



LOCTITE® HHD 8195GY

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PRODUCT DESCRIPTION

LOCTITE® HHD 8195GY provides the following product characteristics:

Technology	Acrylic
Chemical type	Methacrylate
Appearance - Part A	Black
Appearance - Part B	White
Appearance (mixed)	Gray - black
Mix ratio by volume: Part A: Part B	10: 1
Cure	Room temperature, can be accelerated by heat
Application	Device assembly; Structural bonding, metals and plastics
Product benefits	• Superior impact and peel strength • Little or no surface preparation • Rapid cure • Halogen free • Excellent environmental resistance

LOCTITE® HHD 8195GY is a non-sagging two component room temperature curing methacrylate adhesive. The product is designed to have a transparent gray color. Adhesive provides a balanced fixture time and excellent bond strength on multiple substrates including glasses, metals, plastics, and composites. The product is toughened and provides high elongation and excellent impact strength.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A properties

Viscosity, PP25, 25°C, mPa.s (cP)
Parallel plate @ 0.5 mm, Shear rate: 20 s⁻¹ 21,400

Part B properties

Viscosity, PP25, 25°C, mPa.s (cP)
Parallel plate @ 0.5 mm, Shear rate: 20 s⁻¹ 49,600

TYPICAL CURING PERFORMANCE

Curing properties

Peak exotherm time after mixing, minutes 8
Peak exotherm temperature after mixing, °C 125

TYPICAL PROPERTIES OF CURED MATERIAL

Sample cured 12 hours at 25°C

Physical properties

Tensile modulus, MPa 400
Tensile strength, at break, MPa 21.5
Elongation, % 136
Glass transition temperature, DMA (°C) 82
Coefficient of linear thermal expansion, (ppm/ °C) 144/347

Adhesion properties

Lap shear strength, 125µm gap, MPa
Anodized Al to Anodized Al 18.0
SUS/SUS, MPa 13.1
PC/PC, MPa 8.3

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

Directions for use

Mixing

1. Product LOCTITE® HHD 8195GY is typically applied either with the use of meter mix equipment or directly out of cartridges through static mix nozzles. These methods of application ensure that component A and B are dispensed and mixed at the proper ratio. When properly mixed, LOCTITE® HHD 8195GY should achieve a uniform color.
2. When dispensed in a large mass, heat buildup during and after mixing is normal. To reduce the likelihood of exothermic reaction or excessive heat buildup, mix less than 100 grams at a time. Mixing smaller amounts will minimize heat buildup.

Application

1. For best performance, surfaces should be clean and residue free prior to adhesive application.
2. To ensure maximum bond strength, surfaces must be mated within the adhesive's open time.
3. Use enough material to completely fill the joint when parts are clamped.



Curing

1. Curing speeds may vary based on adhesive and substrate temperatures. Reference the peak exotherm and open time on TDS as a guide to better understand curing time trends.
2. After the fixture time is achieved the material usually has reached handling strength. For heavy parts handling strength can take longer.
3. Parts should be fixed for a minimum period of 1 hours prior to applying a load.

Clean up

1. It is important to clean up excess adhesive from the work area and application equipment before it cures.
2. Excess uncured adhesive can be cleaned with ketone type solvents.
3. Cured adhesives typically requires mechanical abrasion for removal.
4. Always test the suitability and effect of any cleaning method on the specific material that will come in contact with first.

Storage

Store product in an 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 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.

Not for product specifications

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

Conversions

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

Disclaimer

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Reference 1

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