Technical Data Sheet

LOCTITE® 426

May 2004

PRODUCT DESCRIPTION

LOCTITE® 426 provides the following product characteristics:

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

LOCTITE® 426 is an adhesive gel toughened with elastomers for impact and peel strength along with improved resistance to heat and humidity.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield - HBT, 25 °C, mPa·s (cP):
Spindle 3, speed 20 rpm, 7,000 to 14,000[LMS]
Flash Point - See SDS

TYPICAL CURING PERFORMANCE

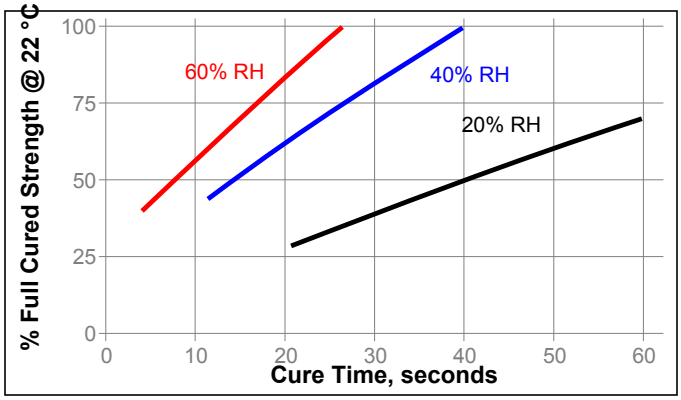
Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure Speed vs. Substrate & Bond Gap

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

Cure Speed vs. Humidity

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



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 PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 48 hours @ 22 °C
Lap Shear Strength, ISO 4587:
Steel (grit blasted) N/mm² ≥16.5[LMS]
(psi) (≥2,395)

Cured for 24 hours @ 22 °C, followed by 24 hours @ 121 °C, tested @ 121 °C
Lap Shear Strength, ISO 4587:
Steel (grit blasted) N/mm² ≥4.8[LMS]
(psi) (≥695)

Cured for 24 hours @ 22 °C, followed by 24 hours @ 121 °C, tested @ 22 °C
Lap Shear Strength, ISO 4587:
Steel (grit blasted) N/mm² ≥20.7[LMS]
(psi) (≥3,000)

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 September 01, 1995. 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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