Technical Data Sheet

LOCTITE HHD 6008WH

November 2018

PRODUCT DESCRIPTION

LOCTITE HHD 6008WH provides the following product characteristics:

Technology	Polyurethane
Appearance - Part A Polyol	White
Appearance - Part B Iso	Beige
Appearance - Mixed	White
Mix Ratio by volume, Part A:Part B	2 : 1
Cure	Two component cure after mixing
Product Benefits	• High shear strength • High tensile strength • High impact resistance
Operating Temperature Range	-30 to 80ºC
Application	Device assembly, Structural bonding
Typical Assembly Applications	Consumer electronic device assembly

LOCTITE HHD 6008WH two component polyurethane adhesive is designed for fast cure and high impact resistance. This product bonds a variety of substrates exceptionally well. This material 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 @ 25ºC	1.02
Viscosity (dynamic), Brookfield CP52, 25 °C, mPa·s (cP): Speed 20 rpm	15,000
Thixotropic Index (2/20 rpm)	4
Flash Point - See SDS	

Part B Properties (Isocyanate)

Specific Gravity @ 25ºC	1.24
Viscosity (dynamic), Brookfield CP52, 25 °C, mPa·s (cP): Speed 20 rpm	12,500
Thixotropic Index (2/20 rpm)	5
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Gel Time

8 to 13 minutes @ 25ºC

LOCTITE HHD 6008WH is cured after mixing at room temperature.

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

2 hours @ 65°C or

20 minutes @ 80°C plus 1 hour @ 25°C

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

Sample cured 7 days @ 25°C

Physical Properties

Hardness, Shore D, ISO 868		55
Elongation at break, ISO 527-2,%		180
Modulus , ISO 527-2	N/mm²	220
	(psi)	(31,900)

TYPICAL PERFORMANCE OF CURED MATERIAL

Shear Strength

Tensile Strength, ISO 527-2	N/mm²	19
	(psi)	(2,760)
Tensile Lap Shear Strength, ISO 4587, Al to Al, acid etched, 5 mil spacer beads	N/mm²	11
	(psi)	(1,600)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. The foil package should not be opened until the adhesive is ready to use.
2. For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
3. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
4. **DUAL CONTAINERS:** Material is dispensed through volumetric metered mixing equipment attached to static mix nozzles.
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 : 21 to 28 °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
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = 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.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:
In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:
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. 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.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:
The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Reference 1