

LOCTITE® 534™

January 2005

PRODUCT DESCRIPTION

LOCTITE® 534™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	Purple, wax consistency ^{LMS}
Appearance (form)	Stick
Fluorescence	Positive under UV light ^{LMS}
Components	One component - requires no mixing
Cure	Anaerobic
Secondary Cure	Activator
Application	Tacking/Dressing
Strength	Low

LOCTITE® 534™ is designed for use as a tacking/dressing agent to be used in conjunction with cork and cut gaskets. This material allows a precut gasket to be positioned on a gasket surface and holds it in place while mating gasket surfaces are aligned and positioned. It holds aggressively yet still allows for repositioning of the cut gasket. It is supplied as a wax-like semi-solid, conveniently packaged in a self-feeding stick applicator. It is particularly well suited for applications where a liquid product may be too fluid to hold aggressively or be too difficult to apply. It stores easily and allows for direct contact to metal surfaces during application to ensure even coverage.

TYPICAL PROPERTIES OF UNCURED MATERIAL

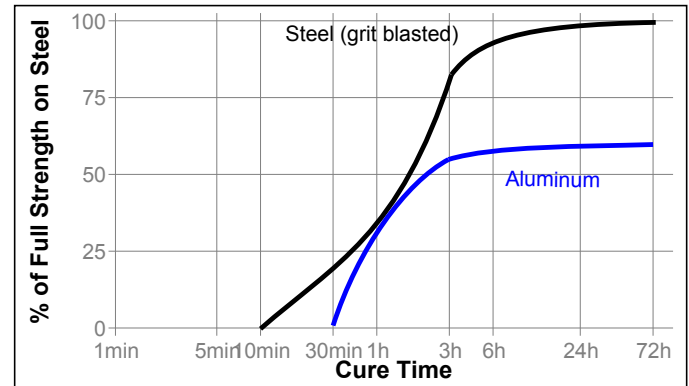
Flash Point - See SDS

Unworked Penetration, ISO 2137, 1/10 mm 80 to 140^{LMS}

TYPICAL CURING PERFORMANCE

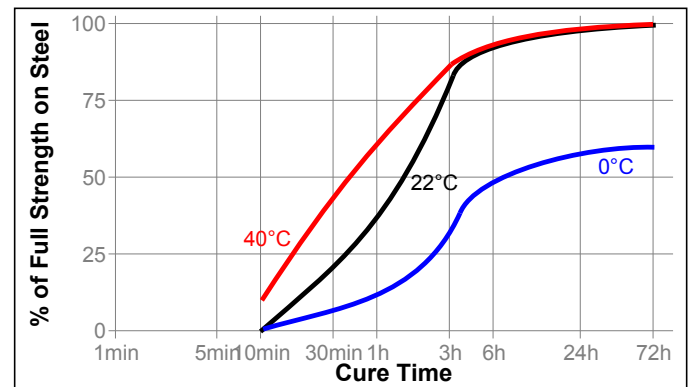
Cure Speed vs. Substrate

The graph below shows the shear strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587.



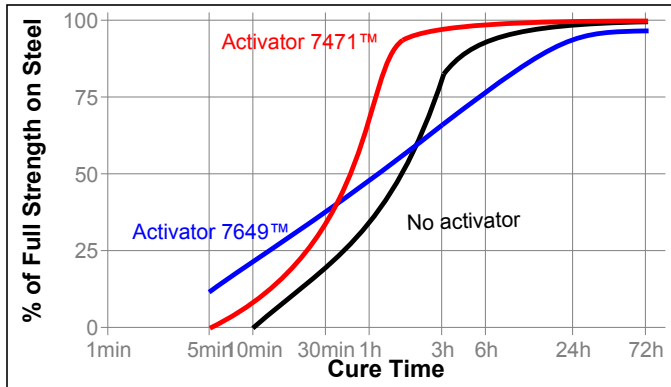
Cure Speed vs. Temperature

The rate of cure will depend on the ambient temperature. The graph below shows the shear strength developed with time at different temperatures on grit blasted steel lap shears and tested according to ISO 4587.



Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the shear strength developed with time on grit blasted steel lap shears using and tested according to ISO 4587.



TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted) N/mm² ≥4
(psi) (≥580)

TYPICAL ENVIRONMENTAL RESISTANCE

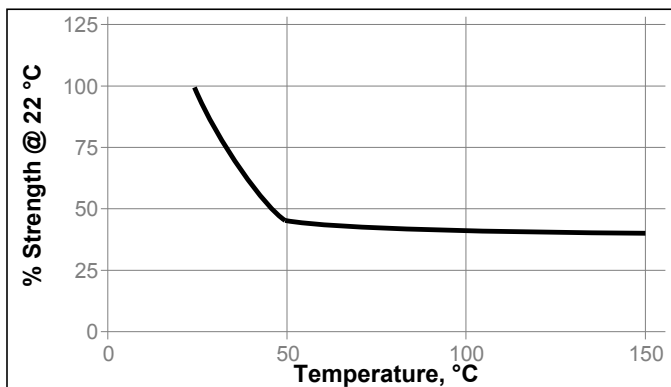
Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)

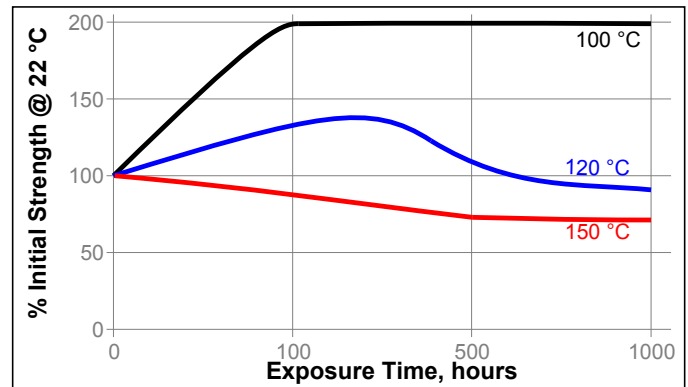
Hot Strength

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		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	125	125	75	75
Unleaded gasoline	22	35	20	20
Brake fluid	22	100	95	75
Water/glycol 50/50	87	100	85	85
Ethanol	22	60	30	30
Acetone	22	20	15	15

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 oxidizing materials.

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

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.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use:

For Assembly

1. For best results, clean all bond surfaces with a LOCTITE® cleaner/degreaser and allow to dry.
2. The product is designed for use in conjunction with pre-cut gaskets as a gasket tacking/dressing agent.
3. If present, remove any visible contaminants on the top of the stick prior to application.
4. Advance only enough stick product to use at the time of application. Typically 3 mm.
5. Apply manually by wiping the advanced stick directly on the surface of the flange.
6. Position the gasket on the tacky surface of the applied material to hold it in position.
7. Flanges should be mated and tightened as soon as possible after assembly to avoid shimming.

Loctite Material Specification^{LMS}

LMS dated November 5, 2004. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

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 Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

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.

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