

# Technical Data Sheet

## Product 480

Worldwide Version, October 1994

### PRODUCT DESCRIPTION

LOCTITE® Product 480 is a medium viscosity, fast curing, single component cyanoacrylate adhesive. It is specifically formulated for increased flexibility and peel strength.

### TYPICAL APPLICATIONS

Rapid bonding of a wide range of metal, plastic and elastomeric materials.

### PROPERTIES OF UNCURED MATERIAL

	Typical Value	Range
Chemical Type	Ethyl cyanoacrylate	
Appearance	Black	
Specific Gravity @ 25°C	1.05	
Viscosity @ 25°C, mPa.s (cP)		
Brookfield LVT		
Spindle 1-6 rpm	300	100 to 500
Flash Point (TCC), °C	>80	

### TYPICAL CURING PERFORMANCE

Under normal conditions, the surface moisture initiates the hardening process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

### Cure speed vs. substrate

The rate of cure will depend on substrate used. The table below shows the fixture time achieved on different materials at 22°C, 50% relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup> (14.5 psi) tested according to ASTM D1002.

Substrate	Fixture Time, seconds
Steel (degreased)	60 to 120
Aluminium	10 to 30
Zinc dichromate	50 to 150
Neoprene	<20
Nitrile rubber	<20
ABS	20 to 50
PVC	50 to 100
Polycarbonate	30 to 90
Phenolic materials	20 to 60

### Cure speed vs. bond gap

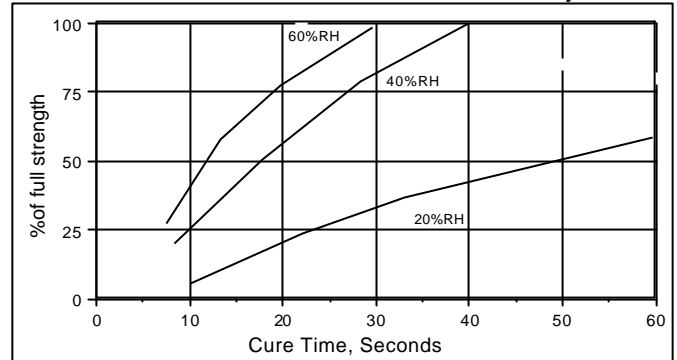
The rate of cure will depend on the bondline gap. High cure speed is favoured by thin bond lines. Increasing the bond gap will slow down the rate of cure.

### Cure speed vs. activator

Where cure speed is unacceptably long due to large gaps or low relative humidity applying activator to the surface will improve cure speed. However, this can reduce the ultimate strength of the bond, therefore testing is recommended to confirm effect.

### Cure speed vs. humidity

The rate of cure will depend on the ambient relative humidity. The graph below shows the tensile strength developed with time on Buna N rubber at different levels of humidity.



### TYPICAL PROPERTIES OF CURED MATERIAL

#### Physical Properties

Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	80 x 10 <sup>-6</sup>
Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1
Glass transition temperature, °C	150

#### Electrical Properties

Dielectric constant & loss, 25°C, ASTM D150:

	Constant	Loss
measured at 100Hz	2.65	<0.02
	2.75	<0.02
	2.75	<0.02

Volume resistivity, ASTM D257, ? .cm: 1 x 10<sup>16</sup>

Surface resistivity, ASTM D257, ? : 1 x 10<sup>16</sup>

Dielectric strength, ASTM D149, kV/mm: 25

### PERFORMANCE OF CURED MATERIAL

(After 24 hr at 22°C)	Value	Typical Range
Shear Strength, ASTM D1002, DIN 53283		
Grit Blasted Steel, N/mm <sup>2</sup>	26	22 to 30
(psi)	(3800)	(3200 to 4300)
Etched Aluminium, N/mm <sup>2</sup>	18	14 to 22
(psi)	(2600)	(2000 to 3200)
Zinc dichromate, N/mm <sup>2</sup>	11.5	8 to 15
(psi)	(1700)	(1200 to 2200)
ABS, N/mm <sup>2</sup>	13	6 to 20
(psi)	(1900)	(900 to 3000)
PVC, N/mm <sup>2</sup>	12	4 to 20
(psi)	(1700)	(600 to 3000)
Polycarbonate, N/mm <sup>2</sup>	12.5	5 to 20
(psi)	(1800)	(700 to 3000)
Phenolic, N/mm <sup>2</sup>	10	5 to 15
(psi)	(1500)	(700 to 2200)
Neoprene rubber, N/mm <sup>2</sup>	10	5 to 15
(psi)	(1500)	(700 to 2200)
Nitrile rubber, N/mm <sup>2</sup>	10	5 to 15

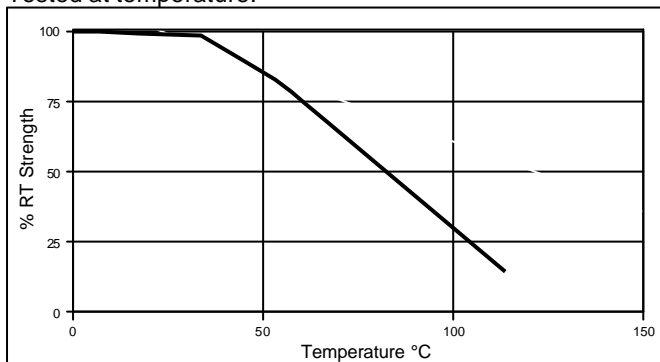
	(psi)	(1500)	(700 to 2200)
Tensile Strength, ASTM D2095, DIN53282			
Grit Blasted Steel, N/mm <sup>2</sup>	18.5	12 to 25	
	(psi)	(2700)	(1700 to 3600)
Buna N rubber, N/mm <sup>2</sup>	10	5 to 15	
	(psi)	(1500)	(700 to 2200)

**TYPICAL ENVIRONMENTAL RESISTANCE**

Test Procedure : Shear Strength ASTM-D1002/DIN 53283  
 Substrate: Grit blasted mild steel laps  
 Cure procedure: 1 week at 22°C

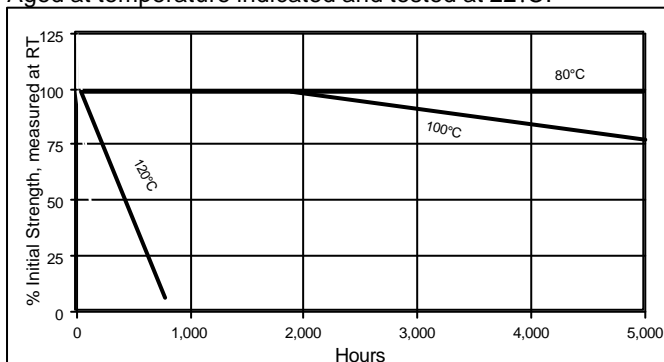
**Hot Strength**

Tested at temperature.



**Heat Ageing**

Aged at temperature indicated and tested at 22°C.



**Chemical / Solvent Resistance**

Aged under conditions indicated and tested at 22°C.

Solvent	Temp.	%Initial strength retained at		
		100 hr	500 hr	1000 hr
Motor Oil	40°C	85	85	85
Leaded Petrol	22°C	90	70	70
Ethanol	22°C	95	95	80
Isopropanol	22°C	75	75	75
Freon TA	22°C	90	90	85
Humidity 95% RH	40°C	80	80	65
Humidity 95% RH polycarbonate	40°C	100	100	100

**GENERAL INFORMATION**

**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 oxidising materials.**

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

**Directions for use**

For best performance surfaces should be clean and free of grease. This product performs best in thin bond gaps, (0.05mm). Excess adhesive can be dissolved with Loctite clean up solvents, nitromethane or acetone.

**Storage**

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C-21°C (46°F-70°F) unless otherwise labelled. Optimal storage conditions for unopened containers of cyanoacrylate products are achieved with refrigeration: 2°C-8°C (36°F-46°F). Refrigerated packages shall be allowed to return to room temperature prior to use. The refrigerated shelf-life period for a 500g container is 18 months based upon date of manufacture. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf-life information on other pack sizes, contact your local Technical Service Centre.

**Data Ranges**

The data contained herein may be reported as a typical value and/or range (based on the mean value ±2 standard deviations). Values are based on actual test data and are verified on a periodic basis.

**Note**

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, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite 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

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