

Loctite® Cyanoacrylate Adhesive Properties Chart

	LOCTITE® PRODUCT	ITEM NUMBER	PACKAGE TYPE/SIZE	TYPICAL USE	COLOR	GAP FILL (INCHES)	CATEGORY	VISCOSITY (cP)	SHEAR STRENGTH* (psi)	TEMPERATURE RANGE	CURE SPEED**	SPECIFIC GRAVITY	AGENCY APPROVALS
TOUGHENED THERMALLY RESISTANT	4203™	1376970 28027	20 g bottle 1 lb. bottle	Close-fitting parts	Clear	0.005	Ethyl	375	2,200	-65°F (-54°C) to 250°F (121°C)	Fixture – 40 sec. Full – 24 hrs.	1.10	N/A
	4204™	1376969 26325	20 g bottle 1 lb. bottle	Gap filling	Clear	0.008	Ethyl	4,000	2,400	-65°F (-54°C) to 250°F (121°C)	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	4205™	28028 28029	20 g tube 200 g tube	Porous surfaces	Clear	0.010	Ethyl	Gel	2,300	-65°F (-54°C) to 250°F (121°C)	Fixture – 90 sec. Full – 24 hrs.	1.10	N/A
GENERAL-PURPOSE	382™	20420 38240 38261	20 g kit/ 20 g bottle 1 lb. bottle	Gap filling and ultra-performance wire tracking	Clear	0.008	Ethyl	5,000	3,200	-65°F (-54°C) to 210°F (99°C)	Fixture – 30 sec. Full – 24 hrs.	1.05	N/A
	404®	46551 46548 46561	1/3 oz. bottle 4 oz. bottle 1 lb. bottle	Rubber O-ring bonder	Clear	0.005	Ethyl	80	3,500	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.09	ABS, CFIA Listed, Commercial item std. A-A-3097
	409™	40904 40945 40974 18030	3 g tube 20 g tube 200 g tube 300 g cartridge	General-purpose gel	Clear	0.010	Ethyl	Gel	3,200	-65°F (-54°C) to 180°F (82°C)	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	414™	41404 41450 41461	3 g tube 1 oz. bottle 1 lb. bottle	Plastic bonder	Clear	0.006	Ethyl	110	3,200	-65°F (-54°C) to 180°F (82°C)	Fixture – 20 sec. Full – 24 hrs.	1.05	CFIA Listed, Commercial item std. A-A-3097
	415™	41550 41561	1 oz. bottle 1 lb. bottle	Gap filling metal bonder	Clear	0.008	Methyl	1,500	3,600	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	416™	41650 41661	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	0.008	Ethyl	1,500	3,200	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.05	CFIA Listed, Commercial item std. A-A-3097
	420™	42050 42061	1 oz. bottle 1 lb. bottle	Wicking type plastic bonder	Clear	0.002	Ethyl	2	2,900	-65°F (-54°C) to 180°F (82°C)	Fixture – 20 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	422™	42250 42261	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	0.008	Ethyl	2,500	3,200	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.09	CFIA Listed, Commercial item std. A-A-3097
	430™	43004 43050 43061	3 g tube 1 oz. bottle 1 lb. bottle	Metal bonder for close-fitting parts	Clear	0.005	Methyl	80	3,600	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	444™	12292 20419 12294	20 g bottle 20 g kit/ 1 lb. bottle	Wire tacking	Clear	0.007	Ethyl	700	3,200	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	495™	49504 49550 49561	3 g tube 1 oz. bottle 1 lb. bottle	General-purpose	Clear	0.004	Ethyl	45	2,060	-65°F (-54°C) to 250°F (121°C)	Fixture – 5 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	496™	49650 49661	1 oz. bottle 1 lb. bottle	General-purpose rubber bonder	Clear	0.005	Methyl	125	3,600	-65°F (-54°C) to 180°F (82°C)	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	498™	49850 49861	1 oz. bottle 1 lb. bottle	Thermal cycling	Clear	0.007	Ethyl	500	3,000	-65°F (-54°C) to 180°F (82°C)	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
	454™	39202	0.14 oz. bottle	General gel	Clear	0.010	Ethyl	Gel	3,200	-65°F (-54°C) to 250°F (121°C)	Fixture – 15 sec. Full – 24 hrs.	1.05	N/A

Loctite® Primer & Accelerator Properties Chart

	LOCTITE® PRODUCT	ITEM	PACKAGE TYPE & SIZE	COLOR	VISCOSITY (cP)	BASE	ON-PART LIFE	DRY TIME	APPLICATION	AGENCY APPROVALS
SURFACE PREPARATION	ACCELERATORS	SF 712™	20352 18636 18390	1.75 fl. oz. bottle 0.7 fl. oz. metered mist 1 gallon can	Clear/Amber	1	Isopropanol	1 minute	<30 seconds	All cyanoacrylates MIL-46050C for existing designs, CFIA Listed
		SF 7109™	22440 23034	1.75 fl. oz. bottle 1 quart can	Clear/Amber	3	Perfluorocarbon	1 minute	<5 seconds	All cyanoacrylates N/A
		SF 7113™	19605 19606 1806199	1.75 fl. oz. bottle 1 gallon can 313 lb. drum	Clear	0.4	Heptane	24 hours	<1 minute	All cyanoacrylates N/A
		SF 7452™	18490 18580 18637 18575 18576	1.75 fl. oz. brush-top bottle 1.75 fl. oz. spray-cap bottle 0.7 fl. oz. metered mist 1 quart can 1 gallon can	Clear/Amber	0.4	Acetone	1 minute	<30 seconds	All cyanoacrylates MIL-46050C for existing designs
	PRIMERS	SF 770™	18396 18397	1.75 fl. oz. bottle 16 fl. oz. can	Colorless, Slightly Hazy	1.25	Heptane	8 hours	30 seconds	All cyanoacrylates CFIA Listed
		SF 7951™	27858	1.75 fl. oz. bottle	Colorless, Slightly Hazy	0.7	Perfluorocarbon and Chlorobenzotrifluoride	8 hours	30 seconds	All cyanoacrylates N/A

PLEASE NOTE: A complete line of surface primers, accelerators and cleaners is available to further enhance the performance of LOCTITE® Instant Adhesives. Refer to the Surface Cleaning section on page 129.