



LOCTITE® SI 5486™

June 2017

PRODUCT DESCRIPTION

LOCTITE® SI 5486™ provides the following product characteristics:

Technology	Cured-In-Place Gasketing
Chemical Type	2k silicon
Appearance (uncured)	Smooth, black
Component A	White
Component B	Black
Mix ratio by vol, resin to hardener	1:1
Thixotropic	Reduced migration of liquid product after application to substrate
Cure	Room temperature or heat
Application	Gasketing and sealing

LOCTITE® SI 5486™ has been designed specifically for gasketing applications. It withstands on line, low pressure tests carried out before product begins to cure. This product can be used in static compression gasket applications for automotive power train and related components. Typical applications include cam covers, oil pans, rear seal retainers, transmission covers, axle covers and module housings.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A

Viscosity (Brookfield, 25°C, 7#, 10rpm) 150~200 Pa s

Part B

Viscosity (Brookfield, 25°C, 7#, 10rpm) 100 ~150 Pa s

TYPICAL CURING PERFORMANCE

Surface Cure

Working time minutes:

@ 25 °C ~ 120s

TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 24h @ 25 °C

Density, g/cm³ 0.4-0.55

Hardness shore A 12-15

Vollume expansion: >50%

Flame retardancy: UL94V0

Permanent compression set < 4%

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24h @ 25 °C

Tensile strength (GB/T 528-2009) ≥ 0.8MPa

Elongation (GB/T528-2009) ≥ 110%

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).

Directions for use

1. For best performance flange surfaces should be clean and free from grease, oil and dirt.
 2. The product is designed for close fitting flanged parts and flanged parts with torque limiters.
 3. To obtain best results, each application should be evaluated under the specific conditions anticipated for performance and durability of the parts.
 4. The warpage of plastic parts and flatness deviation should be controlled to nil/minimum for effective sealing.
 5. Consult with Henkel Technical team for optimum sealant usage and best performance on specific groove dimensions.
 6. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
 7. Dual Cartridges: Insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. Attach the static mixing nozzle to the end of the cartridge and begin dispensing the adhesive. Purge and dispose of the first 3-5 cm from the end of the mix nozzle, as it may not be sufficiently mixed.
- Bulk Containers: Utilize volumetric dispense system to ensure proper mix ratio and utilize mix nozzle to obtain adequate mixing

Loctite Material Specification^{LMS}

LMS dated January, 2013. 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 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.

Trademark usage

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