



LOCTITE[®] Black Contact Adhesive

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PRODUCT DESCRIPTION

LOCTITE[®] Black Contact Adhesive provides the following product characteristics:

Technology	Solvent based
Chemical Type	Neoprene rubber
Appearance (uncured)	Black viscous liquid
Cure	Air dry
Application	Bonding-maintenance
Specific Benefit	<ul style="list-style-type: none"> • Fast drying • Chemical resistant • Outstanding water resistance • Withstands temperature extremes

LOCTITE[®] Black Contact Adhesive is a contact cement used for all types of weatherstripping and general purpose bonding. It is an air-drying contact cement that allows quick bonding yet maintains enough versatility in tack to allow large areas to be spread and bonded at one time. The drying characteristics allow for repositioning of parts after contact is made. The maximum strength of LOCTITE[®] Black Contact Adhesive is attained after all of the solvent has been released. Non-porous surfaces, if assembled while the adhesive is wet, will prevent the release of solvent, consequently, the adhesive will take longer to dry and develop maximum strength. Typical applications include door and trunk moldings, all types of weatherstripping, vinyl tops, and fabric backed vinyl upholstery. This product is typically used in applications with an operating range of -29 °C to +82 °C.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 0.88
Flash Point - See MSDS

TYPICAL CURING PERFORMANCE

LOCTITE[®] Black Contact Adhesive cures on exposure to moisture in the air. Cure times will vary with temperature, humidity and gap. Substantial bond will form when the surfaces are mated. Maximum strength is obtained after the adhesive is completely dry. Force drying with moderate heat will increase strength.

Tack Free Time

Tack Free Time is the time required to achieve a tack free surface

Tack Free Time, @ 22 °C, minutes 3 to 4

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance

-29 °C to 82 °C continuous

Chemical/Solvent Resistance

LOCTITE[®] Black Contact Adhesive retains effective properties in contact with automotive fluids, such as motor oil, transmission fluids, alcohol and antifreeze solutions

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 Material Safety Data Sheet (MSDS).

Directions for use

1. Clean surfaces thoroughly. Use abrasives to remove any powdery mold release from new weatherstripping.
2. Apply a thin, even film to both surfaces.
3. Allow to dry tacky (3 to 4 minutes).
4. Bond the two surfaces together and apply enough pressure to produce uniform contact.
5. **NOTE:** The early strength of LOCTITE[®] Black Contact Adhesive is enough to hold most parts together. However, maximum strength is obtained after the adhesive is completely dry. Aging of the bond and exposure to moderate heat increases strength.

Clean-up

1. Use lacquer thinner or any hydrocarbon solvent.

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 specifications for this product.

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.

Reference 0.0

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

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