



# LOCTITE<sup>®</sup> 5810A<sup>™</sup>

November 2008

## PRODUCT DESCRIPTION

LOCTITE<sup>®</sup> 5810A<sup>™</sup> provides the following product characteristics:

<b>Technology</b>	Formed-In-Place Gasketing
<b>Chemical Type</b>	Polyacrylate
<b>Appearance (uncured)</b>	Black paste <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Thixotropic</b>	Reduced migration of liquid product after application to substrate
<b>Cure</b>	Moisture cure
<b>Application</b>	Sealing

LOCTITE<sup>®</sup> 5810A<sup>™</sup> is a single component, non-silicone, oxime-free, polyacrylate based adhesive/sealant that cures with moisture at room temperature. It is designed with a heavy body viscosity for on line, low air pressure tests to be carried out before product begins to cure. The non-silicone based resin does not promote foaming in lubricants and exhibits excellent resistance to powertrain fluids. LOCTITE<sup>®</sup> 5810A<sup>™</sup> is primarily designed for flange sealing with excellent oil resistance. Typical applications include cast metal, stamped steel, and molded plastic covers for engines, transmissions and axles. This product also works well for sealing plastic and metal housings on electronic components.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 20 °C	1.25 to 1.45 <sup>LMS</sup>
Flash Point - See MSDS	
Extrusion Rate, g/min:	
Pressure 0.6 MPa, temperature 25 °C:	
Semco Cartridge	25 to 85 <sup>LMS</sup>
Blow Out Resistance, seconds:	
6 mm Flange, 1.0 mm Gap @ 0.014 MPa	10

## TYPICAL CURING PERFORMANCE

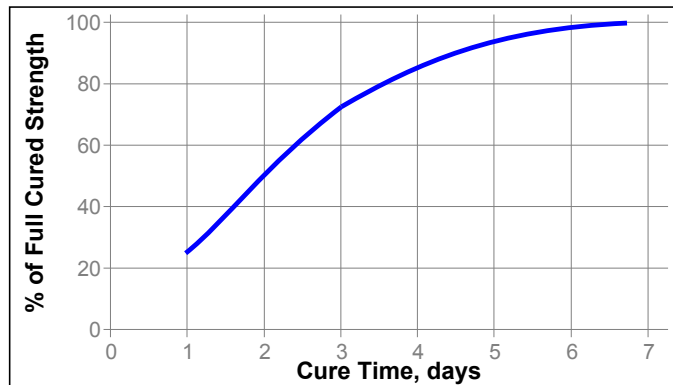
### Skin Over Time

Skin over time is the time the surface of the adhesive forms a skin upon exposure to atmospheric moisture at 25 ± 2 °C, 50 ± 5% RH.

Skin Over Time, minutes	≤120 <sup>LMS</sup>
-------------------------	---------------------

### Cure Speed vs. Time

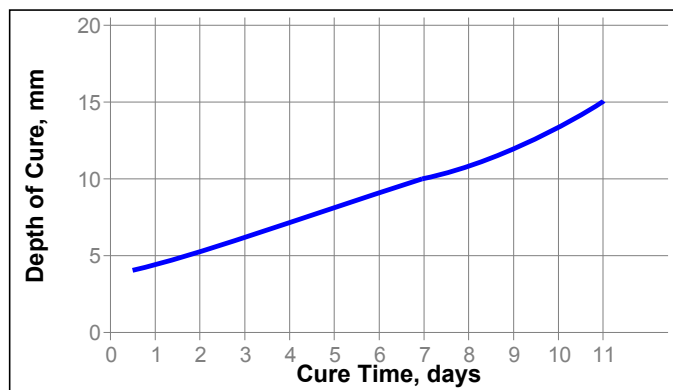
The graph below shows shear strength developed with time on Aluminum (Alclad) lapshears at a bond gap of 1.0 mm. Cure condition 25±2 °C / 50±5% RH. Strength is determined according to ISO 4587.



### Depth of Cure

The depth of cure depends on temperature and humidity. Depth of cure was determined by filling a 15 mm deep cup and removing the cured film of material. The cured section of product is measured to determine depth of cure.

The graph below shows the increase in depth of cure with time at 25±2 °C / 50±5 % RH.



## TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 1 week @ 25 °C / 50±5 % RH

### Physical Properties:

Glass Transition Temperature, °C	-45
Shore Hardness, ISO 868, Durometer A	18 to 35 <sup>LMS</sup>
Elongation, at break, ISO 37, %	≥150 <sup>LMS</sup>
Tensile Strength, ISO 37	N/mm <sup>2</sup> ≥1.0 <sup>LMS</sup> (psi) (≥145)



**TYPICAL PERFORMANCE OF CURED MATERIAL****Adhesive Properties**

After 7 days @ 25±2 °C / 50±5 % RH and 1.0 mm gap

Lap Shear Strength, ISO 4587:

Alclad to Mild steel	N/mm <sup>2</sup>	1.1
	(psi)	(160)
Alclad to Alclad	N/mm <sup>2</sup>	≥1.0 <sup>LMS</sup>
	(psi)	(≥145)

**TYPICAL ENVIRONMENTAL RESISTANCE****Environmental Aging - Effect on bulk properties**

Cured for 7 days @ 25±2 °C / 50±5% RH and 2 mm thick film

Tensile strength, ISO 37, N/mm<sup>2</sup> (Elongation, at break, %):

Environment	100 h	500 h	1000 h
Control, 22 °C	1.5(206)	-----	-----
ATF, 150 °C	2.0(141)	2.2(149)	2.0(111)
SF105 engine oil, 150 °C	1.9(123)	1.9(140)	2.1(110)
Synthetic gear oil, 150 °C	1.9(138)	2.0(136)	2.2(103)
Air at 150 °C	2.7(203)	2.6(168)	2.7(137)

**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. For best performance bond surfaces should be clean and free from grease.
2. Assemble parts within 60 minutes. When joint is assembled, pressure should be applied to spread the adhesive out and fill the joint completely.
3. The bond should be allowed to cure (e.g. seven days), before subjecting to heavy service loads.
4. Excess material can be easily wiped away with non-polar solvents.

**Loctite Material Specification<sup>LMS</sup>**

LMS dated July 23, 2008. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**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.

**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/mm<sup>2</sup> 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

**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.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.3