

LOCTITE HHD 8150

May 2018

PRODUCT DESCRIPTION

LOCTITE HHD 8150 provides the following product characteristics:

Technology	Acrylic
Appearance - Part A	Yellow
Appearance - Part B	Blue
Appearance - Mixed	Green
Mix Ratio by volume, Part A:Part B	10 : 1
Cure	Room temperature cure after mixing
Product Benefits	<ul style="list-style-type: none"> Fast cure High strength 125 µm spacers for bondline thickness control
Application	Device assembly, Structural bonding

LOCTITE HHD 8150 two component methacrylate adhesive system is designed for use in handheld device cover assembly applications. This material contains a maximum spacer bead of 125 µm for controlled bondline thickness between mating substrates. This material reacts when mixed and is fully cured at room temperature.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Viscosity , Rheometer, Physica MCR300, mPa·s (cP):
@ Shear rate of 20 s⁻¹ 45,000
Flash Point - See SDS

Part B Properties

Viscosity Rheometer, Physica MCR300, mPa·s (cP):
@ Shear rate of 20 s⁻¹ 45,000
Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Peak Exotherm

Peak Exotherm Temperature after mixing, °C 95
Peak Exotherm Time after mixing, minutes 5 to 10

LOCTITE HHD 8150 is cured after mixing at room temperature.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Hardness, Shore D, cured 2 hrs @ 60°C >50
Tensile Modulus, cured 72 hours @ 25°C, MPa ≥500

TYPICAL PERFORMANCE OF CURED MATERIAL

Sample cured 24 hours @ 25°C.

Shear Strength

Lap Shear Strength , N/mm²
Anodized Aluminum to Anodized Aluminum >19

GENERAL INFORMATION

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

DIRECTIONS FOR USE

- For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
- Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
- DUAL CONTAINERS:** Material is dispensed through volumetric metered mixing equipment attached to static mix nozzles.
- For maximum bond strength apply adhesive evenly to the surface to be bonded. Parts should be assembled immediately after adhesive has been applied.
- Application to the substrates should be made as soon as possible. Larger quantities and/or higher temperatures will reduce the working time.
- Join the adhesive coated surfaces and allow to cure. High temperatures will speed up curing.
- Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
- 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 : 2 to 8 °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

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

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.

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.

Trademark usage: [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 2

Americas
+1.888.943.6535

Europe
+32.1457.5611

Asia
+86.21.3898.4800

For the most direct access to local sales and technical support visit: www.henkel.com/electronics