

LOCTITE HHD 7520

November 2018

PRODUCT DESCRIPTION

LOCTITE HHD 7520 provides the following product characteristics:

Technology	Water-based polyurethane
Appearance	White liquid
Solids Content, %	48
pH	7.5
Cure	Heat cure followed by room temperature cure
Application	Device assembly

LOCTITE HHD 7520 water-based polyurethane adhesive is formulated for use in the assembly of fabric to consumer electronic parts and devices. This material may be applied by spraying, dispensing, brushing. LOCTITE HHD 7520 delivers its best performance when used with LOCTITE HHD 7520H hardener.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Cone & Plate, @ 25 °C, mPa·s (cP):	
@ Shear rate of 20 s ⁻¹	4,500
Pot Life @ 25°C, 50% RH, hours	4
Storage Life, days:	
15 to 25 °C (Recommended)	180
5 to 35 °C	180
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Cure Schedule**

LOCTITE HHD 7520 with LOCTITE HHD 7520H
Dry 5 minutes @ 40°C then allow to cool down
Followed by heat press 0.2 to 0.5 MPa @ 90 to 115°C for 20 to 60 seconds.
24 hours curing is recommended before evaluating performance.

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.

GENERAL INFORMATION

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

DIRECTIONS FOR USE**Preparation**

1. Surface should be dry, without dust, oil, grease or other impurities.
2. Product should be stirred before use to prevent color separation.

Preparation if used with Hardener

1. The recommended mix ratio of LOCTITE HHD 7520 resin and LOCTITE HHD 7520H hardener is 100:5 to 100:10 by weight.
2. Mix the compound of LOCTITE HHD 7520 and LOCTITE HHD 7520H hardener by manual stirring or agitation.

Spraying

1. LOCTITE HHD 7520 can be sprayed by spray guns.
2. For porous material, it is recommended to spray the surface of both two pre-bonded materials.
3. Recommended dry thickness is 50~100 µm.

Assembly

1. The sprayed layer must be dried at above 40°C.
2. Sprayed parts should be allowed to cool before subjecting to heat press.
3. Heat press sprayed assembled parts at 90 to 115 °C. Recommended pressing pressure is 0.2 to 0.5 MPa for 20 to 60 seconds.

Cleaning

1. Uncured adhesive in spray equipment can be cleaned using deionized water.

Packaging

LOCTITE HHD 7520 is supplied in 20 kg Metal Pail.

STORAGE:

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

Optimal Storage : 15 to 25 °C , the resin is Frost sensitive

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

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

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

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

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

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

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

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

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

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

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

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

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