LOCTITE® 5004™

February 2008

PRODUCT DESCRIPTION

LOCTITE® 5004™ provides the following product characteristics:

Technology	Solvent based
Chemical Type	uPVC in solvent
Appearance	White
Solvent	THF Methylethylketone Cyclohexanone
Components	One part - requires no mixing
Viscosity	Medium
Cure	Solvent evaporation
Application	Bonding of uPVC pipes & fittings

LOCTITE® 5004™ is a special solvent based adhesive for bonding uPVC pipes. It is specially formulated to meet the requirements for contact with drinking water laid down by the German Health Authorities.

This product is suitable for joints resistant to shear strain of pressure pipes with uPVC fittings (water and gas) in accordance with recommendations of the Plastic Pipe Association

Approvals

LOCTITE® 5004™ complies with DIN 16970 and KRV guideline R1.17. and the rules for construction and testing of drainage pipes. It also complies with the adhesives standards BS 4326, part 3, ASTM D2564 and NEN 7106.

The Cured adhesive meets the requirements of admission for drinking water supply through mPVC pipes in compliance with the recommendation number VIII of the Plastics Commission of the Bundesgesundheitsamt (German Health Authorities).

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	0.96
Viscosity, Epprecht @ 23 °C, mPa·s (cP):	
Epprecht Body 3	2,500
Flash Point - See MSDS	

TYPICAL CURING PERFORMANCE

Assembly joints should not be moved within 5 minutes of assembly. Pressure testing should not take place before 24 hours after assembly.

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. Adhesive should be applied lightly to the socket and liberally to the pipe, which should be immediately inserted into the socket (within 4 minutes at 20°C). At higher temperatures this open time should be reduced (e.g. to 1 minute at 40°C).
2. Parts must not be moved within 5 minutes after assembly at 20°C.
3. However, at lower temperatures longer waiting times should be allowed.

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.

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, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel 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 interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Conversions
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Trademark usage

Reference 0.1