

LOCTITE[®] 150460™

Known as LOCTITE[®] 11264 Cup Plug Sealant™
April 2015

PRODUCT DESCRIPTION

LOCTITE[®] 150460™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	Opaque, blue liquid ^{LMS}
Fluorescence	Positive under UV light ^{LMS}
Components	One component - requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Application	Sealing
Strength	High
Specific Benefit	<ul style="list-style-type: none"> Large gap filling capabilities (0.25 mm) Will not crack or shrink

LOCTITE[®] 150460™ applications include sealing core plugs in engines and the assembly and repair of damaged or loose fitting parts. It solidifies at room temperature when confined between metal surfaces. After curing, this product produces an effective seal against leakage and high shear strength resistance to loosening.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 5, speed 2.0 rpm,	40,000 to 85,000 ^{LMS}
Spindle 5, speed 20 rpm	8,000 to 20,000 ^{LMS}

TYPICAL CURING PERFORMANCE

Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, hours	≤1.0
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Curing Properties

Full Cure Time @ 22 °C, hours	≤72
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TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Elongation, %	2
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TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

After 24 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm ² ≥14 ^{LMS} (psi) (≥2,030)
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After 48 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm ² ≥14 ^{LMS} (psi) (≥2,030)
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TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 48 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	
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Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength
		1000 h
Air	22	140
Air	130	120
Motor oil (5W30)	150	130
Motor oil (5W30 -Synthetic)	150	130
ATF	150	120
Differential lube	150	150
Gasoline	22	125
Gasoline (E85)	22	135
Diesel fuel #2	22	140
Water/glycol	130	85
Water/Ext. life Coolant (50/50)	130	105

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 Safety Data Sheet (SDS).

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.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use:

1. For best results, excessive contamination such as grease, heavy oils or dirt should be removed using a LOCTITE® cleaning solvent and allow to dry.
2. LOCTITE® 150460™ can be applied directly from containers by hand or by brush or it can be applied using automatic application equipment such as a roto-spray.

Loctite Material Specification^{LMS}

LMS dated February 26, 1996. 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: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °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:

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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Reference 0.2