

Instant Adhesives

How to apply LOCTITE® 401, 454, 3090

1. Preparation

Cleaning

It is recommended to use LOCTITE® 7063 to degrease and clean surfaces prior to applying the adhesive.



Priming

To improve adhesion on difficult to bond plastic surfaces, apply LOCTITE® 7239 or LOCTITE® 770 to the bond area by brushing or dipping. Avoid applying excess primer. Allow the primer to dry.



Activation

If cure speed is too slow, use appropriate activator LOCTITE® 7458 (see cure speed vs. activator graph in the TDS). Apply activator to one bond surface by spray, brush or dipping (not to primed surfaces). Allow the activator to dry.



Mixing

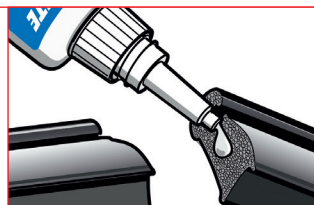
Mixing with static mixer (LOCTITE® 3090):

Before mounting the static mixer onto the cartridge, push out small amount of product to equalize pistons. Mount static mixer and push some mixed product out until a uniform color is reached, then the static mixer provides a well mixed product.



2. Application

Apply adhesive by drop or bead to one of the bond surfaces (not to activated surfaces).



Equipment

Recommended dispensing equipment: (see chapter **Equipment**)

- For precise dispensing of small amounts of adhesive use dispensing needles
- Spare static mixers for Loctite® 3090: IDH 1453183

3. Assembly

Assemble the parts immediately. The parts should be accurately located, as the short fixture time leaves little opportunity for adjustment. Bond should be held fixed or clamped until the adhesive has fixtured.

Hint:

If necessary excess product can be cured by activator LOCTITE® 7455. Spray or drop activator on excess product.

