

LOCTITE HHD 6006

February 2018

PRODUCT DESCRIPTION

LOCTITE HHD 6006 provides the following product characteristics:

Technology	2K-Polyurethane
Technology (Part A)	Polyol
Technology (Part B)	Polyisocyanate
Appearance - Part A Polyol	Blue paste
Appearance - Part B Iso	Off-white to light yellow paste
Appearance (cured)	Blue
Mix Ratio by weight, Part A:Part B	100 : 200
Mix Ratio by volume: Part A: Part B	1 : 2
Cure	Two component cure after mixing
Product Benefits	• High viscosity • Sag resistant • Low modulus • High Impact resistance

LOCTITE HHD 6006 two component polyurethane adhesive is designed for use in electronic device assembly applications. This material reacts when mixed and is fully cured at room temperature. Cure can be accelerated with application of heat.

TYPICAL PROPERTIES OF UNCURED MATERIAL**Part A Properties (Polyol)**

Specific Gravity @ 25°C, g/ml	1
Viscosity @ 25°C, mPa·s (cP):	
Spindle 7, Speed 100 rpm	36,500
Flash Point, °C	>93

Part B Properties (Polyisocyanate)

Specific Gravity @ 25°C g/ml	1.2
Viscosity @ 25°C, mPa·s (cP):	
Spindle 7, speed 100 rpm	15,000
Flash Point, °C	>188

Mixed Properties

Specific Gravity @ 25 °C	1.1
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Gel Time**

@ 100°C, seconds	120 to 300
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LOCTITE HHD 6006 is cured after mixing at room temperature.

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL**Physical Properties**

Hardness, Shore D	47.5
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TYPICAL PERFORMANCE OF CURED MATERIAL

Sample cured 20 minutes @ 50°C plus 24 hours @ 25°C, 50 % RH.

Physical Properties**Lap Shear Strength:**

IXEF	N/mm ²	5.52
	(psi)	(801)
Aluminum	N/mm ²	8.69
	(psi)	(1,261)
Stainless Steel	N/mm ²	6.3
	(psi)	(914)

Lap Shear Strength:

@-20°C, IXEF	N/mm ²	6.36
	(psi)	(922)
@-20°C, Aluminium	N/mm ²	10.3
	(psi)	(1,491)
@-20°C, Stainless Steel	N/mm ²	15.5
	(psi)	(2,248)

Impact Strength:

IXEF, J	8.7
Aluminum, J	13.4
Stainless Steel, J	8.9

Impact Strength:

@-20°C, IXEF, J	8.36
@-20°C, Aluminium, J	13.2
@-20°C, Stainless Steel, J	9

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. This product should not be selected as a sealant for chlorine or other strong oxidizing materials.

STORAGE:

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

Optimal Storage : 21 to 28 °C

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

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{inches}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{psi} \times 145 = \text{N/mm}^2$$

$$\text{MPa} = \text{N/mm}^2$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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