

Description

LOCTITE® EA 9340 is a general purpose adhesive with exceptional high temperature performance. This easy to use epoxy is can be used in many demanding applications where resistance to chemicals and heat extremes are required. LOCTITE® EA 9340 can be used on many different substrates such as wood, metal, ceramics, and most plastics. This exceptional epoxy can be sanded and drilled and painted after curing making it ideal for finish work.

Features

Excellent Heat Resistance
 Good Tensile Shear Strength
 Resistant to Automotive Fluids
 Sandable
 Easy to Mix

Application

Mixing: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly. Continue to mix until all green and gray 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 one pound as excessive exotherm or heat build-up will develop. Mixing smaller quantities will minimize the heat build-up.

Application: Bonding surfaces should be clean and dry. The bonded parts should be held in contact until the adhesive is set. It not necessary to maintain fixturing for the entire cure schedule but only until handling strength is achieved.

Cure: LOCTITE® EA 9340 can be cured by a variety of cure schedules to meet processing requirements. LOCTITE® EA 9340 will achieve handling strength in 6-8 hours at room temperature (note: this can vary with different bond configurations and ambient temperatures). Full cure time at 77°F is 24 hours. Heat cures can be used to shorten this time. For instance, one hour at 180°F or 2 hours at 140°F is sufficient to fully cure the adhesive.

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 solvent supplier for 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.

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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Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 100 grams mins	--	--	90
Color	Green	Grey	Grey
Viscosity, cP	Paste	Paste	Paste
Specific Gravity	--	--	--
Mix Ratio			
By weight	1	1	--
By volume	1	1	--

Typical Properties	Typical Value
Hardness, Shore D	>80

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
3 Days @ 77°F	-40	2100
	77	2300
	180	1850

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: LOCTITE® EA 9340 requires mixing Part A and Part B together just prior to the application. Complete mixing of the two components is necessary.

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