

LOCTITE HHD 6008

October 2021

PRODUCT DESCRIPTION

LOCTITE HHD 6008 provides the following product characteristics:

Technology	Polyurethane
Appearance - Part A Polyol	Beige liquid
Appearance - Part B Iso	Beige liquid
Appearance - Mixed	White to grayish paste
Mix Ratio by volume, Part A:Part B	2 : 1
Cure	Room temperature cure after mixing, heat cure
Product Benefits	• High shear strength • High tensile strength • High impact resistance
Operating Temperature Range	-30 to 80°C
Application	Structural adhesive, Electronic structural bonding
Typical Assembly Applications	Consumer electronic device assembly

LOCTITE HHD 6008 two component polyurethane adhesive is designed for fast cure and high impact resistance. This product bonds a variety of substrates exceptionally well. LOCTITE HHD 6008 reacts when mixed and is fully cured at room temperature. Cure can be accelerated with application of heat.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties (Polyol)

Specific Gravity @ 25°C, g/cm ³	1.0
Viscosity, Brookfield CP52, 25 °C, mPa·s (cP):	
Spindle 14, Speed 5 rpm	121,000

Part B Properties (Isocyanate)

Specific Gravity @ 25°C	1.24
Viscosity, Brookfield CP52, 25 °C, mPa·s (cP):	
Spindle 14, Speed 10 rpm	81,000

TYPICAL CURING PERFORMANCE

LOCTITE HHD 6008 is cured after mixing at room temperature.

Cure can be accelerated by exposure to the following heat cure conditions:

Recommended Heat Cure Schedule

60 minutes @ 45°C plus 7 days @ room temperature

Alternate Heat Cure Schedule

20 minutes @ 80°C plus 24 hours @ room temperature

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

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Hardness, Shore D, ISO 868	58
Glass Transition Temperature (Tg) by TMA, °C	35
Coefficient of Thermal Expansion, TMA:	
Below Tg, ppm/°C	97.5
Above Tg, ppm/°C	225.7
Elongation, ISO 527-2, %	207
Modulus of Elasticity, ISO 527-2, N/mm ²	208
Tensile Strength at break, ISO 527-2, N/mm ²	17
Storage Modulus, DMA, N/mm ²	232
Volumetric Shrinkage, %	4.8

Adhesion Properties

Lap Shear Strength, ISO 4587, 0.127 mm spacer beads:

Al to Al	N/mm ²	14.13
	(psi)	(2,050)
IXEF to IXEF	N/mm ²	6.7
	(psi)	(972)

GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

DIRECTIONS FOR USE

1. DO NOT open foil package until the adhesive is ready to use.
2. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
3. **DUAL CONTAINERS:** Material is dispensed through volumetric metered mixing equipment attached to static mix nozzles.

4. For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
5. For maximum bond strength apply adhesive evenly to the surface to be bonded. Parts should be assembled immediately after adhesive has been applied.
6. Application to the substrates should be made as soon as possible. Larger quantities and/or higher temperatures will reduce the working time.
7. Join the adhesive coated surfaces and allow to cure. High temperatures will speed up curing.
8. Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
9. Excessive uncured adhesive can be cleaned up with keton type solvents.

Storage

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

Optimal Storage : Refer to package label for proper storage condition.

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 Henkel Representative.

Conversions

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

Not for product specifications

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

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Reference 1