LOCTITE®

BEYOND THE BOND

STRUCTURAL ADHESIVES CATALOG



Henkel

Henkel Adhesive Technologies

LOCTITE®

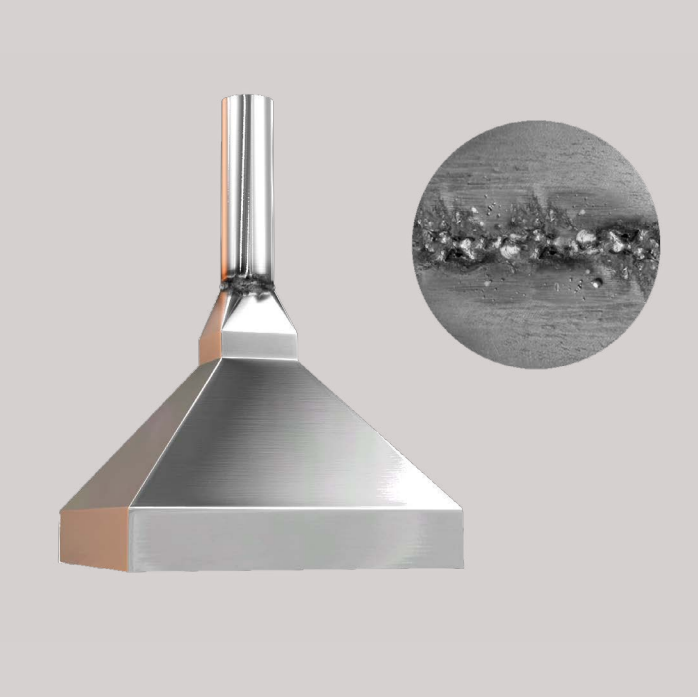
CREATING BONDS *THAT LAST.*

Formulated to provide tough, durable bonds to a wide variety of surfaces within automotive, aerospace, electronics, construction, engineered wood, medical & consumer industries, LOCTITE® structural adhesives create strong, reliable bonding and sealing that outlasts the competition



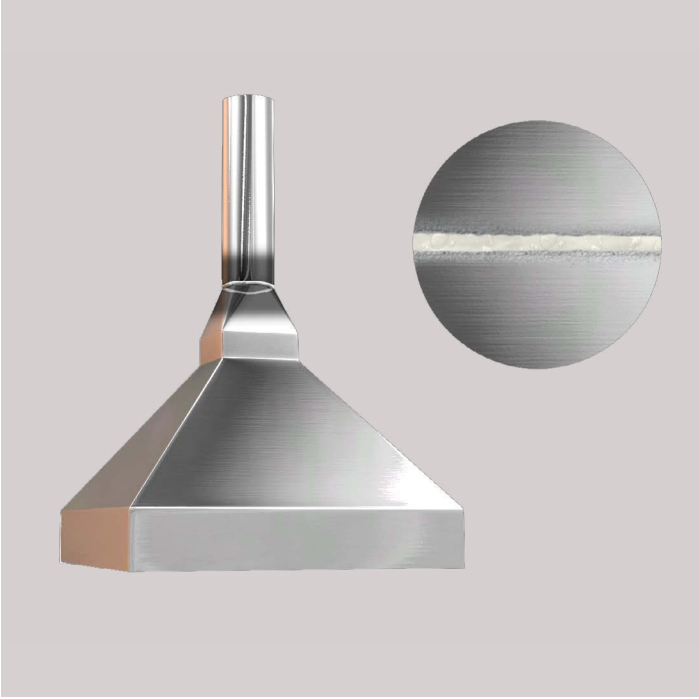
SUPERIOR SPEED, AESTHETICS AND STRENGTH. *WITHOUT THE WEIGHT.*

PROBLEM



With traditional fastening:
Added weight, time, cost and difficulty

SOLUTION



With structural adhesives:
Lightweight, strong, durable, less expensive fastening with better end product aesthetics

LOCTITE®

TAKE OFF THE WEIGHT. ***TAKE ON THE LOAD.***



Structural adhesives join two materials firmly and permanently using an adhesive "bridge" between the substrates. They eliminate many of the shortcomings of mechanical methods, such as:

- Improper stress distribution which can affect product reliabilit
- Added weight to the end-product which can increase cost

They are also easier to apply and assemble. Selection factors to consider include adhesive-material compatibility and joint requirements

HOW TO CHOOSE A STRUCTURAL ADHESIVE

GENERAL PURPOSE vs. *SPECIALTY ADHESIVES*

LOCTITE® has a wide range of structural adhesives, from general purpose — strong and versatile enough to cover the majority of applications, to specialty — formulated for the rare cases where general purpose won't do

HIGH PERFORMANCE

Solutions designed for a range of product needs, with respect to impact strength, peel strength, durability, working time etc.

FLEXIBLE SOLUTIONS

Offering excellent shock absorption, elasticity and adhesion to plastics, metals and glass

SPECIAL SUBSTRATES

From epoxies designed to be safe for food and water contact to acrylics and polyurethanes for bonding e-coated metals, rigid foams, plastics and glass.

BONDING FERRITE COMPONENTS

Epoxies and acrylics designed for the specific requirements of bonding ferrite.

POTTING

Flowable epoxies designed for filling cavities and protecting components

FIXTURE SPEED
A range of fixture times from ultra fast to slow to meet your process requirements.

SUBSTRATE
LOCTITE® structural adhesives can bond most materials

BESTSELLER

EA E-20HP™

FAST FIXTURE, HIGH SHEAR

LOCTITE® EA E-20HP™ is an off-white, 2-part, toughened, medium viscosity, industrial grade epoxy adhesive with a medium work life. The mixture cures at room temperature to form a tough bondline with high peel resistance and high shear strengths. It is resistant to a wide range of chemicals and solvents and is an excellent electrical insulator

Fixture Speed: 120 minutes

Substrate: Concrete, Aluminum, Steel, Stainless Steel, Polyamide (Nylon), Polycarbonate, Wood





BESTSELLER

AA 326™

FAST FIXTURE, SMALL GAPS, 2-STEP

AA 326™ is a yellow to amber, no-mix, medium viscosity (thixotropic) structural and magnet bonder which is activated with LOCTITE® SF 7649™ . It has good adhesion to different types of ferrites, a fixture time of 3 minutes and a shear strength of 2,200 psi. It can be used in temperatures up to 120°C

Fixture Speed: 2 minutes

Substrate: Aluminum, Steel

FIND THE RIGHT PRODUCT *FOR YOUR APPLICATION*

GENERAL PURPOSE

LOCTITE® AA 330™
LOCTITE® EA E-00NS™
LOCTITE® EA E-00CL™
LOCTITE® EA E-05MR™

SPECIALTY ADHESIVES

HIGH PERFORMANCE

WORK LIFE

A range of life times from fast to slow to meet your process requirements

< 1 Hour

LOCTITE® AA H4800™
LOCTITE® AA H8000™
LOCTITE® AA H8003™
LOCTITE® EA E-20HP™

≤ 1 Hour

LOCTITE® EA E-60HP™
LOCTITE® EA E-90FL™
LOCTITE® EA E-120HP™

FLEXIBLE SOLUTIONS

LOCTITE® EA E-05CL™
LOCTITE® U-05FL™

SPECIAL SUBSTRATES

LOCTITE® AA 3035™
LOCTITE® AA H8600™

MAGNET BONDING

LOCTITE® AA 331™
LOCTITE® AA 392™
LOCTITE® AA 332™
LOCTITE® AA 326™

POTTING

LOCTITE® EA E-30CL™
LOCTITE® EA-40EXP™
LOCTITE® EA E-60NC™

GENERAL PURPOSE
STRUCTURAL ADHESIVES



AA 330™

SMALL GAP

This product requires an activator sf 7387™

Fixture Speed: 4 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Stainless Steel, Steel, Wood

Gap: 0.02 in
Temperature Resistance: 250°F
Color: Pale Yellow
Chemistry: Two-step Acrylic



EA E-00CL™

FAST FIXTURE

Fixture Speed: 15 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Stainless Steel, Steel, Wood

Temperature Resistance: 300°F
Color: Clear
Chemistry: Epoxy



EA E-00NS™

NON-SAG

Fixture Speed: 15 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Stainless Steel, Steel, Wood

Temperature Resistance: 300°F
Color: Translucent
Chemistry: Epoxy



EA E-05MR™

MOISTURE RESISTANT

Fixture Speed: 15 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Plastic, Stainless Steel, Steel, Wood

Temperature Resistance: 250°F
Color: Ultra-Clear
Chemistry: Epoxy



LOCTITE SERVICES

Improve strength and aesthetics in reduced time.

HIGH PERFORMANCE
STRUCTURAL ADHESIVES
WORK LIFE* < 1 HOUR



AA H4800™

HIGH IMPACT, PLASTIC BONDER

Work Life: 30 minutes

Substrate: Acrylonitrile Butadiene Styrene, Aluminum, Fiberglass Reinforced Plastic (FRP), Galvanized Steel, Gel Coat, Plastic, RTM, Stainless Steel, Steel, Xenoy

Temperature Resistance: 180°F
Color: Light Yellow
Chemistry: Two-step Acrylic



AA H8000™

HIGH IMPACT, METAL BONDER

Work Life: 30 minutes

Substrate: Acrylonitrile Butadiene Styrene, Aluminum, Fiberglass Reinforced Plastic (FRP), Galvanized Steel, Gel Coat, Plastic, RTM, Stainless Steel, Steel, Xenoy

Temperature Resistance: 180°F
Color: Green
Chemistry: Two-step Acrylic



AA H8003™

FAST CURE, HIGH IMPACT

Work Life: 5 minutes

Substrate: Acrylonitrile Butadiene Styrene, Aluminum, Fiberglass Reinforced Plastic (FRP), Galvanized Steel, Gel Coat, Plastic, RTM, Stainless Steel, Steel, Xenoy

Temperature Resistance: 180°F
Color: Green
Chemistry: Two-step Acrylic



EA E-20HP™

HIGH SHEAR, HIGH PEEL

Work Life: 20 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Steel, Stainless Steel, Wood

Fixture Speed: 120 minutes

Temperature Resistance: 350°F
Color: Off-white
Chemistry: Epoxy

HIGH PERFORMANCE
STRUCTURAL ADHESIVES
WORK LIFE* ≤ 1 HOUR



EA E-60HP™

HIGH SHEAR, HIGH PEEL

Work Life: 60 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Plastic, Stainless Steel, Steel, Wood

Fixture Speed: 180 minutes

Temperature Resistance: 350°F
Color: Off-white
Chemistry: Epoxy



EA E-90FL™

HIGH SHEAR, FLEXIBL

Work Life: 90 minutes

Substrate: Acrylonitrile Butadiene Styrene, Aluminum, Fiberglass Reinforced Plastic (FRP), Galvanized Steel, Gel Coat, Plastic, RTM, Stainless Steel, Steel, Xenoy

Fixture Speed: >180 minutes

Temperature Resistance: 350°F
Color: Opaque Grey
Chemistry: Epoxy



EA E-120HP™

HIGH SHEAR, NON-SAG

Work Life: 120 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Plastic, Stainless Steel, Steel, Wood

Fixture Speed: >180 minutes

Temperature Resistance: 350°F
Color: Amber
Chemistry: Epoxy

HEAT CURE



EA E-214HP™

NON SAG, HIGH SHEAR

Work Life: N/A

Substrate: Acrylics, Aluminum, Glass, Nylon, Polycarbonate, PVC, Stainless Steel

Fixture Speed: N/A

Temperature Resistance: 300°F
Color: Grey
Chemistry: 1-Part-Epoxy

*Work Life = maximum time before assebly

FLEXIBLE SOLUTION
STRUCTURAL ADHESIVES



EA E-05CL™

FAST FIXTURE

Work Life: 5 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Plastic, Stainless Steel, Steel, Wood

Fixture Speed: 30 minutes

Temperature Resistance: 300°F
Color: Clear
Chemistry: Epoxy



UK U-05FL™

HIGH PEEL

Work Life: 5 minutes

Substrate: Aluminum, Ceramic, Concrete, Glass, Metal, Plastic, Stainless Steel, Steel, Wood

Fixture Speed: 160 minutes

Temperature Resistance: 300°F
Color: Off-White
Chemistry: Polyurethane

SPECIAL SUBSTRATES
STRUCTURAL ADHESIVES



AA 3035™

POLYOLEFIN

Work Life: 50 minutes

Substrate: Polyolefin

Temperature Resistance: 350°F
Color: Pale Yellow
Chemistry: Two-part Acrylic



AA H8600™

GALVANIZED STEEL

Work Life: 25 minutes

Substrate: Galvanized Steel

Temperature Resistance: 250°F
Color: Blue
Chemistry: Two-part Acrylic

*Work Life = maximum time before assebly

MAGNET BONDING
STRUCTURAL ADHESIVES



AA 331™

ULTRA FAST FIXTURE

This product requires an activator sf 7387™

Fixture Speed: 20 minutes

Substrate: Metal

Gap: 0.02 in
Temperature Resistance: 350°F
Color: Light to sand yellow
Chemistry: Two-step Acrylic



AA 332™

HIGH TEMP RESISTANCE

This product requires an activator sf 7387™

Fixture Speed: 3 minutes

Substrate: Magnets

Gap: 0.02 in
Temperature Resistance: 400°F
Color: Amber
Chemistry: Two-step Acrylic



AA 392™

MEDIUM VISCOSITY

This product requires an activator sf 7387™

Fixture Speed: 1 minute

Substrate: Metal

Gap: 0.02 in
Temperature Resistance: 250°F
Color: Amber
Chemistry: Two-step Acrylic



AA 326™

HIGH VISCOSITY

This product requires an activator sf 7649™

Fixture Speed: 2 minute

Substrate: Metal

Gap: 0.02 in
Temperature Resistance: 250°F
Color: Light Amber
Chemistry: Two-step Acrylic

*Work Life = maximum time before assebly

POTTING
STRUCTURAL ADHESIVES



EA E-30CL™

WATER RESISTANT, CLEAR

Work Life: 30 minutes

Substrate: Ceramics, Glass, Metals, Optical Fibers, Rigid Plastics

Fixture Speed: 180 minutes

Temperature Resistance: 350°F
Color: Clear
Chemistry: Epoxy



EA E-40EXP™

EXPLOSION PROOF

Work Life: 40 minutes

Substrate: Ceramics, Glass, Metals, Optical Fibers, Rigid Plastics

Fixture Speed: N/A

Temperature Resistance: 300°F
Color: Black
Chemistry: Epoxy



EA E-60NC™

NON-CORROSIVE

Work Life: 60 minutes

Substrate: Ceramics, Glass, Metals, Optical Fibers, Rigid Plastics

Fixture Speed: >180 minutes

Temperature Resistance: 250°F
Color: Black
Chemistry: Epoxy

EQUIPMENT
STRUCTURAL ADHESIVES



DISPENSERS

50 ml

Dual Cartridge Applicators
1:1, 2:1, 4:1
Manual: 720228
Pneumatic: 476898

50 ml

Dual Cartridge Applicators
10:1 S-Style
1:1, 2:1, 4:1
Manual: 1034026
Pneumatic: 1493310

200 ml

Dual Cartridge Applicators
1:1, 2:1
Manual: 218312
Pneumatic: 218311

490 ml

10:1
Pneumatic: 470572

*Work Life = maximum time before assebly

STRUCTURAL ADHESIVES

2-STEP ACRYLICS

PRODUCT	ITEM NUMBER	PACK SIZE	FEATURES	COLOR	VISCOSITY [MPA·S, CP]	GAP FILL	Fixture Time [min]	Shear Stength, GBMS	Temperature Resistance
GENERAL PURPOSE									
AA 326™	135402	50 ml	Ferrites to plated materials in electric motors, loudspeakers hardware, jewelry	Transparent, yellow to light amber	18,000	0.02 in. [0.5 mm]	2	2200 psi [15 N/mm²]	32°F TO 250°F (0°C TO 120°C)
AA 330™	169072	25 ml kit	Metal, wood, ferrite, ceramic, plastic	Cloudy, colorless to pale yellow	65,000	0.02 in. [0.5 mm]	4	3300 psi [23 N/mm²]	32°F TO 250°F (0°C TO 120°C)
AA 331™	1057673	25 ml	Non-corrosive, high temp resistance, high shear and impact, toughened. DC motor assembly, magnet bonding	Light yellow to sand yellow	30,00	0.02 in. [0.5 mm]	20 sec.	3100 psi [21 N/mm²]	32°F TO 350°F (0°C TO 175°C)
AA 332™	23274	300 ml	Securing permanent magnets in motors	Opaque light yellow to dark amber	100,000	0.02 in. [0.5 mm]	3	3000 psi [20 N/mm²]	32°F TO 400°F (0°C TO 200°C)
MAGNET BONDING									
AA 392™	23285	25 ml	Rapid cure. Ideal for DC motor assembly, magnet bonding, pre-coated sheet metal	Translucent beige to dark amber	12,000	0.02 in. [0.5 mm]	1	2500 psi [17 N/mm²]	32°F TO 250°F (0°C TO 120°C)

STRUCTURAL ADHESIVES

2-PART ACRYLICS

PRODUCT	ITEM NUMBER	PACK SIZE	FEATURES	COLOR	VISCOSITY [MPA·S, CP]	MIX RATIO	WORK TIME** (MIN)	Lap Shear Strengt	Impact Strength, Steel [joules]	Peel Strength, Steel
GENERAL METAL BONDERS										
AA H8000™	411833	490 ml	Non-sag, superior impact and peel strength, little to no surface prep, rapid room temp cure, excellent environmental resistance	Green	8,850	10:1	30	2800 psi [15 N/mm²]	23	45 pli [8 N/mm]
AA H8003™	224412	490 ml	Superior impact and peel strength; little/no surface prep; rapid room temp cure; excellent environmental resistance; contains 10ml spacer	Green	20,000 - 50,000	10:1	5	3300 psi [23 N/mm²]	14	15 pli [2 N/mm]
AA H8600™	206083	400 ml	perior impact and peel strength; little/no surface prep; rapid room temp cure; excellent environmental resistance; contains 10ml spacer	Green	20,000 - 50,000	10:1	5	3300 psi [23 N/mm²]	14	15 pli [2 N/mm]
PLASTIC AND COMPOSITE BONDERS										
AA 3035™	1677288	50 ml	Fast fixture time; bonds to low energy plastics	Pale yellow	14,000	1:1	5	365 psi [2.5 N/mm²	5.8****	45 pli [8 N/mm]
AA H4800™	206124	490 ml	Excellent environmental resistance and tolerance to off-ratio mixing; superior impact and peel strength; non-sag gaps	Light yellow	50,000	10:1	30	2300 psi [16 N/mm²]	27 GBMS , 72 hr	80 pli [14 N/mm]

***5 Working time = maximum time before assembly*
****Galvanized steel*
*****HDPE*

LOCTITE®

STRUCTURAL ADHESIVES

EPOXIES

PRODUCT	ITEM NUMBER	PACK SIZE	FEATURES	COLOR	VISCOSITY [MPA·S, CP]	MIX RATIO	Fixture Time [min]	Lap Shear Stength, Steel	Temperature Resistance
HIGH PERFORMANCE									
EA E-20HP™	23710	50 ml	Excellent bond strength to plastics, metals, dry concrete, limestone	Off -white	30,000	2:1	120	3200 psi [22 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
	23710	400 ml							
EA E-30CL™	23711	50 ml	Excellent bond strength to plastics, metals, dry concrete, limestone	Off -white	30,000	2:1	120	3200 psi [22 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
	23711	400 ml							
EA E-40EXP™	151165	200 ml	Potting electirc motors	Black	20,000	2:1	N/A	2060 psi [14 N/mm]	-40°F TO 300°F (-40°C TO 150°C)
EA E-60HP™	23711	50 ml	Extended work life	Off -white	45,000	2:1	> 180	4320 psi [30 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
EA E-60NC™	23711	25 ml	Bonding, potting, encapsulating electrical components	Black opaque	8,000	1:1	> 180	2360 psi [16 N/mm²]	-40°F TO 250°F (-40°C TO 120°C)
	237115	400 ml							
EA E-90FL™	219298	50 ml	Resistant to range of chemicals/ solvents; excellent electrical insulator; extended work life; plastic, metal, glass, wood, ceramic, rubber, masonry	Grey	40,000	1:1	> 180	810 psi [6 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
	237106	400 ml							
EA E-120HP™	237128	50 ml	High impact and peel strength; aerospace applications, aluminum, steel, plastics, ceramics	Amberbeige	30,000	2:1	> 180	4300 psi [30 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
	237130	400 ml							
FAST FIXTURE									
EA E-00CL™	237095	50 ml	General purpose bonding, potting, or encapsulating	Clear	10,000	1:1	15	2200 psi [15 N/mm²]	-40°F TO 300°F (-40°C TO 150°C)
EA E-00NS™	233962	50 ml	Excellent electrical insulator	Translucent white to yellow paste	100,000	1:1	15	1600 psi [11 N/mm²]	-40°F TO 300°F (-40°C TO 150°C)
EA E-05CL™	237099	50 ml	Ideal for bonding when flexibility is needed	Clear	2,500	1:1	30	1450 psi [10 N/mm²]	-40°F TO 300°F (-40°C TO 150°C)
EA E-05MR™	108659	50 ml	Forms ultra clear bond line with excellent impact resistance	Water white clear liquid	25,000	1:1	15	3400 psi [23 N/mm²]	-40°F TO 250°F (-40°C TO 120°C)
	1086599	400 ml							
ONE PART									
EA E-214HP™	23400	300 ml	Excellent peel resistance and impact strength	Light grey paste	Paste	One Component	N/A	4800 psi [33 N/mm²]	-40°F TO 350°F (-40°C TO 175°C)
POLYURETHANE									
UK U-05FL™	261797	50 ml	Potting and encapsulating strain and heat-sensitive electronic components	Off-white	100,000	1:1	160	930 psi [6 N/mm²]	-40°F TO 300°F (-40°C TO 150°C)
	237127	400 ml							

A LONG-LASTING ALTERNATIVE *TO WELDING*

> **"LOCTITE® helped us find a solution to constant spot weld failures that were costing us equipment downtime and repair costs."**



A paper recycler's stainless steel filter screens failed regularly in service—every 6 to 8 weeks—due to the erosion of spot welds that caused the mesh to fall into the rotating screen system. The frequent replacement required by these failures caused equipment downtime and labor costs. LOCTITE® E-20HP™, a structural adhesive that is resistant to peel and shear forces, was the perfect solution. A LOCTITE® engineering solutions expert walked the team through the process, from ground washing the screen mesh and filter to remove any paper recycling debris and chemical residues, to dispensing from a 50 ml. dual cartridge, to positioning and weighting the replacement mesh. The new process has lowered filter replacement costs, labor repair costs and doubled uptime between process downtime, thereby increasing recycling production output.



BENEFITS

LOCTITE® E-20HP™ STRUCTURAL ADHESIVE:

- Provides the needed durability to withstand the abrasive forces in the filter process
- Replaces spot welds and holds the fine filter mesh in place for more than 16 weeks
- Offers cost savings by reducing equipment down time and labor costs

LOCTITE®

BEYOND THE BOND

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