

Description

Loctite® EA 9460PB is a high strength, durable two-part epoxy adhesive specially developed for the fabricating offset printing blankets. This adhesive has the same high performance properties of 9460 with the longer work life needed for blanket assembly. Loctite® EA 9460PB bonds a variety of materials and gives especially good results on aluminum, spring steel, and fabric reinforced rubber printing blanket stock.

Features

- Bonds All Printing Blanket Stock
- Long work life
- Good Peel Strength
- Non-Sag Slump Resistant
- Good Tensile Shear Strength
- Easily Mixed/Easily Dispensed

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 100 grams mins	--	--	95 to 110
Color	White	Black	Grey
Viscosity, cP	150,000 to 300,000	50,000 to 150,000	150,000 to 250,000
Specific Gravity	1.35	1.31	1.33
Mix Ratio			
By weight	100	100	--
By volume	1	1	--

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
16 Hours @ 77°F	77	1500
24 Hours @ 77°F	77	2000
48 Hours @ 77°F	77	2250

Right Angle Peel Strength	Steel to Blanket Stock, pli
3 Days @ 77°F	15

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).

Handling

Mixing: This product requires mixing two components together just prior to the application. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but they should be at room temperature.

Application

Mixing – Bulk: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly. Continue to mix until all white and

black streaks are gone and mix is uniformly gray. This is important! Heat build-up during or after mixing is normal. Do not mix quantities greater than two pounds as dangerous heat build-up can occur causing uncontrolled decomposition of the mixed adhesive. Mixing smaller quantities will minimize the heat build-up.

Application: Bonding surfaces should be clean and dry. Once the adhesive is applied, the bonded parts should be held in contact until the part has developed handling strength. It is not necessary to clamp the parts unless movement during curing is likely.

Cure: Loctite® EA 9460PB may be cured for three days at room temperature to achieve full performance. Hot fixtures or presses up to 350°F can be used to accelerate cure. The adhesive can be fully cured in as little as 10 minutes at this temperature. Other temperatures and times should be determined experimentally for each type of blanket design. Care must be given not to damage the elastomeric substrates.

Clean-up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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