



LOCTITE[®] A-534R[™]

January 2009

PRODUCT DESCRIPTION

LOCTITE[®] A-534R[™] provides the following product characteristics:

Technology	Activator
Chemical Type	Acrylic
Appearance	Red ^{LMS}
Viscosity	Very low
Cure	Not applicable
Solids Content	100%
Application	Cure accelerator
Product Benefits	<ul style="list-style-type: none"> • User Friendly • Requires no drying time • Environmentally friendly

LOCTITE[®] A-534R[™] is designed to initiate the cure of Loctite toughened acrylic adhesives. This product is safe to use in production environments, as it is nonflammable, and contains no solvents. Because the product is solvent free, parts can be bonded immediately after the activator is applied to the bonding surface and requires no drying time.

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.98
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP): Spindle 1, speed 20 rpm	≤50 ^{LMS}
Flash Point - See MSDS	

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using LOCTITE[®] A-534R[™] depend on the adhesive used and the substrate bonded.

Fixture Time, ISO 4587, seconds: Steel (degreased) using LOCTITE [®] A-533 [™] , single side activation	≤30 ^{LMS}
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(Fixture time is defined as the time to develop a shear strength of 0.1 N/mm²)

TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 15 minutes @ 25 °C, using LOCTITE[®] A-533[™], single side activation

Lap Shear Strength, ISO 4587: Steel (degreased)	N/mm ² ≥8.3 ^{LMS} (psi) (≥1,203)
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Cured for 24 hours @ 25 °C, using LOCTITE[®] A-533[™], single side activation

Lap Shear Strength, ISO 4587: Steel (degreased)	N/mm ² ≥13.8 ^{LMS} (psi) (≥2,001)
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GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected with a sealant for chlorine or other strong oxidizing materials.

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

Under no circumstances should activator and adhesive be mixed directly as liquids.

Use only in a well ventilated area

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

Directions for use:

1. Apply LOCTITE[®] A-534R[™] by spraying, wiping, or brushing a thin film of the activator onto one of the bonding surfaces.
2. Apply the Adhesive to the bond area on the non-activated bonding surface.
3. Join surfaces with sufficient pressure to maintain intimate contact between the parts until handling strength is obtained.
4. A 15 to 30 second clamp time is usually required for bonding of parts with minimal gap.

Loctite Material Specification^{LMS}

LMS dated November 21, 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: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note

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Reference 0.0