

LOCTITE® AA 5182™

Known as LOCTITE® 5182™
January 2019

PRODUCT DESCRIPTION

LOCTITE® AA 5182™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Methacrylate ester
Appearance (uncured)	Red gel-like material ^{LMS}
Fluorescence	Positive under UV light ^{LMS}
Components	One component - requires no mixing
Viscosity	High, thixotropic
Cure	Anaerobic
Application	Sealing
Strength	Medium

LOCTITE® AA 5182™ is a single component, medium strength, anaerobic sealant with fast curing properties which cures when confined in the absence of air between close fitting metal surfaces. LOCTITE® AA 5182™ is used to seal gaskets, housings, cases and covers. The thixotropic nature of LOCTITE® AA 5182™ reduces the migration of liquid product after application to the substrate.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.1

Flash Point - See SDS

Viscosity, Brookfield - HBT, 25°C, mPa·s (cP):

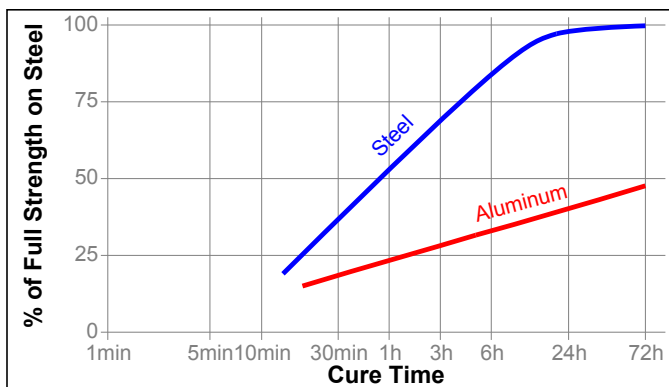
Spindle TB, speed 0.5 rpm, Helipath 300,000 to 900,000^{LMS}

Spindle TB, speed 5.0 rpm, Helipath 85,000 to 200,000^{LMS}

TYPICAL CURING PERFORMANCE

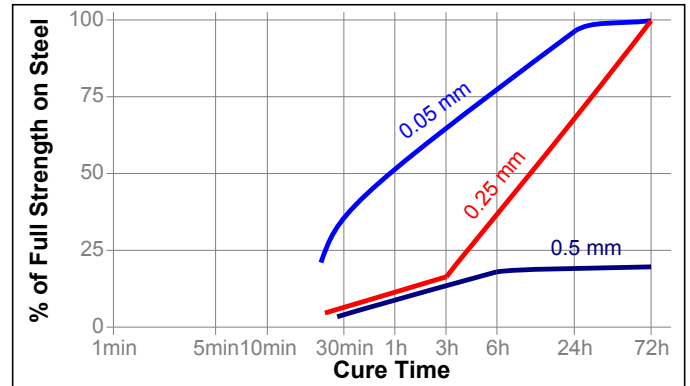
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587.



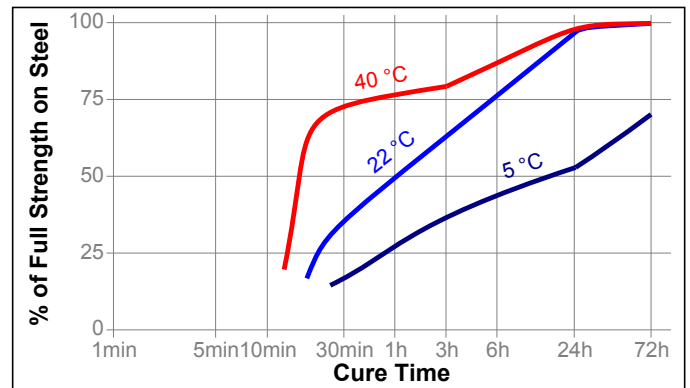
Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows the shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ISO 4587.



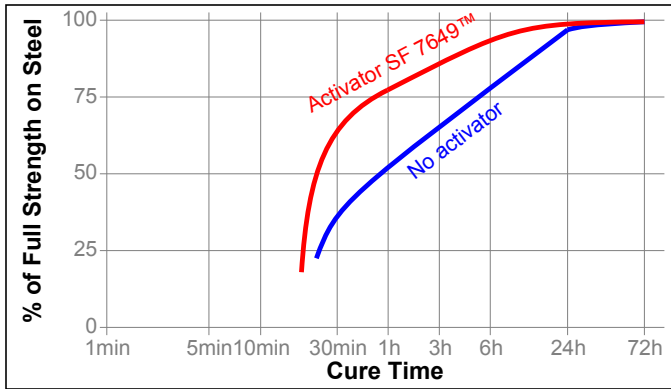
Cure Speed vs. Temperature

The rate of cure will depend on the ambient temperature. The graph below shows the shear strength developed with time at different temperatures on grit blasted steel lap shears and tested according to ISO 4587.



Cure Speed vs. Activator

Where cure speed is unacceptably long, or large gaps are present, applying activator to the surface will improve cure speed. The graph below shows the shear strength developed with time on grit blasted steel lap shears using Activator 7649™ and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹	10×10 ⁻⁴
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 1 hour @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm ² (psi)	≥5.5 ^{LMS} (≥797.5)
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Cured for 24 hours @ 22 °C

Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm ² (psi)	≥6.0 ^{LMS} (≥870)
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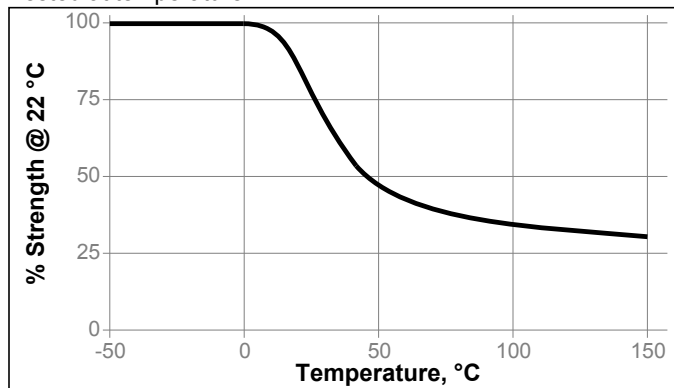
TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 1 week @ 22 °C

Lap Shear Strength, ISO 4587: Steel (grit blasted)

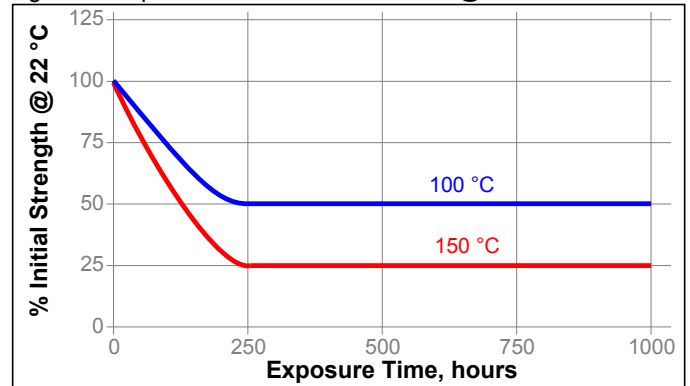
Hot Strength

Tested at temperature



Heat Aging

Aged at temperature indicated and tested @ 22 °C



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C

Environment	°C	% of initial strength	
		300 h	800 h
Motor oil	87	165	140
Unleaded gasoline	87	80	65
Brake fluid	87	20	10
Water/glycol 50/50	87	120	85
Isopropanol	87	20	10
Salt fog	22	85	80

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 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 performance bond surfaces should be clean and free from grease.
2. LOCTITE® AA 5182™ can replace most gaskets up to 0.5 mm in thickness, and can coat hard or soft cut gaskets to improve sealing performance.
3. This product is best applied by a machine dispenser in a continuous bead.
4. Low pressures (<0.05 MPa, psi) may be used when testing to confirm a complete seal immediately after assembly and before curing.
5. Flanges should be tightened as soon as possible after assembly to avoid shimming.

Loctite Material Specification^{LMS}

LMS dated September 01, 1995. 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 1.3