

LOCTITE HHD 3894 S

August 2019

PRODUCT DESCRIPTION

LOCTITE HHD 3894 S provides the following product characteristics:

Technology	Polyurethane Hot Melt
Appearance	White solid
Cure	Moisture
Application	Device assembly, Bonding
Solids Content, %	100
Components	One part - requires no mixing
Product Benefits	• High strength • High heat resistance • Good flexibility

LOCTITE HHD 3894 S is a white high performance hot melt adhesive specially developed for structural bonding of plastics, metal and ink coating where high strength and high heat resistance. This adhesive has good flexibility and can be applied at low temperature compared to conventional hot melt.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield - Thermosel, 180 °C, mPa·s (cP):

Spindle 27 3,500

Solids Content, % 100

Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Softening Point, °C 140

The above cure profile is a guideline recommendation. 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.

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.

Application:

1. LOCTITE HHD 3894 S can be applied by dispensing equipment
2. Application Temperature: 150 to 180°C

Precautions:

1. Material is applied hot. Appropriate clothing and eye protection should be used.
2. Use with an adequately ventilation to remove any hotmelt fumes or vapors that are generated.

STORAGE:

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

Optimal Storage : 5 to 25 °C

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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb/F}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

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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