



LOCTITE® F5002

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Description:

High strength, fast curing Quickbond F5002 1:1 toughened acrylic is designed for the structural bonding of similar or dissimilar surfaces including metals, plastics, ceramics, GRP and most other materials. Quickbond F5002 is available in kits or packed in convenient, simple to use, dual cartridge systems and dispensed using a 1:1 cartridge gun. It is applied as 2 beads directly onto the components so no mixing is required giving a clean application every time.

Physical Properties:

	Part A	Part B	Mixed
Colour	Green	Pink	Grey
Viscosity (mPa.s)	3,000	3,000	3,000
Specific Gravity	1.01	1.01	1.01
Mix Ratio – By Volume			1:1

Performance:

Shear Strength - Steel (MPa)	25
- Aluminium	21
- GRP	17*
Gap Fill (mm)	~0.5
Peel Strength (N/25mm)	150

Cure Speed:

<u>Handling Strength</u>	3-5 mins.
<u>Working Strength</u>	30 mins.
<u>Full Strength</u>	24 hrs.

*denotes substrate failure

Service Temperature:

The recommended service temperature range for this product is -40 to +120°C. However higher temperatures may be endured for short periods providing the adhesive is not unduly stressed.

Storage:

When stored in the original unopened containers at 5-25°C, the shelf life of this product is 21 months from the date of manufacture.

Handling:

Full information can be obtained from the Material Safety Data Sheet (MSDS). Users are reminded that all materials, whether innocuous or not, should be handled according to the principles of good industrial hygiene.



Directions for Use:

1. Though this adhesive will bond through a degree of oil contamination ideally the surfaces should be clean, dry and grease free prior to bonding. Where optimum performance is required then light abrasion (i.e. Emery Cloth or Shot Blasting) is recommended. Surfaces can be degreased using **Loctite 7063**.
2. The adhesive should be dispensed through a static mixer directly onto the components
3. Assemble the parts and squeeze together with sufficient pressure to ensure the adhesive spreads to cover the entire bond area. Apply light clamping pressure and do not disturb, or realign the joint, whilst the adhesive cures.

Quickbond 5002 is available in 50ml and 380ml cartridges or 5 litre kits.

The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions. 19/07/07

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