

LOCTITE® HHD 3624WH

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PRODUCT DESCRIPTION

LOCTITE® HHD 3624WH provides the following product characteristics:

Technology	Polyurethane Hot Melt
Appearance	White
Solids content	100%
Odour	Slight
Components	One component – requires no mixing
Cure	Moisture and Solidification
Application	Sealant; hole-filling; electronic device assembly

LOCTITE® HHD 3624WH is a reactive hot-melt adhesive based on polyurethane prepolymers. The adhesive provides low modulus, high aspect ratio and good rework ability. It is suitable for use in automatic or manual assembly processes.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield Thermosel @ 110 °C, mPa.s (cP)
Spindle 27, speed 50 min⁻¹ 4,500

TYPICAL CURING PERFORMANCE

Preheating temperature/Time @ 110°C, min 20-30
Application temperature, °C 110 to 120
Open time, min 4

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Adhesive properties

Modulus, sample cured 7 days @ 25°C, 50% relative humidity, MPa 1.84
Lap shear strength, sample cured 3 days @ 25°C, 50% relative humidity, MPa 2.31

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).

Pretreatment:

1. The bonding surfaces must be clean, dry and free of oil and grease.
2. Substrate temperature should not fall below 20°C during application.
3. Low temperatures will lead to early solidification of the adhesive and to a reduced open time. The adhesive may even flake off.
4. The substrates may be preheated if necessary.

Curing:

LOCTITE® HHD 3624WH cures exclusively by moisture and gains its final strength in 1-7 days, but exhibits high handling strength instantly after joining.

Curing is a chemical reaction depending on the following parameters:

- Ambient humidity
- Moisture content on the substrates
- Permeability of the substrates to be bonded
- Application volume / layer of the adhesive film

Application:

1. This material can be applied from heating cartridge guns, from usual syringe type melting equipment.
2. At longer rest periods, melting and application temperatures should be decreased. Longer exposure to higher temperatures can lead to a viscosity increase.

Storage

Store product in an unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 8 to 28°C

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 Henkel representative.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on the specifications of this product.

Conversions

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

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