Technical Data Sheet

LOCTITE® HHD 9397BK

August 2025

Product description

LOCTITE® HHD 9397BK provides the following product characteristics:

Technology	Silane modified polymer
Appearance	Black
Odor	Slight
Components	One component
Cure	Moisture
Application	Structure bonding/Sealing

LOCTITE® HHD 9397BK is a one component sealant based on silane modified polymers. It is formulated to cure by reaction with moisture and provide elastomeric properties without causing any cyclic silicone formation. This material creates a low modulus bond/seal between substrates to mitigate the intrusion of moisture and other fluids from entering the device while managing CTE (coefficient of thermal expansion) mismatch between different substrates.

Features

- Fast cure
- High adhesion strength
- Low shrinkage
- High aspect ratio

TYPICAL PROPERTIES OF UNCURED MATERIAL

Solids, %	100
Viscosity Brookfield DV-II+, CP52 @ 25°C, mPa·s (cP):	
Speed 20 rpm	14,530
Thixotropic index, (2/20 rpm)	2.8

TYPICAL APPLICATION PROPERTIES

Skin over time, minutes	15

Recommended cure condition

Under normal conditions, the atmospheric moisture initiates the curing process. The product develops functional strength in 24 hours and fully cures in 7 days.

The skin formation and curing times are dependent on humidity, temperature and joint depth. Increasing the temperature and keeping ambient moisture at the same time reduces the cure time. Low temperatures, along with low moisture will slow down the process.

The above cure profile(s) are guideline recommendations. These 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

Cured for 7 days @ 25 °C / 50% RH

Adhesion properties	
Lap shear strength, MPa	
AnAL6013 to AnAL6013 (after 72 hours)	3.66
Elongation, %	140
Shore A	45

GENERAL INFORMATION

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

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or their strong oxidizing materials.

Pretreatment

1. The bonding surfaces must be clean, dry and free of oil and grease.
2. Substrate temperature should not fall below 20ºC during application.
3. Lower temperatures will lead to early solidification of the adhesive. The adhesive might flake off if open time is reduced.
4. The substrates may be preheated if necessary.

Application

1. This material can be applied from heating cartridge guns, from usual syringe type melting equipment.
2. At longer rest periods, melting and application temperatures should be decreased. Longer exposure to higher temperatures can lead to a viscosity increase.

Storage

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

Optimal storage: -15 to -25°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
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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