

LOCTITE® EA 9466™

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PRODUCT DESCRIPTION

LOCTITE® EA 9466™ provides the following product characteristics:

Technology	Epoxy
Chemical Type	Epoxy
Appearance (resin)	White opaque paste
Appearance (hardener)	White translucent liquid
Appearance (mixed)	Off-white opaque paste
Components	Two components – requires mixing
Viscosity	Medium
Mix ratio, (by volume) Resin : Hardener	2 : 1
Mix ratio, (by weight) Resin : Hardener	100 : 50
Cure	Room temperature cure after mixing
Application	Bonding

LOCTITE® EA 9466™ is a toughened, industrial grade epoxy adhesive with extended work life. Once mixed, the two component epoxy cures at room temperature to form a tough, off-white bondline which provides high peel resistance and high shear strengths. The fully cured epoxy is resistant to a wide range of chemicals and solvents, and acts as an excellent electrical insulator. LOCTITE® EA 9466™ provides excellent bond strengths to a wide variety of plastics and metals. Typical applications include general purpose industrial applications requiring extended work life for adjusting parts during assembly.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Resin	
Specific Gravity @ 25°C	1.0
Viscosity, Brookfield - RVT @ 25 °C, mPa·s (cP):	15,000 to 50,000
Spindle 6, Speed 20 rpm	
Hardener:	
Specific Gravity @ 25°C	1.0
Viscosity, Brookfield - RVT @ 25 °C, mPa·s (cP):	3,000 to 7,000
Spindle 5, Speed 50 rpm	
Mixed:	
Working life, minutes	60

TYPICAL CURING PERFORMANCE

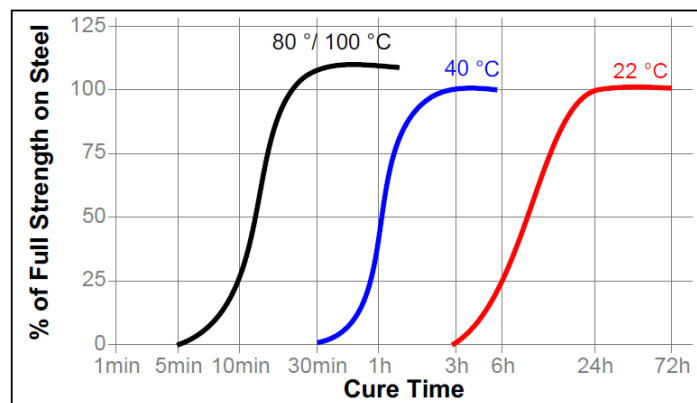
Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, ISO 4587, minutes:	
Steel (grit blasted)	180

Cure Speed vs. Time, Temperature

The rate of cure will depend on the ambient temperature, elevated temperatures may be used to accelerate the cure. The graph below shows shear strength developed with time at various temperatures on grit blasted steel lapshears and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 7 days @ 22°C, 1.2 mm thick film

Physical Properties

Glass Transition Temperature, ASTM E 1640, °C		62
Shore hardness ISO 868, Durometer D		60
Elongation, at break, ISO 527-3, %	N/mm ²	3
Tensile Strength ASTM D 882	(psi)	32 (4,640)
Tensile Modulus, ISO 527-3	N/mm ²	1,718 (249,110)
	(psi)	

Electrical Properties

Dielectric Breakdown Strength, IEC 60243-1, kV/mm	30
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TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive properties

Cured for 5 days @22°C

Lap Shear Strength ISO 4587:

Steel (grit blasted)	N/mm ² (psi)	37.0 (5,365)
Aluminum (abraded)	N/mm ² (psi)	26.0 (3,770)
Aluminum (anodised)	N/mm ² (psi)	17.9 (2,595)
Galvanized Steel (Hot Dipped)	N/mm ² (psi)	8.5 ((1,230))
Stainless Steel	N/mm ² (psi)	23.0 (3,335)
Polycarbonate	N/mm ² (psi)	5.3 (765)
Nylon	N/mm ² (psi)	1.6 (230)
Wood (Fir)	N/mm ² (psi)	11.3 (1,635)
GRP	N/mm ² (psi)	5.0 (725)
ABS	N/mm ² (psi)	4.7 (680)

180° Peel Strength, ISO 8510-2:
Steel (grit blasted) N/mm (lb/in) 8.0 (45.5)

Tensile Strength, ISO 6922:
Steel pin (grit blasted) to Soda glass N/mm² (psi) 43.2 (6,260)

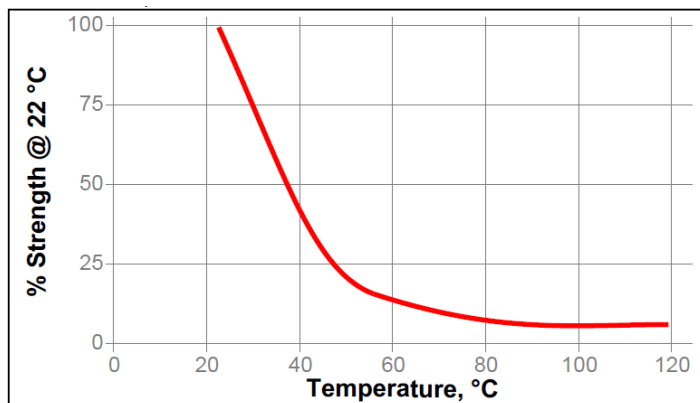
Impact Strength, ISO 9653, KJ/m²:
Steel (grit blasted) 5.8

TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 5 days @22°C
Lap Shear Strength, ISO 4587:
Steel (grit blasted):

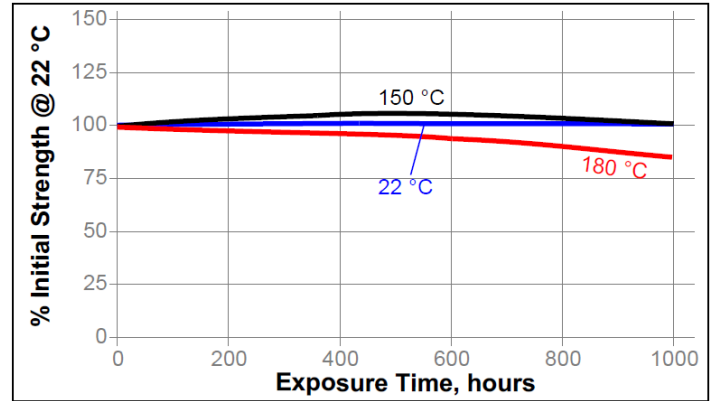
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C.



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22°C.

Environment	°C	% of initial strength	
		500 h	1000 h
Motor oil (10W/30)	87	135	145
Unleaded gasoline	22	95	125
Water/glycol 50/50	87	75	75
Salt fog	22	---	80
98% RH	40	85	90
Condensing Humidity	49	---	90
Water	22	---	90
Acetone	22	75	90
Isopropanol	22	90	100

Tensile Strength, ISO 6992:

Steel pin (grit blasted) to Soda glass

Environment	°C	% of initial strength	
		500 h	1000 h
98% RH	40	90	90

GENERAL INFORMATION

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

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 other strong oxidizing materials.

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.



Direction for use

- For best performance part surfaces should be clean and free of grease.
- For high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
- Dual Cartridges:** To use, simply insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. If automatic mixing of resin and hardener is desired, attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of the adhesive and mix thoroughly. Mix for approximately 15 seconds after uniform color is obtained.
Bulk Containers: Mix thoroughly by weight or volume in the proportions specified in Product Description section. Mix for approximately 15 seconds after uniform color is obtained.
- Do not mix quantities greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimise the heat build-up.
- Apply the adhesive as quickly as possible after mixing to one surface to be joined. For maximum bond strength apply adhesive evenly to both surfaces. Parts should be assembled immediately after mixed adhesive has been applied.
- Keep assembled parts from moving during cure. The bond should be allowed to cure 24 hours before subjecting to any service loads.
- Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
- After use and before adhesive hardens mixing and dispensing equipment should be cleaned with hot soapy water.

Storage

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

Optimal storage: 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.

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 Henkel representative.

Conversions

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

Disclaimer

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