Technical Data Sheet

LOCTITE CR 6127 SB 15 / LOCTITE CR 4300

August 2023

PRODUCT DESCRIPTION

LOCTITE CR 6127 SB 15 / LOCTITE CR 4300 provides the following product characteristics:

Technology	Polyurethane
Product Type	PU Adhesive
Cure	Polyaddition
Condition	Solvent-free
Components	Two-components
Component A	Resin
Component B	Hardener
Application	Assembly
Color (Comp. A)	Black
Color (Comp. B)	Clear brown
Mixing Ratio, by weight Comp. A : Comp. B	100 : 15

LOCTITE CR 6127 SB 15 / LOCTITE CR 4300 is a solvent-free two-component adhesive, based on polyurethane. The resin part (component A) contains organic compounds with hydroxyl groups, the hardener (component B) is based on isocyanates.

By mixing both components in a mix ratio of 100 : 15 a hard elastic product is formed through chemical reaction. After curing the product exhibits no measurable change in volume.

Application Areas:

LOCTITE CR 6127 SB 15 / LOCTITE CR 4300 is used for filling, coating and casting. The product adheres well to metals and plastics. It contains flame retardant additives. It is qualified for the casting of telecommunication articles (internal and external usage), transformers and other electrical and electronical equipment.

TECHNICAL DATA

Component A
Loctite CR 6127 SB 15:

Consistency	liquid
Density (20°C), g/cm³	1.46 to 1.56
Viscosity, Brookfield - RVT, 20°C, mPa.s	8,000 to 14,000

Component B
Loctite CR 4300:

Consistency	liquid
Density (20°C), g/cm³	1.18 to 1.28
Viscosity, Brookfield - RVT, 20°C, mPa.s * Henkel method 10	40 to 70

Mixture (Component A + B):

Consistency	liquid
Viscosity, Brookfield - RVT, 25 °C, mPa.s	2,200 to 3,000
Pot life (180g, 25°C), min* Henkel method 21	11.5 to 18.5
Shore A hardness ISO 868	79 to 89
Coeff. of Thermal Expansion, ppm/K:	135
Thermal Conductivity, W/mK: ASTM E 1464-01	0.61

All technical data based on Henkel test method.
Data with * are specified.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Pretreatment:

The substrate should be clean, dry, free of dust, oil, grease and other contaminants. The usage of suitable primers on metal surfaces can improve the adhesion and/or the long-term bond stability. The surface of plastic materials should be cleaned, so as to remove any kind of release agents present on the substrate surface. An improvement of the adhesion can be achieved by grinding or sandblasting the surface.

Application:

Component A must be properly and slowly homogenized before use.
The filler in Loctite CR 6127 SB 15 will settle upon prolonged storage. The resin must be thoroughly mixed before combining with Loctite CR 4300. The components can be mixed manually either by using mixing equipment or by using machinery with a two-component application equipment and inclusion of air must be prevented. The casting resin is only to be used within a limited time (potlife). After this time the mixture gels up and is not suitable for use. Therefore only the amount that can be applied within the time of potlife should be mixed. The potlife depends on the quantity and temperature of the mixed batch. With larger quantities and an increase in temperature, the potlife decreases. Lower temperatures extend the potlife. Casting resin components should not come into contact with moisture during the storage or application. Contact with moisture (water vapour) generates foaming of the casting resin. Therefore all packaging should be sealed properly and protected

against humidity during storage.

Curing:
LOCTITE CR 6127 SB 15 / LOCTITE CR 4300 can be cured between 15°C and elevated temperatures (up to 60 °C). The curing time will be reduced substantially with increasing temperatures. The addition of chemical catalysts (accelerators) also speeds up the curing reaction (i.e. pot life, open time).

Cleaning:
Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with LOCTITE SF 8040; cured adhesive can only be removed mechanically.

Classification:
Please refer to the corresponding **Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

Storage:

Component A

Recommended storage temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	12 months

Component B

Recommended storage temperature, °C	15 to 30
Shelf-life (in unopened original packaging)	9 months

ADDITIONAL INFORMATION

Disclaimer

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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Reference N/A

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