



## Technical Information

### Product Description

Lockfast® LF406 a low viscosity instant adhesive formulated for rapid adhesion of rubbers and plastics such as nylon, PBT, PEI, polyurethane, and EPDM. Its surface-insensitive properties allow it to effectively bond a wide range of substrates to themselves and to other materials.

### Physical Properties

Liquid State		Cured State	
Base	Ethyl Cyanoacrylate	Colour	Clear
Colour	Clear	Specific Gravity (20°C)	1.1-1.2
Specific Gravity (20°C)	1.06	Service Temperature	-55 °C to 80°C
Refraction Index (n 20D)	1.439	Refractive Index (n 20D)	1.49
Flash Point (°C)	>80°C	Dielectric Constant (at 10MHz)	3.5
Shelf Life	12 months	Soluble in Acetone, Nitromethane.	
Boiling Point	65°C at 16mmHg		
Viscosity (cP)	10-30		

### Bond Strength

(Tensile shear strength, cured for 24 hours at 20-25°C)

Substrate	N/mm <sup>2</sup>
Rigid PVC to Rigid PVC	4 to 6
ABS to ABS	5 to 7
Nitrile Rubber to Nitrile Rubber	5 to 9
Stainless steel to Stainless steel	15 to 18
Aluminium to Aluminium	17 to 19

### Fixture Time vs. Humidity

Instant adhesives require surface moisture on the substrates in order to initiate the curing mechanism. The speed of cure is reduced in low-humidity conditions.

### Storage

Store in a cool area and out of direct sunlight. Refrigeration to 5°C gives optimum storage stability.

### General Information

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

### Disclaimer

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### Available Sizes

20g / 50g Bottles

### Hot Strength

Lockfast® instant adhesives are suitable for use at temperatures up to 80°C. At 80°C the bond will be approximately 70% of the strength at 21°C.

### Chemical/Solvent Resistance

Lockfast® instant adhesives exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol and isopropanol. Cyanoacrylates are generally not resistant to high levels of moisture or humidity over extended periods of time.

### Fixture Time vs. Bond Gap

Lockfast® instant adhesives give best results on close fitting parts. The product should be applied in a very thin line in order to ensure rapid polymerisation and a strong bond. Excessive bond gaps will result in slower fixture times.

### Fixture Time vs. Activator

Lockfast® instant adhesive Activator LF786 may be used with instant adhesives where a faster cure speed is required. Fixture times of less than 2 seconds can be obtained with most cyanoacrylates. Testing on the parts to measure the effect is recommended.

At Cyanotec, we are committed to providing you with personalized guidance to identify the most suitable solution for your needs. If you are aware of the product you require and would like to receive a quote, please feel free to call us at 01384 294 753. Alternatively, you may email your specifications to sales@cyanotec.com, and we will promptly prepare a quote for you.