



## Safety Data Sheet according to Regulation (EC) No 1907/2006

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LOCTITE 649

SDS No. : 173111  
V003.1

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Replaces version from: 27.07.2015

### SECTION 1: Identification of the substance/mixture and of the company/undertaking

#### 1.1. Product identifier

LOCTITE 649

#### Contains:

2,2'-Ethylenedioxydiethyl dimethacrylate

Hydroxypropyl methacrylate

Cumene hydroperoxide

#### 1.2. Relevant identified uses of the substance or mixture and uses advised against

Intended use:

Anaerobic

#### 1.3. Details of the supplier of the safety data sheet

Henkel Ltd

Wood Lane End

HP2 4RQ Hemel Hempstead

Great Britain

Phone: +44 1442 278000

Fax-no.: +44 1442 278071

ua-productsafety.uk@henkel.com

#### 1.4. Emergency telephone number

24 Hours Emergency Tel: +44 (0)1442 278497

### SECTION 2: Hazards identification

#### 2.1. Classification of the substance or mixture

##### Classification (CLP):

Serious eye irritation

Category 2

H319 Causes serious eye irritation.

Skin sensitizer

Category 1

H317 May cause an allergic skin reaction.

Specific target organ toxicity - single exposure

Category 3

H335 May cause respiratory irritation.

Target organ: respiratory tract irritation

#### 2.2. Label elements

##### Label elements (CLP):

**Hazard pictogram:****Signal word:**

Warning

**Hazard statement:**

H317 May cause an allergic skin reaction.  
 H319 Causes serious eye irritation.  
 H335 May cause respiratory irritation.

**Precautionary statement:**

\*\*\*\*\* \*\*For consumer use only: P101 If medical advice is needed, have product container or label at hand. P102 Keep out of reach of children. P501 Dispose of waste and residues in accordance with local authority requirements\*\*\*

**Precautionary statement:  
Prevention**

P261 Avoid breathing vapours.  
 P280 Wear protective gloves.

**Precautionary statement:  
Response**

P333+P313 If skin irritation or rash occurs: Get medical advice/attention.  
 P337+P313 If eye irritation persists: Get medical advice/attention.

**2.3. Other hazards**

None if used properly.

Not fulfilling Persistent, Bioaccumulative and Toxic (PBT), very Persistent and very Bioaccumulative (vPvB) criteria.

**SECTION 3: Composition/information on ingredients****3.2. Mixtures****General chemical description:**

Anaerobic Sealant

**Declaration of the ingredients according to CLP (EC) No 1272/2008:**

Hazardous components CAS-No.	EC Number REACH-Reg No.	content	Classification
2,2'-Ethylendioxydiethyl dimethacrylate 109-16-0	203-652-6 01-2119969287-21	25- 50 %	Skin Sens. 1B H317
Hydroxypropyl methacrylate 27813-02-1	248-666-3 01-2119490226-37	5- < 10 %	Skin Sens. 1 H317 Eye Irrit. 2 H319
Cumene hydroperoxide 80-15-9	201-254-7	1- < 2,5 %	Acute Tox. 4; Dermal H312 STOT RE 2 H373 Acute Tox. 4; Oral H302 Org. Perox. E H242 Acute Tox. 3; Inhalation H331 Aquatic Chronic 2 H411 Skin Corr. 1B H314

For full text of the H - statements and other abbreviations see section 16 "Other information".

Substances without classification may have community workplace exposure limits available.

## SECTION 4: First aid measures

### 4.1. Description of first aid measures

**Inhalation:**

Move to fresh air. If symptoms persist, seek medical advice.

**Skin contact:**

Rinse with running water and soap.

Seek medical advice.

**Eye contact:**

Rinse immediately with plenty of running water (for 10 minutes). Seek medical attention if necessary.

**Ingestion:**

Rinse out mouth, drink 1-2 glasses of water, do not induce vomiting.

Seek medical advice.

### 4.2. Most important symptoms and effects, both acute and delayed

**EYE:** Irritation, conjunctivitis.

**RESPIRATORY:** Irritation, coughing, shortness of breath, chest tightness.

**SKIN:** Rash, Urticaria.

Prolonged or repeated contact may cause skin irritation.

### 4.3. Indication of any immediate medical attention and special treatment needed

See section: Description of first aid measures

## SECTION 5: Firefighting measures

### 5.1. Extinguishing media

**Suitable extinguishing media:**

Foam, extinguishing powder, carbon dioxide.

**Extinguishing media which must not be used for safety reasons:**

High pressure waterjet

### 5.2. Special hazards arising from the substance or mixture

In the event of a fire, carbon monoxide (CO), carbon dioxide (CO<sub>2</sub>) and nitrogen oxides (NO<sub>x</sub>) can be released.

### 5.3. Advice for firefighters

Wear self-contained breathing apparatus and full protective clothing, such as turn-out gear.

**Additional information:**

In case of fire, keep containers cool with water spray.

## SECTION 6: Accidental release measures

### 6.1. Personal precautions, protective equipment and emergency procedures

Avoid contact with skin and eyes.

Ensure adequate ventilation.

Wear protective equipment.

### 6.2. Environmental precautions

Do not empty into drains / surface water / ground water.

### 6.3. Methods and material for containment and cleaning up

For small spills wipe up with paper towel and place in container for disposal.

For large spills absorb onto inert absorbent material and place in sealed container for disposal.

### 6.4. Reference to other sections

See advice in section 8

## SECTION 7: Handling and storage

### 7.1. Precautions for safe handling

Use only in well-ventilated areas.  
Avoid skin and eye contact.  
Prolonged or repeated skin contact should be avoided  
See advice in section 8

#### Hygiene measures:

Wash hands before work breaks and after finishing work.  
Do not eat, drink or smoke while working.  
Good industrial hygiene practices should be observed.

### 7.2. Conditions for safe storage, including any incompatibilities

Refer to Technical Data Sheet

### 7.3. Specific end use(s)

Anaerobic

## SECTION 8: Exposure controls/personal protection

### 8.1. Control parameters

#### Occupational Exposure Limits

Valid for  
Great Britain

None

#### Occupational Exposure Limits

Valid for  
Ireland

None

**Predicted No-Effect Concentration (PNEC):**

Name on list	Environmental Compartment	Exposure period	Value				Remarks
			mg/l	ppm	mg/kg	others	
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	aqua (freshwater)		0,164 mg/l				
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	aqua (marine water)		0,0164 mg/l				
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	sewage treatment plant (STP)		10 mg/l				
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	aqua (intermittent releases)		0,164 mg/l				
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	sediment (freshwater)				1,85 mg/kg		
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	sediment (marine water)				0,185 mg/kg		
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	soil				0,274 mg/kg		
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	Air						
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	Predator						
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	aqua (freshwater)		0,904 mg/l				
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	aqua (marine water)		0,904 mg/l				
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	sewage treatment plant (STP)		10 mg/l				
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	aqua (intermittent releases)		0,972 mg/l				
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	sediment (freshwater)				6,28 mg/kg		
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	sediment (marine water)				6,28 mg/kg		
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	soil				0,727 mg/kg		
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	aqua (freshwater)		0,0031 mg/l				
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	aqua (marine water)		0,00031 mg/l				
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	aqua (intermittent releases)		0,031 mg/l				
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	Sewage treatment plant		0,35 mg/l				
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	sediment (freshwater)				0,023 mg/kg		
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	sediment (marine water)				0,0023 mg/kg		
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	soil				0,0029 mg/kg		

**Derived No-Effect Level (DNEL):**

Name on list	Application Area	Route of Exposure	Health Effect	Exposure Time	Value	Remarks
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	Workers	inhalation	Long term exposure - systemic effects		48,5 mg/m <sup>3</sup>	
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	Workers	dermal	Long term exposure - systemic effects		13,9 mg/kg	
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	General population	inhalation	Long term exposure - systemic effects		14,5 mg/m <sup>3</sup>	
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	General population	dermal	Long term exposure - systemic effects		8,33 mg/kg	
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	General population	oral	Long term exposure - systemic effects		8,33 mg/kg	
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	Workers	dermal	Long term exposure - systemic effects		4,2 mg/kg	
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	Workers	Inhalation	Long term exposure - systemic effects		14,7 mg/m <sup>3</sup>	
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	General population	dermal	Long term exposure - systemic effects		2,5 mg/kg	
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	General population	Inhalation	Long term exposure - systemic effects		8,8 mg/m <sup>3</sup>	
Methacrylic acid, monoester with propane-1,2-diol 27813-02-1	General population	oral	Long term exposure - systemic effects		2,5 mg/kg	
.alpha.,.alpha.-Dimethylbenzyl hydroperoxide 80-15-9	Workers	inhalation	Long term exposure - systemic effects		6 mg/m <sup>3</sup>	

**Biological Exposure Indices:**

None

**8.2. Exposure controls:**

## Engineering controls:

Ensure good ventilation/extraction.

## Respiratory protection:

Use only in well-ventilated areas.

An approved mask or respirator fitted with an organic vapour cartridge should be worn if the product is used in a poorly ventilated area

Filter type: A (EN 14387)

## Hand protection:

Chemical-resistant protective gloves (EN 374).

Suitable materials for short-term contact or splashes (recommended: at least protection index 2, corresponding to &gt; 30 minutes permeation time as per EN 374):

nitrile rubber (NBR;  $\geq$  0.4 mm thickness)

Suitable materials for longer, direct contact (recommended: protection index 6, corresponding to &gt; 480 minutes permeation time as per EN 374):

nitrile rubber (NBR;  $\geq$  0.4 mm thickness)

This information is based on literature references and on information provided by glove manufacturers, or is derived by analogy with similar substances. Please note that in practice the working life of chemical-resistant protective gloves may be considerably shorter than the permeation time determined in accordance with EN 374 as a result of the many influencing factors (e.g. temperature). If signs of wear and tear are noticed then the gloves should be replaced.

Eye protection:  
Wear protective glasses.  
Protective eye equipment should conform to EN166.

Skin protection:  
Wear suitable protective clothing.  
Protective clothing should conform to EN 14605 for liquid splashes or to EN 13982 for dusts.

Advices to personal protection equipment:

The information provided on personal protective equipment is for guidance purposes only. A full risk assessment should be conducted prior to using this product to determine the appropriate personal protective equipment to suit local conditions. Personal protective equipment should conform to the relevant EN standard.

## SECTION 9: Physical and chemical properties

### 9.1. Information on basic physical and chemical properties

Appearance	liquid liquid green
Odor	characteristic
Odour threshold	No data available / Not applicable
pH	No data available / Not applicable
Melting point	No data available / Not applicable
Solidification temperature	No data available / Not applicable
Initial boiling point	No data available / Not applicable
Flash point	> 100 °C (> 212 °F)
Evaporation rate	No data available / Not applicable
Flammability	No data available / Not applicable
Explosive limits	No data available / Not applicable
Vapour pressure	No data available / Not applicable
Relative vapour density:	No data available / Not applicable
Density ( )	1,12 g/cm <sup>3</sup>
Bulk density	No data available / Not applicable
Solubility	No data available / Not applicable
Solubility (qualitative) (Solvent: Water)	Not miscible
Solubility (qualitative) (Solvent: Acetone)	Miscible
Partition coefficient: n-octanol/water	No data available / Not applicable
Auto-ignition temperature	No data available / Not applicable
Decomposition temperature	No data available / Not applicable
Viscosity	No data available / Not applicable
Viscosity (kinematic)	No data available / Not applicable
Explosive properties	No data available / Not applicable
Oxidising properties	No data available / Not applicable

### 9.2. Other information

No data available / Not applicable

## SECTION 10: Stability and reactivity

### 10.1. Reactivity

Reacts with strong oxidants.

### 10.2. Chemical stability

Stable under recommended storage conditions.

### 10.3. Possibility of hazardous reactions

See section reactivity

**10.4. Conditions to avoid**

Stable

**10.5. Incompatible materials**

See section reactivity.

**10.6. Hazardous decomposition products**

carbon oxides.

May produce fumes when heated to decomposition. Fumes may contain carbon monoxide and other toxic fumes.

**SECTION 11: Toxicological information****11.1. Information on toxicological effects****General toxicological information:**

The mixture is classified based on the available hazard information for the ingredients as defined in the classification criteria for mixtures for each hazard class or differentiation in Annex I to Regulation (EC) No 1272/2008. Relevant available health/ecological information for the substances listed under Section 3 is provided in the following.

**STOT-single exposure:**

May cause respiratory irritation.

**Oral toxicity:**

May cause irritation to the digestive tract.

**Skin irritation:**

Prolonged or repeated contact may cause skin irritation.

**Eye irritation:**

Causes serious eye irritation.

**Sensitizing:**

May cause an allergic skin reaction.

**Acute oral toxicity:**

Hazardous components CAS-No.	Value type	Value	Route of application	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	LD50	10.837 mg/kg	oral		rat	not specified
Hydroxypropyl methacrylate 27813-02-1	LD50	> 2.000 mg/kg	oral		rat	OECD Guideline 401 (Acute Oral Toxicity)
Cumene hydroperoxide 80-15-9	LD50	550 mg/kg	oral		rat	not specified

**Acute dermal toxicity:**

Hazardous components CAS-No.	Value type	Value	Route of application	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	LD50	> 2.000 mg/kg	dermal		mouse	not specified
Hydroxypropyl methacrylate 27813-02-1	LD50	> 5.000 mg/kg	dermal		rabbit	not specified
Cumene hydroperoxide 80-15-9	LD50	1.200 - 1.520 mg/kg	dermal			not specified



**Skin corrosion/irritation:**

Hazardous components CAS-No.	Result	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	not irritating	24 h	rabbit	Draize Test
Hydroxypropyl methacrylate 27813-02-1	not irritating	24 h	rabbit	Draize Test
Cumene hydroperoxide 80-15-9	corrosive		rabbit	Draize Test

**Serious eye damage/irritation:**

Hazardous components CAS-No.	Result	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	not irritating		rabbit	OECD Guideline 405 (Acute Eye Irritation / Corrosion)

**Respiratory or skin sensitization:**

Hazardous components CAS-No.	Result	Test type	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	sensitising	Mouse local lymphnode assay (LLNA)	mouse	OECD Guideline 429 (Skin Sensitisation: Local Lymph Node Assay)

**Germ cell mutagenicity:**

Hazardous components CAS-No.	Result	Type of study / Route of administration	Metabolic activation / Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	negative	mammalian cell gene mutation assay	with and without		OECD Guideline 476 (In vitro Mammalian Cell Gene Mutation Test)
	negative	bacterial reverse mutation assay (e.g Ames test)	with and without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)
	negative	in vitro mammalian cell micronucleus test	with and without		OECD Guideline 487 (In vitro Mammalian Cell Micronucleus Test)
Hydroxypropyl methacrylate 27813-02-1	negative	bacterial reverse mutation assay (e.g Ames test)	with and without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)
	negative	mammalian cell gene mutation assay	with and without		OECD Guideline 476 (In vitro Mammalian Cell Gene Mutation Test)
Hydroxypropyl methacrylate 27813-02-1	negative	oral: gavage		rat	OECD Guideline 474 (Mammalian Erythrocyte Micronucleus Test)
Cumene hydroperoxide 80-15-9	positive	bacterial reverse mutation assay (e.g Ames test)	without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)
Cumene hydroperoxide 80-15-9	negative	dermal		mouse	not specified

**Carcinogenicity:**

Hazardous components CAS-No.	Result	Species	Sex	Exposure time Frequency of treatment	Route of application	Method
Hydroxypropyl methacrylate 27813-02-1		rat	male	2 years (102 weeks) 6 hours/day, 5 days/week	inhalation	OECD Guideline 451 (Carcinogenicity Studies)

**Reproductive toxicity:**

Hazardous substances CAS-No.	Result / Classification	Species	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	NOAEL P = 1.000 mg/kg NOAEL F1 = 1.000 mg/kg	oral: gavage		rat	OECD Guideline 422 (Combined Repeated Dose Toxicity Study with the Reproduction / Developmental Toxicity Screening Test)
Hydroxypropyl methacrylate 27813-02-1	NOAEL P = 400 mg/kg	two- generation study oral: gavage	until one day before sacrifice	rat	OECD Guideline 416 (Two- Generation Reproduction Toxicity Study)

**Repeated dose toxicity**

Hazardous components CAS-No.	Result	Route of application	Exposure time / Frequency of treatment	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	NOAEL=1.000 mg/kg	oral: gavage	daily	rat	OECD Guideline 422 (Combined Repeated Dose Toxicity Study with the Reproduction / Developmental Toxicity Screening Test)
Hydroxypropyl methacrylate 27813-02-1	NOAEL=300 mg/kg	oral: gavage		rat	OECD Guideline 422 (Combined Repeated Dose Toxicity Study with the Reproduction / Developmental Toxicity Screening Test)
Cumene hydroperoxide 80-15-9		inhalation: aerosol	6 h/d5 d/w	rat	not specified

**SECTION 12: Ecological information****General ecological information:**

The mixture is classified based on the available hazard information for the ingredients as defined in the classification criteria for mixtures for each hazard class or differentiation in Annex I to Regulation (EC) No 1272/2008. Relevant available health/ecological information for the substances listed under Section 3 is provided in the following.

**12.1. Toxicity****Ecotoxicity:**

Do not empty into drains / surface water / ground water.

Hazardous components CAS-No.	Value type	Value	Acute Toxicity Study	Exposure time	Species	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	LC50	16,4 mg/l	Fish	96 h	Danio rerio	OECD Guideline 203 (Fish, Acute Toxicity Test)
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	EC50	> 100 mg/l	Algae	72 h	Pseudokirchnerella subcapitata	OECD Guideline 201 (Alga, Growth Inhibition Test)
	NOEC	18,6 mg/l	Algae	72 h	Pseudokirchnerella subcapitata	OECD Guideline 201 (Alga, Growth Inhibition Test)
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	NOEC	32 mg/l	chronic Daphnia	21 d	Daphnia magna	OECD 211 (Daphnia magna, Reproduction Test)
Hydroxypropyl methacrylate 27813-02-1	LC50	493 mg/l	Fish	48 h	Leuciscus idus melanotus	DIN 38412-15
Hydroxypropyl methacrylate 27813-02-1	EC50	> 143 mg/l	Daphnia	48 h	Daphnia magna	OECD Guideline 202 (Daphnia sp. Acute Immobilisation Test)
Hydroxypropyl methacrylate 27813-02-1	EC50	> 97,2 mg/l	Algae	72 h	Pseudokirchnerella subcapitata	OECD Guideline 201 (Alga, Growth Inhibition Test)
	NOEC	> 97,2 mg/l	Algae	72 h	Pseudokirchnerella subcapitata	OECD Guideline 201 (Alga, Growth Inhibition Test)
Hydroxypropyl methacrylate 27813-02-1	EC10	1.140 mg/l	Bacteria	16 h		not specified
Hydroxypropyl methacrylate 27813-02-1	NOEC	45,2 mg/l	chronic Daphnia	21 d	Daphnia magna	OECD 211 (Daphnia magna, Reproduction Test)
Cumene hydroperoxide 80-15-9	LC50	3,9 mg/l	Fish	96 h	Oncorhynchus mykiss	OECD Guideline 203 (Fish, Acute Toxicity Test)
Cumene hydroperoxide 80-15-9	EC50	18 mg/l	Daphnia	48 h	Daphnia magna	OECD Guideline 202 (Daphnia sp. Acute Immobilisation Test)
Cumene hydroperoxide 80-15-9	ErC50	3,1 mg/l	Algae	72 h	Pseudokirchnerella subcapitata	OECD Guideline 201 (Alga, Growth Inhibition Test)
Cumene hydroperoxide 80-15-9	EC10	70 mg/l	Bacteria	30 min		not specified

## 12.2. Persistence and degradability

### Persistence and Biodegradability:

The product is not biodegradable.

Hazardous components CAS-No.	Result	Route of application	Degradability	Method
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	readily biodegradable	aerobic	85 %	OECD Guideline 301 B (Ready Biodegradability: CO2 Evolution Test)
Hydroxypropyl methacrylate 27813-02-1	readily biodegradable	aerobic	94,2 %	OECD Guideline 301 E (Ready biodegradability: Modified OECD Screening Test)
Cumene hydroperoxide 80-15-9		no data	0 %	OECD Guideline 301 B (Ready Biodegradability: CO2 Evolution Test)

## 12.3. Bioaccumulative potential / 12.4. Mobility in soil

### Mobility:

Cured adhesives are immobile.

### Bioaccumulative potential:

No data available for the product.

Hazardous components CAS-No.	LogPow	Bioconcentration factor (BCF)	Exposure time	Species	Temperature	Method
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2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	2,3					OECD Guideline 117 (Partition Coefficient (n-octanol / water), HPLC Method)
Hydroxypropyl methacrylate 27813-02-1	0,97				20 °C	not specified
Cumene hydroperoxide 80-15-9		9,1		calculation		OECD Guideline 305 (Bioconcentration: Flow-through Fish Test) not specified
Cumene hydroperoxide 80-15-9	2,16					

### 12.5. Results of PBT and vPvB assessment

Hazardous components CAS-No.	PBT/vPvB
2,2'-Ethylenedioxydiethyl dimethacrylate 109-16-0	Not fulfilling Persistent, Bioaccumulative and Toxic (PBT), very Persistent and very Bioaccumulative (vPvB) criteria.
Hydroxypropyl methacrylate 27813-02-1	Not fulfilling Persistent, Bioaccumulative and Toxic (PBT), very Persistent and very Bioaccumulative (vPvB) criteria.
Cumene hydroperoxide 80-15-9	Not fulfilling Persistent, Bioaccumulative and Toxic (PBT), very Persistent and very Bioaccumulative (vPvB) criteria.

### 12.6. Other adverse effects

No data available.

## SECTION 13: Disposal considerations

### 13.1. Waste treatment methods

Product disposal:

Dispose of in accordance with local and national regulations.

Collection and delivery to recycling enterprise or other registered elimination institution.

Disposal of uncleaned packages:

After use, tubes, cartons and bottles containing residual product should be disposed of as chemically contaminated waste in an authorised legal land fill site or incinerated.

Disposal must be made according to official regulations.

Waste code

08 04 09 waste adhesives and sealants containing organic solvents and other dangerous substances

The valid EWC waste code numbers are source-related. The manufacturer is therefore unable to specify EWC waste codes for the articles or products used in the various sectors. The EWC codes listed are intended as a recommendation for users. We will be happy to advise you.

#### SECTION 14: Transport information

- 14.1. UN number**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.2. UN proper shipping name**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.3. Transport hazard class(es)**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.4. Packing group**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.5. Environmental hazards**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.6. Special precautions for user**  
Not hazardous according to RID, ADR, ADN, IMDG, IATA-DGR.
- 14.7. Transport in bulk according to Annex II of Marpol and the IBC Code**  
not applicable

#### SECTION 15: Regulatory information

**15.1. Safety, health and environmental regulations/legislation specific for the substance or mixture**

VOC content < 3 %  
(2010/75/EC)

**15.2. Chemical safety assessment**

A chemical safety assessment has not been carried out.

## SECTION 16: Other information

The labelling of the product is indicated in Section 2. The full text of all abbreviations indicated by codes in this safety data sheet are as follows:

H242 Heating may cause a fire.

H302 Harmful if swallowed.

H312 Harmful in contact with skin.

H314 Causes severe skin burns and eye damage.

H317 May cause an allergic skin reaction.

H319 Causes serious eye irritation.

H331 Toxic if inhaled.

H373 May cause damage to organs through prolonged or repeated exposure.

H411 Toxic to aquatic life with long lasting effects.

### **Further information:**

This information is based on our current level of knowledge and relates to the product in the state in which it is delivered. It is intended to describe our products from the point of view of safety requirements and is not intended to guarantee any particular properties.

**Relevant changes in this safety data sheet are indicated by vertical lines at the left margin in the body of this document. Corresponding text is displayed in a different color on shadowed fields.**

## LOCTITE® 649™

June 2006

### PRODUCT DESCRIPTION

LOCTITE® 649™ provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Urethane methacrylate
<b>Appearance (uncured)</b>	Green liquid <sup>LMS</sup>
<b>Fluorescence</b>	Positive under UV light <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	Low
<b>Cure</b>	Anaerobic
<b>Secondary Cure</b>	Activator
<b>Application</b>	Retaining

LOCTITE® 649™ cures when confined in the absence of air between close fitting metal surfaces. Typical applications include bonding of cylindrical fitting parts, particularly where low viscosity is required.

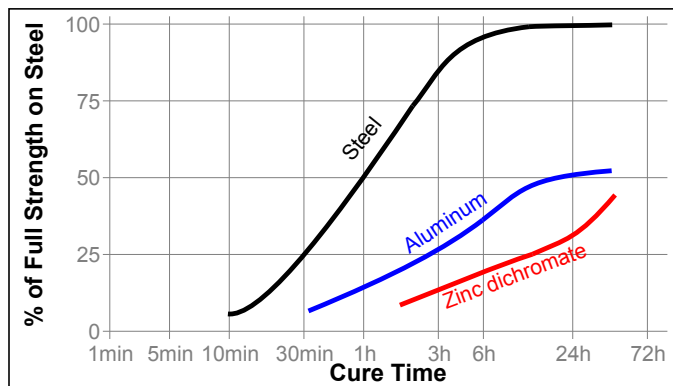
### TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.12
Vapor pressure, mbar	<3
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 2, speed 20 rpm,	550 to 950 <sup>LMS</sup>
Spindle 5, speed 20 rpm	400 to 600

### TYPICAL CURING PERFORMANCE

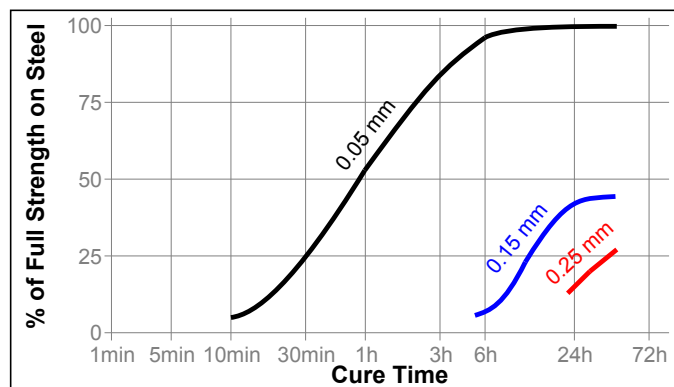
#### Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on steel pins and collars compared to different materials and tested according to ISO 10123.



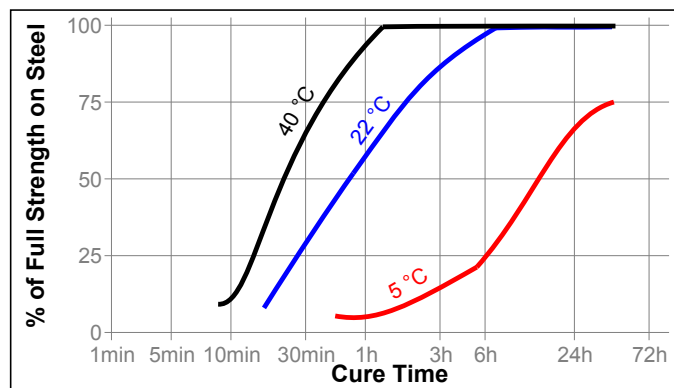
#### Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows shear strength developed with time on steel pins and collars at different controlled gaps and tested according to ISO 10123.



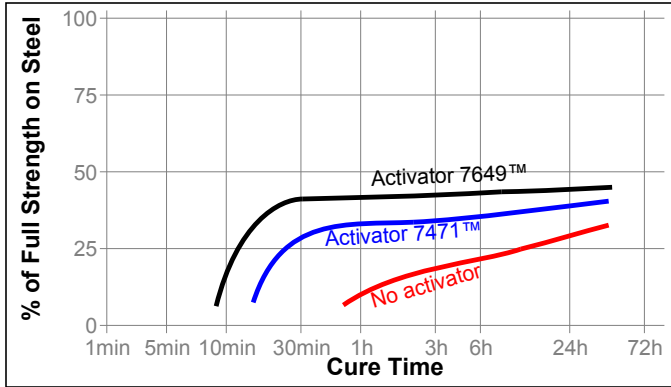
#### Cure Speed vs. Temperature

The rate of cure will depend on the temperature. The graph below shows the shear strength developed with time at different temperatures on steel pins and collars and tested according to ISO 10123.



#### Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the shear strength developed with time on zinc dichromate steel pins and collars using Activator 7471™ and 7649™ and tested according to ISO 10123.



**TYPICAL PROPERTIES OF CURED MATERIAL**

**Physical Properties:**

Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup>	100×10 <sup>-6</sup>
Coefficient of Thermal Conductivity ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

**TYPICAL PERFORMANCE OF CURED MATERIAL**

**Adhesive Properties**

Cured for 24 hours @ 22 °C

Breakaway Torque, ISO 10964	N·m	25 to 45
	(lb.in.)	(220 to 400)
Prevail Torque, ISO 10964	N·m	30 to 60
	(lb.in.)	(265 to 530)

Breakloose Torque, ISO 10964, Pre-torqued to 5 N·m	N·m	30 to 55
	(lb.in.)	(265 to 490)
Max. Prevail Torque, ISO 10964, Pre-torqued to 5 N·m	N·m	38 to 60
	(lb.in.)	(340 to 530)

Cured for 72 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm <sup>2</sup>	≥15 <sup>LMS</sup>
	(psi)	(≥2,175)

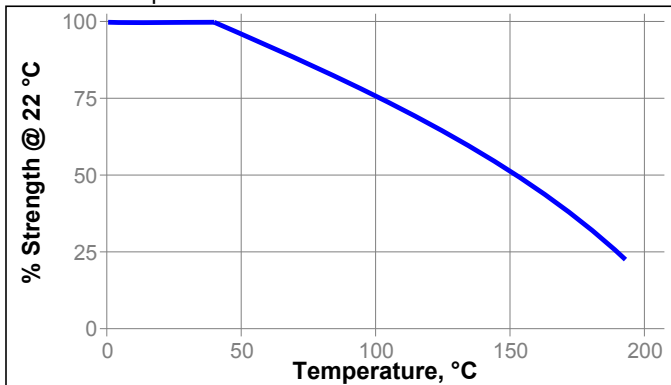
**TYPICAL ENVIRONMENTAL RESISTANCE**

Cured for 1 week @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	
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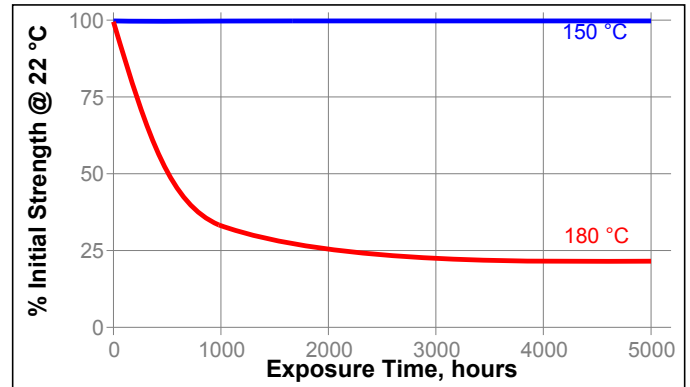
**Hot Strength**

Tested at temperature



**Heat Aging**

Aged at temperature indicated and tested @ 22 °C



**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	100	100	100
Unleaded gasoline	22	100	100	100
Brake fluid	22	85	85	80
Ethanol	22	85	85	80
Acetone	22	80	80	80
Water/glycol 50/50	87	100	85	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).**

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

**Directions for use:**

**For Assembly**

1. For best results, clean all surfaces (external and internal) with a LOCTITE® cleaning solvent and allow to dry.
2. If the material is an inactive metal or the cure speed is too slow, spray with Activator 7471™ or 7649™ and allow to dry.
3. **For Slip Fitted Assemblies**, apply adhesive around the leading edge of the pin and the inside of the collar and use a rotating motion during assembly to ensure good coverage.
4. **For Press Fitted Assemblies**, apply adhesive thoroughly to both bond surfaces and assemble at high press on rates.
5. **For Shrink Fitted Assemblies** the adhesive should be



coated onto the pin, the collar should then be heated to create sufficient clearance for free assembly.

- Parts should not be disturbed until sufficient handling strength is achieved.

#### For Disassembly

- Apply localized heat to the assembly to approximately 250 °C. Disassemble while hot.

#### For Cleanup

- Cured product can be removed with a combination of soaking in a Loctite solvent and mechanical abrasion such as a wire brush.

#### Loctite Material Specification<sup>LMS</sup>

LMS dated June 13, 2006. 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: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

#### 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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Reference 1.2