

LOCTITE HHD 9393 BK

February 2019

PRODUCT DESCRIPTION

LOCTITE HHD 9393 BK provides the following product characteristics:

Technology	MS Polymer
Appearance	Black paste
Cure	Moisture cure
Product Benefits	• High bond strength • Adheres well to a variety of substrates • Free of solvents, isocyanates, silicones and PVC
Application	Device assembly, Elastomeric adhesive

LOCTITE HHD 9393 BK one component silane modified polymer is formulated to cure by reaction with moisture. The skin formation and curing times are dependent on humidity, temperature and joint depth. Increasing the temperature and keeping ambient moisture at the same time reduces the cure time. Low temperatures, along with low moisture will slow down the process.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield - RVDVII, 25 °C, mPa·s (cP):
 Spindle 52, speed 2.5 rpm 30,000
 Flash Point - See SDS

TYPICAL CURING PERFORMANCE

Skin over time, minutes 6 to 10
 Application Temperature, °C 5 to 40

TYPICAL PROPERTIES OF CURED MATERIAL

Sample cured 7 days @ 23°C, 50% RH

Physical Properties

Hardness, Shore A 47

TYPICAL PERFORMANCE OF CURED MATERIAL

Sample cured 7 days @ 23°C, 50% RH

Shear Strength

Lap Shear Strength, PPA to PPA, N/mm² 2.51

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. The substrates must be clean, dry, oil and grease free.
2. For cleaning, Cleaner-FL from the Teroson programme is suitable.

STORAGE

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage : 10 to 25 °C (unless otherwise labeled)

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

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

Disclaimer

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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Reference 1