

LOCTITE 406

Cyanoacrylate adhesive — Low viscosity, fast fixturing for plastics & rubbers

Product Information

Product Name	LOCTITE 406
Brand	Henkel / Loctite
Technology	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Transparent, colorless to straw colored liquid
Components	One part — requires no mixing
Viscosity	Low
Cure System	Humidity (atmospheric moisture)
Key Substrates	Plastics and Rubbers

Typical Properties of Uncured Material

Property	Value
Specific Gravity @ 25°C	1.1
Viscosity, Cone & Plate @ 25°C, 3000 s■ ¹	12 to 22 mPa·s (cP)
Viscosity, Brookfield LVF @ 25°C	15 to 25 mPa·s (cP)
Flash Point	See SDS

Cure Speed — Fixture Time vs Substrate (@ 22°C / 50% RH)

Substrate	Fixture Time (seconds)
Steel (degreased)	20 to 45
Aluminum (etched)	< 5
Neoprene	< 5
Nitrile Rubber	< 5
ABS	< 5
PVC	< 5
Polycarbonate	10 to 20
Phenolic	< 5

Lap Shear Strength (ISO 4587) — After 24 h @ 22°C

Substrate	N/mm²	psi
Steel (grit blasted)	15.5	2,250
Aluminum (etched)	12	1,740
Zinc dichromate	14	2,030
ABS	8.8	1,280
PVC	8.7	1,260
Polycarbonate	9.1	1,320
Phenolic	11.3	1,640
Neoprene	1.0	150
Nitrile	1.2	—

Chemical / Solvent Resistance (% initial strength)

Environment	°C	100 h	500 h	1000 h
Motor oil	40	100	85	70
Gasoline	22	90	100	95
Water	22	55	70	70
Water/glycol	22	85	75	80
Ethanol	22	105	105	100
Isopropanol	22	120	110	120
98% RH	40	50	60	45

Directions for Use

1. Clean	Bond areas should be clean and free from grease. Use a Loctite cleaning solvent and allow to dry.
2. Primer	For low energy plastics, apply Loctite Primer to bond area. Avoid excess. Allow to dry.
3. Activator	May be used if needed. Apply to one surface only. Allow to dry.

1. Clean	Bond areas should be clean and free from grease. Use a Loctite cleaning solvent and allow to dry.
4. Apply	Apply adhesive to one bond surface (not the activated surface). Assemble within seconds.
5. Fixture	Hold parts fixed or clamped until adhesive has fixtured.
6. Full Strength	Allow 24 to 72 hours before service loads, depending on bond gap and conditions.

Storage

Store in unopened container in a dry location. Optimal storage: 2°C to 8°C. Storage below 2°C or above 8°C can adversely affect properties. Do not return product to original container after use.

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Source: Henkel Loctite TDS, Feb 2012 | LOCTITE is a trademark of Henkel | www.henkel.com/industrial