

Structural Bonding – Epoxies

How to apply LOCTITE® 9492, 3430, Double Bubble

1. Preparation

Cleaning

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



Mixing

- **Hand mixing (LOCTITE® 3430, Double Bubble):**

Mix A and B components according to the specified mixing ratio.
Thoroughly mix the two components before use



- **With static mixer (LOCTITE® 9492):**

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

2. Application

Apply product directly after mixing to the bonding area.

Hint:

After use, leave the static mixer in place and use it as a cap.



Equipment

- Recommended dispensing equipment for LOCTITE® 9492 (see chapter **Equipment**): IDH 267452
- Spare static mixers: IDH 1487440

3. Assembly

- Parts should be assembled immediately
- Keep the assembled parts from moving during curing
- The joint should be allowed to develop full strength before subjecting to any service load

Hint:

Excess of uncured product can be wiped away with LOCTITE® 7063.