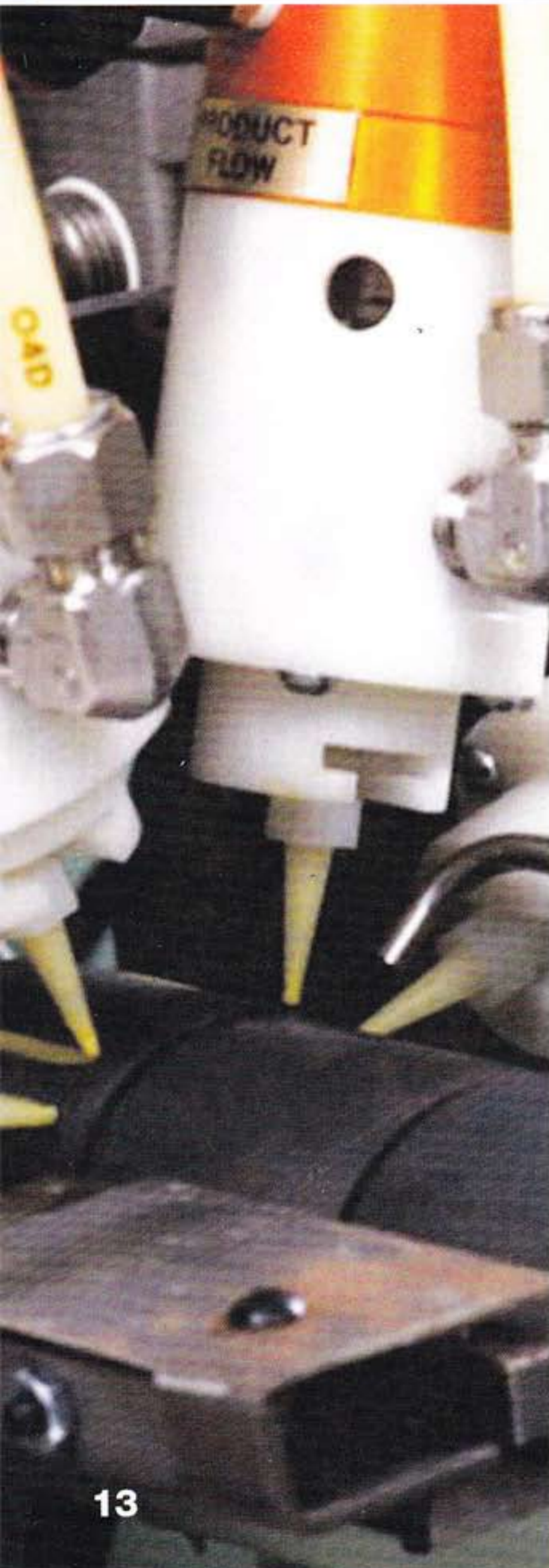


# Bonding – Acrylic Adhesives

Loctite® brand structural acrylic adhesives were developed for structural bonding applications that require tensile, shear and peel strength combined with maximum impact, stress and shock resistance. Available in two major categories:

- Two-Step No-Mix Structural Acrylics
- Two-Part Structural Acrylics



## LOCTITE® 324™ SPEEDBONDER™ STRUCTURAL ADHESIVE

### High Impact

Ideal for large gap applications. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Specially formulated for toughness and impact strength.

## LOCTITE® 325™ SPEEDBONDER™ STRUCTURAL ADHESIVE

### High Temperature

Solvent resistant, activator-cured in minutes. Forms flexible bonds on gaps up to 0.40". Designed for severe environments and temperatures to 350°F.

## LOCTITE® 326™ SPEEDBONDER™ STRUCTURAL ADHESIVE

### Fast Fixture

An all-purpose bonder. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Ideal for applications requiring fast fixturing.

## LOCTITE® 332™ STRUCTURAL ADHESIVE

### Severe Environment

An activator-cured, no-mix adhesive that provides high temperature capability with thermal durability up to 400°F.

## LOCTITE® 334™ STRUCTURAL ADHESIVE

### Toughened/Magnet Bonder

Single component, dual-cure acrylic. Forms tough, flexible bonds on gaps up to 0.02".

## LOCTITE® 392™ STRUCTURAL ADHESIVE

### Fast Fixture/Magnet Bonder

Single component, dual-cure acrylic. Provides fast fixture speed and tough reliable bonds.



## GENERAL PURPOSE

## LOCTITE® H3101™ SPEEDBONDER™ STRUCTURAL ADHESIVE

### Medium Fixture/Open time

A medium viscosity adhesive ideal for bonding a variety of substrates.



## PLASTIC/COMPOSITE BONDING

## LOCTITE® H4800™ SPEEDBONDER™ STRUCTURAL ADHESIVE

### Toughened


Provides extended open time, making it ideal for the assembly and adjustment of large parts. Excellent peel and impact resistance. Provides high bond strengths on composites.



## Loctite® Brand Two-Step, No-Mix Structural Acrylics Properties Chart

PRODUCT	Item Number	Container	TYPICAL USE	COLOR	GAP FILL	VISCOSITY (cP) at 20 RPM	SHEAR STRENGTH* (PSI)	TEMPERATURE RANGE	CURE SPEED	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS
324™ Speedbonder™	231558 32490	50 ml bottle 1 liter bottle	High impact applications	Amber	0.040"	17,000	3,600	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	7075™	1.11	N/A
325™ Speedbonder™	667653 32586	50 ml bottle 1 liter bottle	Severe environment applications	Transparent Dark Brown	0.040"	20,000	2,200	-65°F to 300°F	Fixture – 5 min. Full – 24 hrs.	7075™	1.11	N/A
326™ Speedbonder™	231560 32685	50 ml bottle 1 liter bottle	Fast fixturing applications	Transparent Dark Brown	0.020"	18,000	3,500	-65°F to 250°F	Fixture – 1 min. Full – 24 hrs.	7649™	1.10	N/A
332™	33201 33275 33290	25 ml syringe 300 ml cartridge 1 liter bottle	High temperature applications	Pale Yellow	0.020"	75,000 / 130,000	3,000	-65°F to 400°F	Fixture – 3 min. Full – 24 hrs.	7387™ or 7380™	0.97	N/A
334™	33403 33470	25 ml syringe 300 ml cartridge	Tough magnet bonder	Pale Yellow	0.020"	80,000 / 140,000 Thixotropic	2,800	-65°F to 200°F	Fixture – 90 sec. Full – 24 hrs.	7387™ or 7380™	1.05	N/A
392™	39250 39275 39280	50 ml tube 300 ml cartridge 1 liter bottle	Fast fixturing magnet bonder	Amber	0.025"	6,500 / 17,500 Thixotropic	2,500	-65°F to 250°F	Fixture – 1 min. Full – 24 hrs.	7387™ or 7380™	1.16	N/A

\* Varies with substrates.

 Indicates worldwide availability.

 Indicates TOP CHOICE products.

- 1 Contains 10 ml bottle of Loctite® 312™ Speedbonder™ and 40 g aerosol can of Loctite® 736™ Primer NF™.
- 2 Contains 50 ml bottle of Loctite® 312™ Speedbonder™ and 6 oz. aerosol can of Loctite® 736™ Primer NF™.
- 3 Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.
- 4 Contains 25 ml syringe of Loctite® 330™ Depend® Adhesive and 25 g aerosol can of Loctite® 7387™ Depend® Activator.
- 5 Contains 250 ml tube of Loctite® 330™ Depend® Adhesive and 4.5 fl. oz. aerosol can of Loctite® 7387™ Depend® Activator.

## Loctite® Brand Two-Part Structural Acrylics Properties Chart

PRODUCT	Item Number	Container	MIX RATIO	VISCOSITY (cP) (Part A / Part B)	COLOR (MIXED)	OPEN TIME IN MINUTES	FIXTURE TIME IN MINUTES	PEEL STRENGTH (PL)	IMPACT STRENGTH (kJ/m²)	ALUMINUM SHEAR STRENGTH (PSI)	STEEL SHEAR STRENGTH (PSI)	FIBERGLASS SHEAR STRENGTH (PSI)	GEL COAT SHEAR STRENGTH (PSI)	ABS SHEAR STRENGTH (PSI)	PVC SHEAR STRENGTH (PSI)	AGENCY APPROVALS
GENERAL PURPOSE H3101™ Speedbonder™	83007 83006	50 ml dual cartridge 400 ml dual cartridge	1:1	95,000 / 57,000	Cream	15-20	25	35	20-25	1,610	2,510	>1,810	>1,565	1,420	2,080	N/A
PLASTIC/COMPO SITE BONDING H4800™ Speedbonder™	83045 83047* 83046*	490 ml dual cartridge 40 lb. pail, adhesive 36 lb. pail, activator	10:1	50,000 / 55,000	Light Yellow	20-25	35	50	>42	1,810	3,930	>1,725	>1,590	530	2,090	N/A
POLYOLEFIN BONDING 3030™	37220	35 ml dual cartridge	10:1	30,000 / 5,000	Off White	2-3	10	2-4	6	975	1,450	N/A	N/A	1,330	2,000	N/A

Peel Strength measured on steel.  
Impact Strength measured on as-received aluminum.

 Indicates TOP CHOICE products.

\* Made-to-order item.

† Fixture time measured on steel.