

LOCTITE 380 provides the following product characteristics:

	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Black liquid <sup>LMS</sup>
Components	One part - requires no mixing
Viscosity	Medium
	Humidity
	Bonding
Key Substrates	Metals, Plastics and Rubbers

LOCTITE 380 is a rubber toughened adhesive with increased flexibility and peel strength along with enhanced resistance to shock.

Specific Gravity @ 25 °C 1.1  
 Viscosity, Brookfield - RVT, 25 °C, mPa s (cP):  
 Spindle 3, speed 50 rpm, 100 to 800<sup>LMS</sup>

Flash Point - See SDS

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22 °C / 50 % relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm .

Fixture Time, seconds:	
Steel (degreased)	60 to 120
Aluminum	10 to 30
Neoprene	15 to 25
Rubber, nitrile	15 to 25
ABS	20 to 50
PVC	50 to 100
Polycarbonate	30 to 90
Phenolic	20 to 60

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Where cure speed is unacceptably long due to large gaps, applying activator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

After 24 hours @ 22 °C

Coefficient of Thermal Expansion, ISO 11359-2, K<sup>-1</sup> 80 · 10<sup>-6</sup>  
 Coefficient of Thermal Conductivity, ISO 8302 0.1 W/(m K)  
 Glass Transition Temperature, ASTM E 228, 120 °C  
 Dielectric Constant / Dissipation Factor, IEC 60250:  
 0.05 kHz 2.65 / <0.02  
 1 kHz 2.75 / <0.02  
 1,000 kHz 2.75 / <0.02  
 Volume Resistivity, IEC 60093, cm 10 · 10<sup>15</sup>  
 Dielectric Breakdown Strength, IEC 60243-1, kV/mm 25

After 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:  
 Steel (grit blasted) N/mm 26 (psi) (3,770)  
 Aluminum (etched) N/mm 18 (psi) (2,610)  
 ABS N/mm >6 (psi) (>870)  
 PVC N/mm >4 (psi) (>580)  
 Polycarbonate N/mm >5 (psi) (>725)  
 Phenolic N/mm 10 (psi) (1,450)  
 Neoprene N/mm >10 (psi) (>1,450)  
 Nitrile N/mm >10 (psi) (>1,450)  
 Tensile Strength, ISO 6922:  
 Steel (grit blasted) N/mm 18.5 (psi) (2,700)

After 48 hours @ 22 °C

Lap Shear Strength, ISO 4587:  
 Steel (grit blasted) N/mm 17.2<sup>LMS</sup> (psi) (2,495)





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

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.

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

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