



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

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SDS No. : 434634
V001.9

LOCTITE 408

Revision: 26.05.2015

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Replaces version from: 26.02.2014

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

1.1. Product identifier

LOCTITE 408

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

Intended use:

Adhesive

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

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):

Chronic hazards to the aquatic environment

H412 Harmful to aquatic life with long lasting effects.

Category 3

2.2. Label elements

Label elements (CLP):

Hazard statement:

H412 Harmful to aquatic life with long lasting effects.

Supplemental information

EUH202 Cyanoacrylate. Danger. Bonds skin and eyes in seconds. Keep out of the reach of children.

Precautionary statement: Prevention

P273 Avoid release to the environment.

Precautionary statement: Disposal

P501 Dispose of waste and residues in accordance with local authority requirements.

2.3. Other hazards

None if used properly.

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

Cyanoacrylate Adhesive

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

Hazardous components CAS-No.	EC Number REACH-Reg No.	content	Classification
Bismaleimide 105391-33-1	424-600-0	> 0,25- < 2,5 %	Aquatic Acute 1 H400 Aquatic Chronic 1 H410
2-Methoxyethyl a-cyanoacrylate 27816-23-5	248-670-5 01-2120070891-53	> 80- < 100 %	No data available.
Hydroquinone 123-31-9	204-617-8 01-2119524016-51	> 0,01- < 0,1 %	Aquatic Acute 1 H400 Aquatic Chronic 1 H410 Carc. 2 H351 Muta. 2 H341 Acute Tox. 4; Oral H302 Eye Dam. 1 H318 Skin Sens. 1 H317 M factor: 10
Bis(2-hydroxy-3-tert-butyl-5-methylphenyl)methane 119-47-1	204-327-1 01-2119496065-33	> 0,1- < 0,9 %	Repr. 2 H361 Aquatic Chronic 4 H413

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, consult doctor if complaint persists.

Skin contact:

Do not pull bonded skin apart. It may be gently peeled apart using a blunt object such as a spoon, preferably after soaking in warm soapy water.

Cyanoacrylates give off heat on solidification. In rare cases a large drop will generate enough heat to cause a burn.

Burns should be treated normally after the adhesive has been removed from the skin.

If lips are accidentally stuck together apply warm water to the lips and encourage maximum wetting and pressure from saliva inside the mouth.

Peel or roll lips apart. Do not try to pull the lips apart with direct opposing action.

Eye contact:

If the eye is bonded closed, release eyelashes with warm water by covering with wet pad.

Cyanoacrylate will bond to eye protein and will cause periods of weeping which will help to debond the adhesive.

Keep eye covered until debonding is complete, usually within 1-3 days.

Do not force eye open. Medical advice should be sought in case solid particles of cyanoacrylate trapped behind the eyelid cause any abrasive damage.

Ingestion:

Ensure that breathing passages are not obstructed. The product will polymerise immediately in the mouth making it almost impossible to swallow. Saliva will slowly separate the solidified product from the mouth (several hours).

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

Prolonged or repeated contact may cause eye irritation.

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.

Fine water spray

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) and carbon dioxide (CO₂) can be released.

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

Oxides of carbon, oxides of nitrogen, irritating organic vapors.

5.3. Advice for firefighters

Fire fighters should wear positive pressure self-contained breathing apparatus (SCBA).

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

Ensure adequate ventilation.

Avoid skin and eye contact.

6.2. Environmental precautions

Do not let product enter drains.

6.3. Methods and material for containment and cleaning up

Do not use cloths for mopping up. Flood with water to complete polymerization and scrape off the floor. Cured material can be disposed of as non-hazardous waste.

6.4. Reference to other sections

See advice in section 8

SECTION 7: Handling and storage

7.1. Precautions for safe handling

Ventilation (low level) is recommended when using large volumes

Use of dispensing equipment is recommended to minimise the risk of skin or eye contact

Avoid skin and eye contact.

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

For optimum shelf life store in original containers under refrigerated conditions at 2 - 8°C (35.6 - 46.4 °F)

7.3. Specific end use(s)

Adhesive

SECTION 8: Exposure controls/personal protection**8.1. Control parameters****Occupational Exposure Limits**

Valid for

Great Britain

Ingredient [Regulated substance]	ppm	mg/m ³	Value type	Short term exposure limit category / Remarks	Regulatory list
Hydroquinone 123-31-9 [HYDROQUINONE]		0,5	Time Weighted Average (TWA):		EH40 WEL

Predicted No-Effect Concentration (PNEC):

Name on list	Environmental Compartment	Exposure period	Value				Remarks
			mg/l	ppm	mg/kg	others	
Hydroquinone 123-31-9	aqua (freshwater)					0,114 µg/L	
Hydroquinone 123-31-9	aqua (marine water)					0,0114 µg/L	
Hydroquinone 123-31-9	sediment (freshwater)					0,98 µg/kg	
Hydroquinone 123-31-9	sediment (marine water)					0,097 µg/kg	
Hydroquinone 123-31-9	aqua (intermittent releases)					0,00134 mg/L	
Hydroquinone 123-31-9	soil					0,129 µg/kg	
Hydroquinone 123-31-9	STP					0,71 mg/L	

Derived No-Effect Level (DNEL):

Name on list	Application Area	Route of Exposure	Health Effect	Exposure Time	Value	Remarks
Hydroquinone 123-31-9	Workers	Dermal	Long term exposure - systemic effects		128 mg/kg bw/day	
Hydroquinone 123-31-9	Workers	Inhalation	Long term exposure - systemic effects		7 mg/m ³	
Hydroquinone 123-31-9	Workers	Inhalation	Long term exposure - local effects		1 mg/m ³	
Hydroquinone 123-31-9	general population	Dermal	Long term exposure - systemic effects		64 mg/kg bw/day	
Hydroquinone 123-31-9	general population	Inhalation	Long term exposure - systemic effects		1,74 mg/m ³	
Hydroquinone 123-31-9	general population	Inhalation	Long term exposure - local effects		0,5 mg/m ³	

Biological Exposure Indices:

None

8.2. Exposure controls:

Respiratory protection:

Ensure adequate ventilation.

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

Hand protection:

The use of chemical resistant gloves such as Nitrile is recommended.

Polyethylene or polypropylene gloves are recommended when using large volumes.

Do not use PVC, rubber or nylon gloves.

Please note that in practice the working life of chemical resistant gloves may be considerably reduced as a result of many influencing factors (e.g. temperature). Suitable risk assessment should be carried out by the end user. If signs of wear and tear are noticed then the gloves should be replaced.

Eye protection:

Wear protective glasses.

Skin protection:

Suitable protective clothing

SECTION 9: Physical and chemical properties**9.1. Information on basic physical and chemical properties**

Appearance

liquid
colourless to
yellowish

Odor

odorless

Odour threshold

No data available / Not applicable

pH

No data available / Not applicable

Initial boiling point

149 °C (300.2 °F)

Flash point

> 80 °C (> 176 °F); Tagliabue closed cup

Decomposition temperature

No data available / Not applicable

Vapour pressure

< 0,3 mbar

Density

1,1 g/cm³

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Bulk density

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
Solubility (qualitative) (Solvent: Water)	Polymerises in presence of water.
Solidification temperature	No data available / Not applicable
Melting point	No data available / Not applicable
Flammability	No data available / Not applicable
Auto-ignition temperature	No data available / Not applicable
Explosive limits	No data available / Not applicable
Partition coefficient: n-octanol/water	No data available / Not applicable
Evaporation rate	No data available / Not applicable
Vapor density	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

Rapid exothermic polymerization will occur in the presence of water, amines, alkalis and alcohols.

10.2. Chemical stability

Stable under recommended storage conditions.

10.3. Possibility of hazardous reactions

See section reactivity

10.4. Conditions to avoid

Stable under normal conditions of storage and use.

10.5. Incompatible materials

None if used properly.

10.6. Hazardous decomposition products

carbon oxides.

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 1272/2008/EC. Relevant available health/ecological information for the substances listed under Section 3 is provided in the following.

Oral toxicity:

Cyanoacrylates are considered to have relatively low toxicity. Acute oral LD50 is >5000mg/kg (rat). It is almost impossible to swallow as it rapidly polymerises in the mouth.

Inhalative toxicity:

Prolonged exposure to high concentrations of vapours may lead to chronic effects in sensitive individuals
In dry atmosphere with < 50% humidity, vapours may irritate the eyes and respiratory system

Skin irritation:

Prolonged or repeated contact may cause skin irritation.
Bonds skin in seconds. Considered to be of low toxicity: acute dermal LD50 (rabbit)>2000mg/kg
Due to polymerisation at the skin surface allergic reaction is unlikely to occur

Eye irritation:

Prolonged or repeated contact may cause eye irritation.
Liquid product will bond eyelids. In a dry atmosphere (RH<50%) vapours may cause irritation and lachrymatory effect

Acute oral toxicity:

Hazardous components CAS-No.	Value type	Value	Route of application	Exposure time	Species	Method
Bismaleimide 105391-33-1	LD50	> 5.000 mg/kg	oral		rat	OECD Guideline 401 (Acute Oral Toxicity)
2-Methoxyethyl a- cyanoacrylate 27816-23-5	LD50	> 5.000 mg/kg	oral		rat	OECD Guideline 401 (Acute Oral Toxicity)
Hydroquinone 123-31-9	LD50	367 mg/kg	oral		rat	OECD Guideline 401 (Acute Oral Toxicity)
Bis(2-hydroxy-3-tert- butyl-5- methylphenyl)methane 119-47-1	LD50	> 10.000 mg/kg	oral		rat	

Acute inhalative toxicity:

Hazardous components CAS-No.	Value type	Value	Route of application	Exposure time	Species	Method
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Acute dermal toxicity:

Hazardous components CAS-No.	Value type	Value	Route of application	Exposure time	Species	Method
2-Methoxyethyl a- cyanoacrylate 27816-23-5	LD50	> 2.000 mg/kg	dermal		rabbit	OECD Guideline 402 (Acute Dermal Toxicity)

Skin corrosion/irritation:

Hazardous components CAS-No.	Result		Exposure time	Species	Method
Bismaleimide 105391-33-1	not irritating		4 h	rabbit	OECD Guideline 404 (Acute Dermal Irritation / Corrosion)
2-Methoxyethyl a- cyanoacrylate 27816-23-5	not irritating		4 h	rabbit	OECD Guideline 404 (Acute Dermal Irritation / Corrosion)

Serious eye damage/irritation:

Hazardous components CAS-No.	Result		Exposure time	Species	Method
Bismaleimide 105391-33-1	not irritating		24 h	rabbit	OECD Guideline 405 (Acute Eye Irritation / Corrosion)
2-Methoxyethyl a- cyanoacrylate 27816-23-5	not irritating		300 s		HET-CAM Test

Respiratory or skin sensitization:

Hazardous components CAS-No.	Result		Test type	Species	Method
Bismaleimide 105391-33-1	not sensitising		Guinea pig maximisation test	guinea pig	OECD Guideline 406 (Skin Sensitisation)
2-Methoxyethyl a- cyanoacrylate 27816-23-5	not sensitising		Guinea pig maximisation test	guinea pig	
Hydroquinone 123-31-9	sensitising		Guinea pig maximisation test	guinea pig	

Germ cell mutagenicity:

Hazardous components CAS-No.	Result	Type of study / Route of administration	Metabolic activation / Exposure time	Species	Method
Bismaleimide 105391-33-1	negative	bacterial gene mutation assay	with and without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)
2-Methoxyethyl a- cyanoacrylate 27816-23-5	negative	bacterial reverse mutation assay (e.g Ames test)	with and without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)
Hydroquinone 123-31-9	negative	bacterial reverse mutation assay (e.g Ames test)	with and without		EU Method B.13/14 (Mutagenicity)
Bis(2-hydroxy-3-tert- butyl-5- methylphenyl)methane 119-47-1	negative	bacterial reverse mutation assay (e.g Ames test)	with and without		OECD Guideline 471 (Bacterial Reverse Mutation Assay)

Reproductive toxicity:

Hazardous substances CAS-No.	Result / Classification	Species	Exposure time	Species	Method
Bis(2-hydroxy-3-tert- butyl-5- methylphenyl)methane 119-47-1	NOAEL P = 12,5 mg/kg	screening oral: gavage		rat	OECD Guideline 421 (Reproduction / Developmental Toxicity Screening Test)

Repeated dose toxicity

Hazardous components CAS-No.	Result	Route of application	Exposure time / Frequency of treatment	Species	Method
Hydroquinone 123-31-9	NOAEL= \geq 250 mg/kg	oral: gavage	14 days5 days/week. 12 doses	rat	OECD Guideline 407 (Repeated Dose 28-Day Oral Toxicity in Rodents)
Hydroquinone 123-31-9	LOAEL= \leq 500 mg/kg	oral: gavage	14 days5 days/week. 12 doses	rat	OECD Guideline 407 (Repeated Dose 28-Day Oral Toxicity in Rodents)

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

Biological and Chemical Oxygen Demands (BOD and COD) are insignificant.

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

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 1272/2008/EC. Relevant available health/ecological information for the substances listed under Section 3 is provided in the following.

12.1. Toxicity**Ecotoxicity:**

Harmful to aquatic life with long lasting effects.

Hazardous components CAS-No.	Value type	Value	Acute Toxicity Study	Exposure time	Species	Method
Bismaleimide 105391-33-1	LC50	0,5 mg/l	Fish	48 h	Oryzias latipes	OECD Guideline 203 (Fish, Acute Toxicity Test)
Hydroquinone 123-31-9	LC50	0,638 mg/l	Fish	96 h	Oncorhynchus mykiss	OECD Guideline 203 (Fish, Acute Toxicity Test)
Hydroquinone 123-31-9	EC50	0,134 mg/l	Daphnia	48 h	Daphnia magna	OECD Guideline 202 (Daphnia sp. Acute Immobilisation Test)
Hydroquinone 123-31-9	EC50	0,335 mg/l	Algae	72 h	Selenastrum capricornutum (new name: Pseudokirchnerella subcapitata)	OECD Guideline 201 (Alga, Growth Inhibition Test)
Hydroquinone 123-31-9	NOEC	0,0057 mg/l	chronic Daphnia	21 d	Daphnia magna	OECD 211 (Daphnia magna, Reproduction Test)

12.2. Persistence and degradability**Persistence and Biodegradability:**

No data available for the product.

Hazardous components CAS-No.	Result	Route of application	Degradability	Method
2-Methoxyethyl a- cyanoacrylate 27816-23-5	readily biodegradable	aerobic	86 %	OECD Guideline 301 F (Ready Biodegradability: Manometric Respirometry Test)
Hydroquinone 123-31-9	readily biodegradable	aerobic	75 - 81 %	EU Method C.4-E (Determination of the "Ready" Biodegradability Closed Bottle Test)
Bis(2-hydroxy-3-tert-butyl-5- methylphenyl)methane 119-47-1	under test conditions no biodegradation observ		0 %	OECD Guideline 301 F (Ready Biodegradability: Manometric Respirometry 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.	LogKow	Bioconcentration factor (BCF)	Exposure time	Species	Temperature	Method
Hydroquinone 123-31-9	0,59					EU Method A.8 (Partition Coefficient)
Bis(2-hydroxy-3-tert-butyl-5- methylphenyl)methane 119-47-1	6,24					

12.5. Results of PBT and vPvB assessment

Hazardous components CAS-No.	PBT/vPvB
Hydroquinone 123-31-9	Not fulfilling PBT (persistent/bioaccumulative/toxic) criteria
Bis(2-hydroxy-3-tert-butyl-5- methylphenyl)methane 119-47-1	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:

Cured adhesive: Dispose of as water insoluble non-toxic solid chemical in authorised landfill or incinerate under controlled conditions.

Dispose of in accordance with local and national regulations.

Contribution of this product to waste is very insignificant in comparison to article in which it is used

Disposal of uncleaned packages:

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**

ADR	Not dangerous goods
RID	Not dangerous goods
ADN	Not dangerous goods
IMDG	Not dangerous goods
IATA	3334

14.2. UN proper shipping name

ADR	Not dangerous goods
RID	Not dangerous goods
ADN	Not dangerous goods
IMDG	Not dangerous goods
IATA	Aviation regulated liquid, n.o.s. (Cyanoacrylate ester)

14.3. Transport hazard class(es)

ADR	Not dangerous goods
RID	Not dangerous goods
ADN	Not dangerous goods
IMDG	Not dangerous goods
IATA	9

14.4. Packaging group

ADR	Not dangerous goods
RID	Not dangerous goods
ADN	Not dangerous goods
IMDG	Not dangerous goods
IATA	III

14.5. Environmental hazards

ADR	not applicable
RID	not applicable
ADN	not applicable
IMDG	not applicable
IATA	not applicable

14.6. Special precautions for user

ADR	not applicable
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RID	not applicable
ADN	not applicable
IMDG	not applicable
IATA	Primary packs containing less than 500ml are unregulated by this mode of transport and may be shipped unrestricted.

14.7. Transport in bulk according to Annex II of MARPOL 73/78 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 %
(1999/13/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:

H302 Harmful if swallowed.
H317 May cause an allergic skin reaction.
H318 Causes serious eye damage.
H341 Suspected of causing genetic defects.
H351 Suspected of causing cancer.
H361 Suspected of damaging fertility or the unborn child.
H400 Very toxic to aquatic life.
H410 Very toxic to aquatic life with long lasting effects.
H413 May cause long lasting harmful effects to aquatic life.

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.

This safety data sheet was prepared in accordance with Council Directive 67/548/EEC and its subsequent amendments, and Commission Directive 1999/45/EC.

Label elements (DPD):**Risk phrases:**

R52/53 Harmful to aquatic organisms, may cause long-term adverse effects in the aquatic environment.

Safety phrases:

S61 Avoid release to the environment. Refer to special instructions/Safety data sheets.

Additional labeling:

Cyanoacrylate. Danger. Bonds skin and eyes in seconds. Keep out of the reach of children.

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® 408™

(TDS for new formulation of Loctite® 408™) August 2012

PRODUCT DESCRIPTION

LOCTITE® 408™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Alkoxyethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to straw colored liquid ^{LMS}
Components	One part - requires no mixing
Viscosity	Very low
Cure	Humidity
Application	Bonding
Key Substrates	Metals, Plastics and Elastomers

Fixture Time, seconds:

Steel	20 to 30
Aluminum	<5
Zinc dichromate	30 to 45
Neoprene	<5
Rubber, nitrile	<5
ABS	<5
PVC	30 to 45
Polycarbonate	20 to 45
Phenolic	<5
Wood (pine)	10 to 20
Leather	<5
Paper	<5

This Technical Data Sheet is valid for LOCTITE® 408™ manufactured from the dates outlined in the "Manufacturing Date Reference" section.

LOCTITE® 408™ has low odor and low blooming properties and is particularly suitable for applications where vapor control is difficult. The product provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. LOCTITE® 408™ is particularly suited for bonding porous or absorbent materials such as wood, paper, leather and fabric.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.1

Flash Point - See SDS

Viscosity, Cone & Plate, mPa·s (cP):
Temperature: 25 °C, Shear Rate: 3,000 s⁻¹ 4 to 10^{LMS}
Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):
Spindle 1, speed 60 rpm, 4 to 10

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.

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. Humidity

The rate of cure will depend on the ambient relative humidity. The best results are achieved when the relative humidity in the working environment is 40% to 60% at 22°C. Lower humidity leads to slower cure. Higher humidity accelerates it, but may impair the final strength of the bond.

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 10 seconds @ 22 °C

Tensile Strength, ISO 6922:

Buna-N	N/mm ² ≥4.5 ^{LMS}
	(psi) (≥652)

Cured for 72 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ²	20.8
	(psi)	(3,020)
Aluminum (etched)	N/mm ²	17.3
	(psi)	(2,500)
Zinc dichromate	N/mm ²	2.0
	(psi)	(290)
ABS	N/mm ²	9.7
	(psi)	(1,400)
PVC	N/mm ²	2.8
	(psi)	(410)
Phenolic	N/mm ²	1.3
	(psi)	(180)
Polycarbonate	N/mm ²	8.6
	(psi)	(1,240)
Nitrile	N/mm ²	0.3
	(psi)	(45)
Neoprene	* N/mm ²	0.6
	* (psi)	(88)

* substrate failure

Block Shear Strength, ISO 13445:

Polycarbonate	N/mm ²	22.9
	(psi)	(3,330)
PVC	N/mm ²	1.2
	(psi)	(180)

Cured for 24 hours @ 22 °C

Tensile Strength, ISO 6922:

Steel pin to steel pin	N/mm ²	27.3
	(psi)	(3,950)

TYPICAL ENVIRONMENTAL RESISTANCE

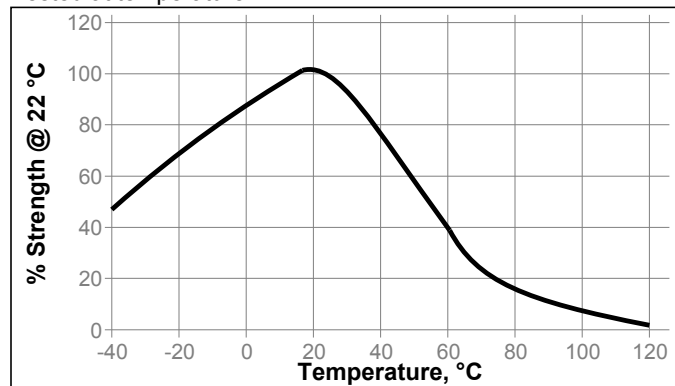
Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

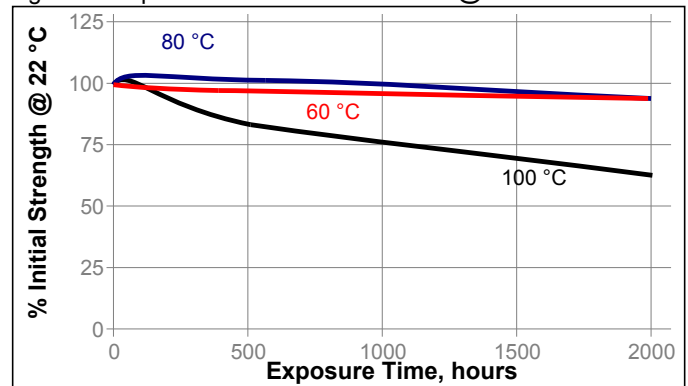
Steel (grit blasted)

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.

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil	40	95	60	95
Unleaded gasoline	22	90	85	80
Ethanol	22	90	85	85
Isopropanol	22	90	100	95
Water	22	75	40	35
98% RH	40	60	55	75
Water/glycol	22	95	85	85

Lap Shear Strength, ISO 4587:

Polycarbonate

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Air	22	90	105	165
98% RH	40	90	85	85

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. Bond areas should be clean and free from grease. Clean all surfaces with a Loctite® cleaning solvent and allow to dry.
2. To improve bonding on low energy plastic surfaces, Loctite® Primer may be applied to the bond area. Avoid applying excess Primer. Allow the Primer to dry.
3. LOCTITE® Activator may be used if necessary. Apply it to one bond surface (do not apply activator to the primed surface where Primer is also used). Allow the Activator to dry.

4. Apply adhesive to one of the bond surfaces (do not apply the adhesive to the activated surface). Do not use items like tissue or a brush to spread the adhesive. Assemble the parts within a few seconds. The parts should be accurately located, as the short fixture time leaves little opportunity for adjustment.
5. LOCTITE® Activator can be used to cure fillets of product outside the bond area. Spray or drop the activator on the excess product.
6. Bonds should be held fixed or clamped until adhesive has fixtured.
7. Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

Loctite Material Specification^{LMS}

LMS dated December 22, 2011. 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

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

Manufacturing Date Reference

This Technical Data Sheet is valid for LOCTITE® 408™ manufactured from the dates below:

<u>Made in:</u>	<u>First manufacturing date:</u>
EU	Pending
China	April 2012
India	Pending
U.S.A.	February 2012

The manufacturing date can be determined from the batch code on the pack. For assistance please contact your local Technical Service Center or Customer Service Representative.

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 2.5