



## PL<sup>®</sup> Marine Fast Cure Adhesive Sealant

**Description:** Loctite PL Marine Fast Cure Adhesive Sealant is a fast setting, moisture cure polyether adhesive sealant which delivers strong bonds while forming a watertight, flexible seal above or below the waterline once cured. Free of solvents, phthalates and isocyanates, it will not shrink when cured, discolor from UV exposure, or bubble on damp surfaces. Once cured, it withstands both saltwater and freshwater environments.

**Available As:**

Item #	Size	Package	Color
2020627	3 oz (88 ml)	Carded Tube	White
2016891	10.1 fl oz (295 ml)	Plastic Cartridge	White

**Features & Benefits:**

- Ideal for Through-Hull Fastening & Deck Fittings
- Fast Setting, 24 Hours Cure
- Watertight, Flexible Bond
- Use Above or Below Waterline Once Cured

**Recommended For:**

Loctite PL Marine is recommended for applications such as through-hull fastening, deck fittings, deck to hull joints, portlights, moldings, struts and planking, and stem joints. It adheres to teak and other woods, fiberglass, vinyl, glass, FRP, metal, gelcoat, polycarbonate, and most plastics (test all plastic substrates for bond strength and compatibility before use).

**For Best Results:**

- Not suitable for engine compartment use
- Horizontal applications will require tooling
- Remove all coatings and sealers before application
- Allow treated wood to “cure” for 6 months prior to application per APA guidelines
- Test and evaluate all paints before application
- Do not store in elevated temperatures

**Coverage:**

For a 3 fl. oz. (88 ml) cartridge:

- A 1/4” (6 mm) bead extrudes approximately 9.2 ft. (2.8 m)
- A 3/8” (9.5 mm) bead extrudes approximately 4.1 ft. (1.2 m)

For a 10.1 fl. oz. (295 ml) cartridge:

- A 1/4” (6 mm) bead extrudes approximately 30.9 ft. (9.4 m)
- A 3/8” (9.5 mm) bead extrudes approximately 13.8 ft. (4.2 m)



# TECHNICAL DATA SHEET

## Typical Uncured Physical Properties:

Color:	White	
Appearance:	Thick paste	
Base:	Polyether	
Odor:	Slightly, minty	
Specific Gravity:	1.41	
Viscosity:	1,200,000 ± 400,000 cp	Brookfield, 4 rpm @ 72°F (22°C)
VOC Content:	1.2% by weight	CARB
	15 g/l	SCAQMD rule 1168
Shelf Life:	12 months from date of manufacture (unopened)*	Stored at 70°F (21°C) /50% RH
	*High temperature & high relative humidity may significantly reduce shelf life	
Lot Code Explanation:	#YYDDD # = Letter corresponding to batch number of the day (ie. A=Batch 1) YY = Last two digits of year of manufacture DDD = Day of manufacture based on 365 days in a year Example: A15061 = Batch 1 made on 61st day of 2015 = March 2, 2015	

## Typical Application Properties:

Application Temperature:	Apply between 32°F (0°C) and 100°F (38°C)	
	For best results, apply between 60°F (16°C) and 100°F (38°C)	
Tack-Free Time:	20 to 30 minutes*	*At 72°F and 50% relative humidity
Handling Time:	30 to 60 minutes*	
Cure Time:	24 hours*	
	*Time is dependent on temperature, humidity, porosity of substrate and depth of sealant applied	

## Typical Cured Performance Properties:

Color:	White	
Appearance:	Firm synthetic rubber	
Service Temperature:	-40°F to 200°F (-40°C to 93°C)	
Water Resistant:	Yes	
Paintable:	Yes. All paint should be tested and evaluated before application. Polyurethane and oil-based paints may dry slowly.	
Hardness:	38 - 42	ASTM C661
Shrinkage:	No visible shrinkage after 14 days	
Low Temperature Flexibility:	-10°F (-23°C) Pass ¼" mandrel	ASTM D816
Tensile Strength:	325 - 375 psi	ASTM D412
Maximum At Break:	275 - 325%	ASTM D412

## Directions:

### Tools Typically Required:

Utility knife, caulking gun

### Safety Precautions:

Wear gloves and wash hands after use.

### Surface Preparation:

Ensure all surfaces are clean and free of dirt, oil, wax, loose paint, frost, oxidation and other contaminations. Rubbing alcohol and ammonia water are effective cleaners for surface preparation. Do not use petroleum solvents. Abraded or irregular surfaces are acceptable bonding surfaces but must be cleaned. For use with teak, wipe with alcohol prior to application to remove surface oils. Mask off areas that must be protected.



# TECHNICAL DATA SHEET

**General Preparation:**

The temperature of the product, the surfaces and the working area should be between 32°F (0°C) and 100°F (38°C). For best performance, temperature should be between 60°F (16°C) and 100°F (38°C). Cut tip to desired bead size.

**Application:**

When using the cartridge, place in cartridge gun. Apply to clean surface and smooth sealant or make bond before product skins. When bonding two impermeable materials, such as metal or plastic, brief separation and reassembly of the bonding surfaces to expose the adhesive to atmospheric moisture will often accelerate the cure. In extremely dry environments, local humidification may be needed to initiate curing. Low temperature will slow the cure reaction and heat will accelerate it. Product should not be applied below 32°F (0°C). Allow the assembly to cure for 30 to 60 minutes before handling or machining. Allow 24 hours for cure and before painting. Open containers should be quickly protected from atmospheric moisture.

**Clean-up:**

Clean tools and uncured sealant residue immediately using a solvent such as alcohol. Cured sealant can be removed by abrading or scraping the substrate.

**Storage & Disposal:**

NOT DAMAGED BY FREEZING. Store original, unopened containers in a cool, dry area. Protect unopened containers from water, heat and direct sunlight. Elevated temperatures will reduce shelf life. Take unwanted product to an approved household hazardous waste transfer facility. Hardened material may be disposed of with trash.

**Label Precautions:**

**WARNING! UNCURED SEALANT IRRITATES EYES AND SKIN. MAY CAUSE ALLERGIC SKIN REACTION.**

**WARNING!** Contains amino silane. Avoid eye and skin contact. Prolonged or repeated skin contact with uncured sealant may cause sensitization. Wear gloves and safety glasses when applying product. Remove contact lenses before using sealant. Wash hands after using. **FIRST AID:** For eye contact flush with water for 15 minutes. Call a physician if irritation develops and persists. For skin contact, wash thoroughly with soap and water. If affected by inhalation, remove to fresh air and get medical attention. If ingested, do not induce vomiting; call a physician or Poison Control Center immediately. **DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.**

Refer to the Safety Data Sheet (SDS) for further information.

**Disclaimer:**

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

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Henkel Corporation - Professional & Consumer Adhesives Headquarters - Rocky Hill, CT 06067

[www.henkelna.com](http://www.henkelna.com)

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