Technical Data Sheet

LOCTITE® AA H4800™

Known as Loctite H4800
January 2018

PRODUCT DESCRIPTION

LOCTITE® AA H4800™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Methacrylate
Appearance, Resin (Component A)	Milky white
Appearance, Hardener (Component B)	Yellow
Appearance (Mixture)	Light yellow[LMS]
Components	Two components - requires mixing
Mix Ratio, by weight - Part A: Part B	9.7 : 1
Mix Ratio, by volume - Part A: Part B	10 : 1
Thixotropic	Reduced migration of liquid product after application to substrate
Key Substrates	PVC, Polycarbonate, Acrylic, Aluminum, Epoxy-coated metal, ABS , Stainless Steel and FRP
Cure	Room temperature cure
Application	Bonding
Specific Benefit	• Excellent environmental resistance • Excellent tolerance to off-ratio mixing • Superior impact and peel strength • Non-sagging gaps filled to 25.4 mm

LOCTITE® AA H4800™ is a methacrylate adhesive system that forms resilient bonds and maintains its strength over a wide range of temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A:

Specific Gravity @ 25 °C	1.03
Flash Point - See SDS	
Viscosity, Brookfield - HBD, 25 °C, mPa·s (cP):	
Spindle 5, speed 20 rpm	30,000 to 70,000
Viscosity, Cone & Plate, 25 °C, mPa·s (cP):	
Cone CP50-1 @ shear rate 50 s^{-1}	11,400

Part B:

Specific Gravity @ 25 °C	0.95
Flash Point - See SDS	
Viscosity, Brookfield - HBD, 25 °C, mPa·s (cP):	
Spindle 4, speed 20 rpm	30,000 to 70,000
Viscosity, Cone & Plate, 25 °C, mPa·s (cP):	
Cone CP50-1 @ shear rate 50 s^{-1}	10,860

Mixed:

Specific Gravity @ 25 °C	1.02
Flash Point - See SDS	
Working Time @ 25 °C, minutes (maximum time before assembly):	
Polyethylene	30
Steel	30
Aluminum	30

TYPICAL CURING PERFORMANCE

Fixture Time

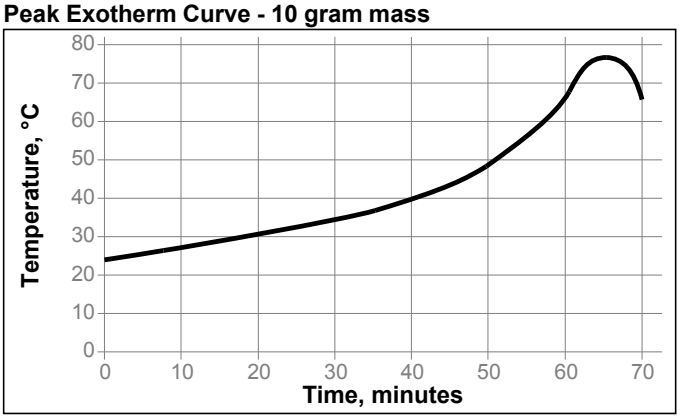
Fixture time is defined as the time to develop a shear strength of 0.1 N/mm² .

Fixture Time @ 22°C, (mixed), minutes	35 to 40

Open Time

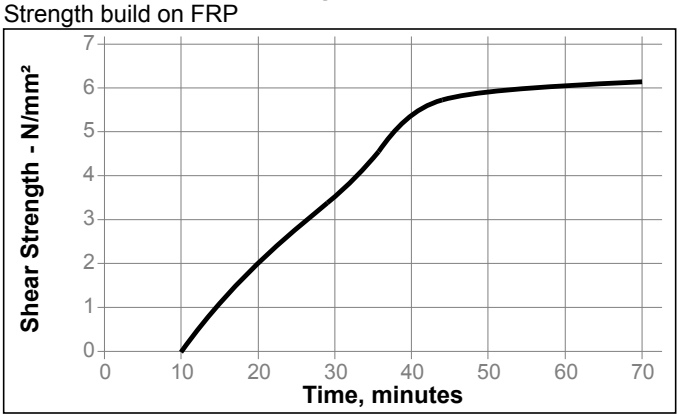
Open Time @ 22°C, minutes	20 to 25

Peak Exotherm Curve - 10 gram mass



Development of Bond Strength

Strength build on FRP



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Elongation, ISO 527-2, %		25 to 35
Shore Hardness, ISO 868, Durometer D		75 to 80
Tensile Strength, ISO 527-2	N/mm²	23.4 to 25
	(psi)	(3,400 to 3,600)

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24 hours @ 22 °C.

Lap Shear Strength, ISO 4587:

Aluminum (etched)	N/mm²	≥20.69[LMS]
	(psi)	(≥3,000)

Cured for 72 hours @ 22 °C.

Impact Strength, ISO 9653, J:

Grit Blasted Mild Steel (GBMS)	27
Aluminum (abraded)	10
Grit Blasted Mild Steel (GBMS) @ -40 °C	10

"T" Peel Strength, ISO 11339:

Steel	N/mm	14.5
	(lb/in)	(83)
Aluminum	N/mm	6.5
	(lb/in)	(37)

Block Shear Strength, ISO 13445:

Ferrite Magnet to Steel	N/mm²	20
	(psi)	(2,920)
Phenolic	N/mm²	3.7
	(psi)	(530)
Glass	N/mm²	7.2
	(psi)	(1,050)
Acrylic	N/mm²	3.4
	(psi)	(490)
Epoxy	N/mm²	2.4
	(psi)	(350)
ABS	N/mm²	2.6
	(psi)	(385)
PVC	N/mm²	1.0
	(psi)	(145)
Polycarbonate	N/mm²	3.3
	(psi)	(480)

Lap Shear Strength, ISO 4587:

Grit Blasted Mild Steel (GBMS)	N/mm²	16
	(psi)	(2,370)
Aluminum	N/mm²	24
	(psi)	(3,450)
Stainless Steel	N/mm²	18
	(psi)	(2,570)
Galvanized Steel	N/mm²	7
	(psi)	(1,010)
FRP	N/mm²	8.5
	(psi)	(1,230)
Gelcoat	N/mm²	3.3
	(psi)	(480)

TYPICAL ENVIRONMENTAL RESISTANCE

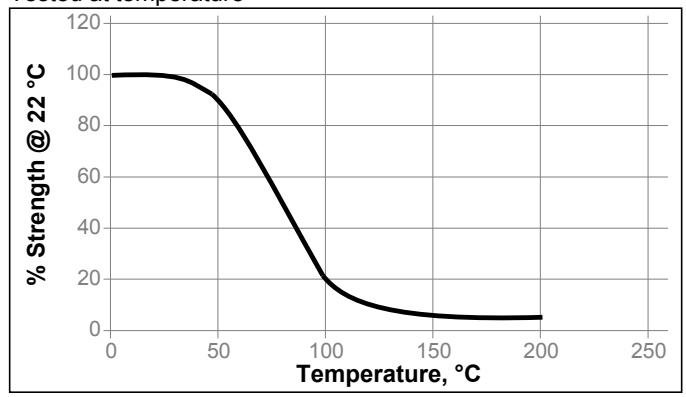
Cured for 72 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Grit Blasted Mild Steel (GBMS)

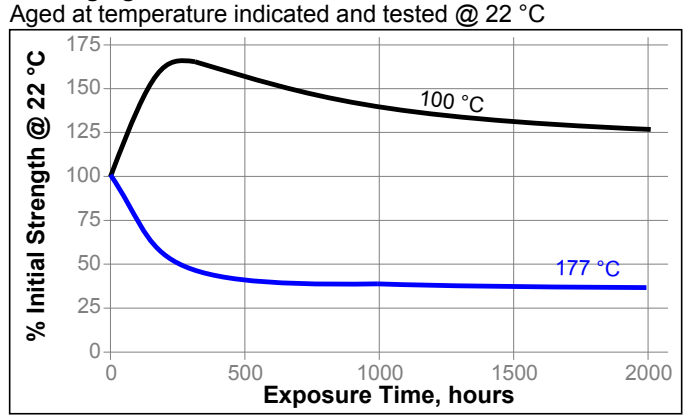
Hot Strength

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**	**500 h**	**1000 h**
Air	87	160	105
Water	22	100	100
95% RH	40	100	100
Salt fog	35	95	80
Condensing Humidity	49	80	80

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 high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
2. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
3. **Dual Cartridges:** To begin using a new cartridge, remove cartridge cap and dispense a small amount of adhesive, making sure both parts A&B are extruding. Attach nozzle and dispense approximately 25 to 50mm, before applying onto part to be bonded. Partially used cartridges can be stored with the mixing nozzle attached. To reuse, remove and discard old nozzle, attach the new nozzle, dispense approximately 25 to 50mm, before applying onto part to be bonded.
   Bulk Containers: Normally material is dispensed through volumetric metered mixing equipment, attached to static mix nozzles.
4. For maximum bond strength apply adhesive evenly to both surfaces to be joined.
5. Application to the substrates should be made as soon as possible. Larger quantities and/or higher temperatures will reduce the working time.
6. Join the adhesive coated surfaces and allow to cure. Higher temperatures will speed up curing.
7. Keep assembled parts from moving during cure. The bond should be allowed to develop full strength before subjecting to any service load.
8. Excessive uncured adhesive can be cleaned up with ketone type solvents.

Loctite Material Specification[LMS]

LMS dated September 26, 2007. 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

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

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 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 Representive.

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:
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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