6}
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Softening Point, DIN EN 1427, °C	165

Electrical Properties:

Dielectric Constant / Dissipation Factor, IEC 60250:	
0.1 kHz	2 to 3.3 / <0.02
1 kHz	2 to 3.5 / <0.02
10 kHz	2 to 3.5 / <0.02
Volume Resistivity, IEC 60093, Ω·cm	2×10^{15} to 10×10^{15}
Surface Resistivity, IEC 60093, Ω	10×10^{15} to 80×10^{15}
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	25

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm²	16 to 26
	(psi)	(2,320 to 3,770)
Aluminum	N/mm²	12 to 19
	(psi)	(1,740 to 2,755)
Zinc dichromate	N/mm²	6 to 13
	(psi)	(870 to 1,885)
ABS	N/mm²	6 to 20
	(psi)	(870 to 2,900)
PVC	N/mm²	6 to 20
	(psi)	(870 to 2,900)
Polycarbonate	N/mm²	5 to 20
	(psi)	(725 to 2,900)
Phenolic	N/mm²	5 to 15
	(psi)	(725 to 2,175)
Neoprene	N/mm²	5 to 15
	(psi)	(725 to 2,175)
Nitrile	N/mm²	5 to 15
	(psi)	(725 to 2,175)

Tensile Strength, ISO 6922:

Steel (grit blasted)	N/mm²	12 to 25
	(psi)	(1,740 to 3,625)
Buna-N	N/mm²	5 to 15
	(psi)	(725 to 2,175)

"T" Peel Strength, ISO 11339:

Steel (degreased)	N/mm	≤0.5
	(lb/in)	(≤2.8)

Cured for 24 hours @ 22 °C, followed by 48 hours @ 120 °C, tested @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm²	≥8.0[LMS]
	(psi)	(≥1,160)

Cured for 30 seconds @ 22 °C

Tensile Strength, ISO 6922:

Buna-N	N/mm²	≥4.0[LMS]
	(psi)	(≥580)

TYPICAL ENVIRONMENTAL RESISTANCE

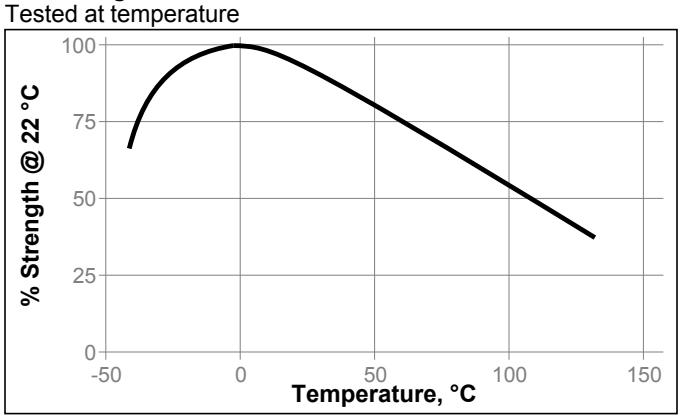
After 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Mild steel (grit blasted)

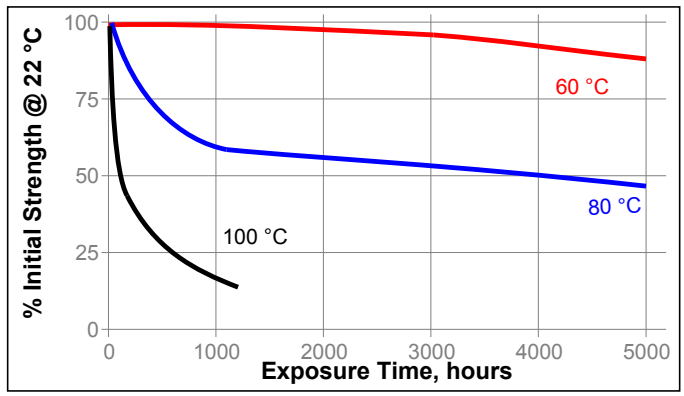
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

		% of initial strength		
Environment	**°C**	**100 h**	**500 h**	**1000 h**
Motor oil (MIL-L-46152)	40	100	100	100
Gasoline	22	100	100	100
Isopropanol	22	100	100	100
Ethanol	22	100	100	100
Freon TA	22	100	100	100
1,1,1 Trichloroethane	22	100	100	100
Heat/humidity 95% RH	40	100	100	95
Heat/humidity 95% RH on polycarbonate	40	100	100	95

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 Safety Data Sheet (SDS).

Directions for use:

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

Loctite Material Specification[LMS]

LMS dated December 02, 2005. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

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
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² 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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Reference 1.2