

The Adhesive Sourcebook

The complete source of Loctite® adhesives, sealants, lubricants, coatings, dispensing and curing equipment available only from Henkel Corporation.

The Adhesive Sourcebook contains over 1,400 products in total! Put them to work to make things better, faster, and more cost efficient. Loctite® products will help you tackle the most difficult challenges the world can throw your way.

Reorganized to make Loctite® product selection easy and fast:

- **Industrial Application Solutions** – Twelve application areas feature easy-to-use product selector guides, Top Choice designations, and dispensing options designed to help you quickly narrow your search for the right Loctite® product solution to all your design, assembly, maintenance or repair challenges.
- **Medical Application Solutions** – Distinctive line for medical device assemblies.
- **Agency Approvals** – Quick reference listing of certified Loctite® products by agency: ABS, CFIA, CSA, FDA, ISO, Mil-Spec, NSF®, UL®, ULC®, NEHC, NAVSEA and Lloyd's of London.
- **Engineering Services** – Engineers and scientists are available to provide engineering assistance, contract lab services, prototype testing, joint product development programs and more.
- **Training** – A variety of training programs are offered to educate today's product designers, production and maintenance staffs, on the benefits and cost-savings associated with Loctite® product solutions.
- **Indexes** – Easy-to-use indexes help you quickly find obsolete items, Loctite® products by product number and item number, and by Loctite® product name.

Call us at **1-800-LOCTITE** (562-8483) in the U.S. and 1-800-263-5043 in Canada:

- For technical product assistance
- For local application assistance from the Loctite® Adhesives and Sealants Specialist in your area
- For the name of your nearest distributor authorized to sell Loctite® products
- For access to the Henkel Auto-Fax system to obtain Loctite® product data sheets or material safety data sheets

In addition to support from your local representative, **The Adhesive Sourcebook** is also supported by www.loctite.com – a virtual adhesive library designed to give you the best technical electronic support in the industry.

Available at your convenience, from your desktop, log on to our web site to obtain the following:



www.loctite.com

Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

E-CATALOG

Gain quick and easy access to product descriptions, approvals/specifications, application suggestions, package specifications, and technical and material safety data.

APPLICATION ASSISTANCE

Application assistance will aid in narrowing the range of products suitable for your design and maintenance needs. Or send a message to your local Adhesives and Sealants Specialist to arrange "in person" assistance.

DISTRIBUTOR LOCATOR

Find a local distributor in the U.S. or Canada that has the product you need. All it takes is a zip code.

DATA SHEETS & LITERATURE

Instant access to technical and material safety data sheets. View electronic versions of our design guides, bonding guides, quick reference tools, and other special literature.

WHAT'S NEW?

Find out about new Loctite® product introductions, feature articles, trade show schedules, and application success stories. Register on-line for adhesives seminars or CEU-accredited Manufacturing Reliability Training classes in your area.

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At Henkel Corporation, we invent more than just quality Loctite® products, we provide solutions to industry's biggest challenges. Whether we are reducing assembly cost, providing design and application assistance, or increasing the reliability of your process, Henkel is dedicated to earning and keeping the trust of our customers. Through this philosophy, Henkel has assumed a position of worldwide leadership.

Trust Henkel Corporation to be your sole source for design assistance, application assistance, and after-the-sale support.

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The Top Choice designation lets you know that this Loctite® product has demonstrated proven performance in handling a variety of customer applications and is most often included in initial product testing and evaluation.

Bonding

For successful bonding, knowledge of adhesive methodology is essential. The most frequent causes for adhesive failure do not involve adhesive strength. Rather, they are attributed to inadequate preparation of the substrates and improper adhesive selection.

The most important factor in proper adhesive selection is assessing the environment the adhesive must withstand. Once the environmental factors have been recognized, adhesive selection becomes more easily defined as other factors, such as joint design, substrates, load, stress cycles, etc., can often be varied or altered with minor design changes.

What is the best adhesive for my application?

The following chart has been designed to help you select a bonding adhesive. This chart is intended to serve as a general guideline to help you determine which adhesive categories are best suited for your application. The data presented represents typical properties for each adhesive category; however, individual product properties may differ. It is suggested that, based on the information provided, you consider at least the two best adhesive categories that meet your application criteria. Individual product information can then be found on the pages that follow to help narrow your search.

This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any adhesive.

Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit www.loctite.com and select "Contact Loctite." In Canada, please call **1-800-263-5043**.

FREE BONDING GUIDES

Loctite® Design Guides help you select the proper Loctite® adhesive for bonding Metals, Plastics, Rubbers and Thermoplastic Elastomers. Visit www.loctite.com and click on **Product & Service Solutions**, then select **Literature** to view the guides or request copies.



Bonding Selector Guide

PERFORMANCE CONSIDERATIONS	ADHESIVE CATEGORY								
	Cyanoacrylates	Epoxies	Hot Melts	Light Cure	Silicones	Modified Silanes	Urethanes	2-Part Acrylics	2-Step Acrylics
BENEFITS	Wide range of bonding applications	Wide range of formulations	Fast, large gap filling	Rapid cure/adhesion to plastics	Excellent temperature resistance	Flexible, paintable, bonder/sealant	Excellent toughness/flexibility	Good impact resistance/flexibility	Good impact resistance, no-mix
LIMITATIONS	Low solvent resistance	Mixing required	Low heat resistance	Light cure system required	Low adhesion strength	Low temperature resistance	Sensitive to moisture	Mixing required	Primer required
TEMPERATURE RESISTANCE									
Typical for the category	-65°F to +180°F	-65°F to +180°F	-65°F to +250°F	-65°F to +300°F	-65°F to +400°F	-40°F to +200°F	-65°F to +250°F	-65°F to +250°F	-65°F to +300°F
Highest Rated Product	+250°F	+400°F	+330°F	+350°F	+725°F	+200°F	+300°F	+250°F	+400°F
ENVIRONMENTAL RESISTANCE									
Polar Solvents <i>(ex. H₂O, Ethylene Glycol IPA, Acetone)</i>	Poor ¹	Very Good	Good	Good	Good	Good	Good	Good	Good
Non-Polar Solvents <i>(ex. Motor Oil, Toluene, Gasoline, ATF)</i>	Good	Excellent	Good	Very Good	Poor to Fair	Poor	Good	Very Good	Very Good
ADHESION TO SUBSTRATES									
Metals	Very Good	Excellent	Good	Good	Good	Good	Good	Excellent	Excellent
Plastics ²	Excellent	Fair	Very Good	Excellent	Fair	Good	Very Good	Excellent	Fair
Glass	Poor	Excellent	Good	Excellent	Very Good	Good	Good	Good	Excellent
Rubber	Very Good	Fair	Fair	Fair	Good	Poor	Good	Poor	Poor
Wood	Good	Very Good	Excellent	Poor	Fair	Good	Fair	Good	Good
OVERLAPPING SHEAR STRENGTH	High	High	Low	High	Low	Medium	Medium	High	High
PEEL STRENGTH	Low ⁵	Medium	Medium	Medium	Medium	Medium	Medium	High	Medium
TENSILE STRENGTH	High	High	Low	High	Medium	Medium	Medium	High	High
ELONGATION / FLEXIBILITY	Low	Low	High	Medium	High	High	High	High	Medium
HARDNESS	Rigid	Rigid	Semi-Soft	Semi-Rigid	Soft	Soft	Soft	Semi-Rigid	Semi-Rigid
PROCESS CONSIDERATIONS	ADHESIVE CATEGORY								
	Cyanoacrylates	Epoxies	Hot Melts	Light Cure	Silicones	Modified Silanes	Urethanes	2-Part Epoxies	2-Step Acrylics
NUMBER OF COMPONENTS	1	2	1	1	1	1	2	2	2
CURE TEMPERATURE	Room Temperature	Room Temperature	Room Temperature ³	UV/Visible	Room Temperature	Room Temperature	Room Temperature	Room Temperature	Room Temperature
FIXTURE TIME									
Average	60 seconds	35 minutes	70 seconds	30 seconds	25 minutes	25 minutes	25 minutes	20 minutes	5 minutes
Fastest	5 seconds	3 to 5 minutes	20 seconds	5 seconds	2 minutes	10 minutes	5 minutes	3 to 5 minutes	30 seconds
FULL CURE TIME	24 hours	12 to 24 hours	1 hour (or when cooled) ⁴	30 to 60 seconds	1 to 7 days	1 to 7 days	24 hours	24 hours	24 hours
GAP FILL									
Ideal (in inches)	0.001 to 0.006	0.004 to 0.006	0.002 to 0.005	0.002 to 0.010	0.001 to 0.006	0.001 to 0.006	0.004 to 0.006	0.010 to 0.040	0.002 to 0.004
Maximum (in inches)	0.010	0.125	0.240	0.25	0.25	0.24	0.125	0.5	0.040
DISPENSING / MIXING EQUIPMENT REQUIRED	No	Yes	Yes	No	No	No	Yes	Yes	No
LIGHT CURE VERSIONS AVAILABLE?	Yes	Yes	No	Yes	Yes	No	No	No	Yes
<i>For more information on each adhesive category refer to pages...</i>	4-7	24-29	8-11	12-15	56-59	16-17	24-29	21, 23	20, 22

¹ Cyanoacrylates have very good moisture resistance on plastics.

² Uncured liquid adhesives may cause stress cracking of certain thermoplastics, e.g. polycarbonate, acrylic, and polysulfone. Special products and process techniques are available. Consult the Loctite® Design Guide to Bonding Plastics (LT-2197) or contact 1-800-LOCTITE (562-8483) for more information.

³ Elevated temperatures are required to dispense liquid Hot Melt Adhesives.

⁴ Urethane Hot Melts require 24 hours for full cure.

⁵ Exception: Toughened cyanoacrylates have *HIGH* peel strength.

Cyanoacrylates

Technology from Henkel Corporation has made the productivity promises of cyanoacrylate adhesives (instant adhesives) a reality with the industry's widest selection of high-performance, application-specific, instant adhesives. Loctite® instant adhesives are available in a variety of viscosities, cure speeds, gap-filling capabilities, and substrate compatibilities. The ultra high-performance Loctite® Prism® family offers additional products that surpass the most stringent demands, including toughened formulations, low odor and low blooming products, and thermally resistant formulations.



GENERAL PURPOSE/ SURFACE INSENSITIVE

LOCTITE® 401™ PRISM® INSTANT ADHESIVE

Medium Viscosity

Designed for the assembly of difficult-to-bond materials which require uniform stress distribution. Particularly suited for bonding a wide range materials, including metals, plastics, and elastomers. Also formulated for faster cure speeds on dry or acidic surfaces and substrates.



LOCTITE® 406™ PRISM® INSTANT ADHESIVE

Wicking Grade

Designed for the bonding of plastics and electromagnetic materials where very fast fixturing is required.

LOCTITE® 431™ PRISM® INSTANT ADHESIVE



High Viscosity

For bonds that require greater gap fill. Bonds to a wide variety of substrates, including dry or acidic surfaces. Fixtures fast and stays fast throughout the life of the product.

LOCTITE® 454™ PRISM® INSTANT ADHESIVE

Gel

Designed for the assembly of difficult-to-bond materials which require uniform stress distribution. Particularly suited for bonding porous or absorbent materials. Also formulated for faster cure speeds on dry or acidic surfaces and substrates.



LOW ODOR/LOW BLOOM

LOCTITE® 403™ PRISM® INSTANT ADHESIVE

High Viscosity

Part of a family of low odor, low blooming, surface insensitive products designed to improve the work environment and to improve cosmetic appearance. Products now have faster fixture speeds on plastics and metals.

LOCTITE® 455™ PRISM® INSTANT ADHESIVE

Gel

Particularly suited for bonding porous or absorbent substrates where low odor and/or non-blooming properties are required.

TOUGHENED

LOCTITE® 380™ BLACK MAX® INSTANT ADHESIVE

The original elastomer-modified instant adhesive. Bonds metal, rubber, and plastic. Excellent peel, impact and shear strength.



LOCTITE® 411™ PRISM® INSTANT ADHESIVE

Clear

An adhesive formulated for excellent impact and peel strength in gap-filling applications.

LOCTITE® 426™ PRISM® INSTANT ADHESIVE

Gel

Designed for porous surfaces and vertical or overhead application with the added benefits provided by an elastomer-modified instant adhesive.



INTRODUCING:
the **NEW**
Loctite® Bottle

New nozzle for *optimal* dispensing accuracy and control.

Positive seal cap – seals with a click.

Highly flexible package provides flow control and ease of use.

TOUGHENED CONT.

LOCTITE® 435™ PRISM® INSTANT ADHESIVE

Surface Insensitive

The first true *clear, surface insensitive*, elastomer-modified instant adhesive. Faster fixture times over traditional toughened adhesives with exceptional bond and peel strength on metals, plastics, and rubbers.

THERMALLY RESISTANT

LOCTITE® 4204™ PRISM® INSTANT ADHESIVE

Clear, toughened, thermally resistant instant adhesive. Excellent hot strength and heat aging properties up to 250°F.

LIGHT CURE ADHESIVE

LOCTITE® 4306™/4307™ FLASHCURE® LIGHT CURE ADHESIVES

Low or high viscosity fluorescent adhesives that achieve tack-free cures in less than 5 seconds. Surface versatile with shadow cure capability.



FLEXIBLE

LOCTITE® 4851™/4861™ PRISM® INSTANT ADHESIVES

A medium and high viscosity instant adhesive for the assembly of flexible components.

GENERAL PURPOSE

LOCTITE® 404™ QUICK SET™ INSTANT ADHESIVE

For general maintenance and repair. Excellent for rubber bonding.



LOCTITE® 430™ SUPER BONDER® INSTANT ADHESIVE

A general industrial-grade instant adhesive. Excellent choice for bonding close-fitting metal parts.

LOCTITE® 444™ TAK PAK® INSTANT ADHESIVE

An adhesive designed for printed circuit board assembly and repair. Cures instantly with Loctite® 712™ or 7452™ Tak Pak® Accelerator.

LOCTITE® 495™ SUPER BONDER® INSTANT ADHESIVE

Designed to bond rubber, metal, and plastic parts with gaps to 0.004".

LOCTITE® 498™ SUPER BONDER® INSTANT ADHESIVE

Thermal Cycling Resistant
A medium viscosity, high temperature product for all metals, and most plastics and rubbers. Resists temperatures to 180°F continuous or up to 250°F intermittent.

DISPENSING OPTIONS

Loctite® Integrated Semi-Automatic Dispenser systems combine a controller and reservoir into a single unit for valve dispensing of all Loctite® gel and instant adhesives. These reservoirs are large enough to accept up to 2 kg bottles, and units can be equipped with low-level sensing. For available valves, spare parts, accessories and dispense tips, please visit



www.equipment.loctite.com
Item Numbers: 97007, 97010, 97017 and 97020
Dimensions: 13.2" H x 13.8" W x 9.1" D
Weight: 16.5 lbs. (7.5 kg)
Package Types & Sizes: 250 ml, 1 lb., 1 L and 2 kg bottles, and 200 g squeeze tubes

Loctite® Benchtop Peristaltic Dispenser

is a reliable and effective volumetric dispenser for single-component, low viscosity instant adhesives, up to 5,000 cPA; directly from the product bottle. It is great for dispensing applications where a precise bead or specific flow rate is necessary. The dispenser is electro-mechanically operated and does not require the use of an air source. For available spare parts and accessories, please visit



www.equipment.loctite.com.

Item Number: 98548
Dimensions: 3.2" H x 7.2" W x 6.7" D
Weight: 6.6 lbs. (2.99 kg)
Package Types & Sizes: All Loctite® instant adhesive packages

See our **Loctite® Equipment Sourcebook, LT-3669** or visit us at www.equipment.loctite.com for more details.

www.instantadhesives.loctite.com



Loctite® Instant Adhesives Properties Chart

PRODUCT		Item Number	Package Type & Size	TYPICAL USE	COLOR	GAP FILL	CATEGORY	VISCOSITY (cPA)	SHEAR STRENGTH* (PSI)	TEMPERATURE RANGE	CURE SPEED**	SPECIFIC GRAVITY	AGENCY APPROVALS
GENERAL PURPOSE	SURFACE INSENSITIVE	401™ Prism®	40104 3 g tube 40140 20 g bottle 40161 1 lb. bottle	General purpose	Clear	0.005"	Ethyl	110	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	CFIA
		406™ Prism®	40604 3 g tube 40640 20 g bottle 40661 1 lb. bottle	Wicking grade	Clear	0.004"	Ethyl	20	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
		431™ Prism®	41254 3 g tube 41255 20 g bottle 41256 1 lb. bottle	Gap filling	Clear	0.008"	Ethyl	1,000	2,300	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.1	N/A
		454™ Prism®	45404 3 g tube 21925 10 g syringe 45440 20 g tube 45474 200 g tube 45478 300 g cartridge	Porous surfaces	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 180°F	Fixture – 15 sec. Full – 24 hrs.	1.05	CFIA, ABS
LOW ODOR / LOW BLOOM	SURFACE INSENSITIVE	455™ Prism®	22309 10 g syringe 17421 200 g tube	Porous surfaces	Clear	0.010"	Alkoxy	Gel	2,600	-65°F to 160°F	Fixture – 90 sec. Full – 24 hrs.	1.10	N/A
		403™ Prism®	40304 3 g tube 40340 20 g bottle 40361 1 lb. bottle	Gap filling	Clear	0.008"	Alkoxy	1,000	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
		408™ Prism®	40840 20 g bottle 40861 1 lb. bottle	Wicking grade	Clear	0.002"	Alkoxy	5	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.05	N/A
		460™ Prism®	46004 3 g tube 46040 20 g bottle 46061 1 lb. bottle	Close fitting parts	Clear	0.004"	Alkoxy	45	2,600	-65°F to 160°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
TOUGHENED	SURFACE INSENSITIVE	380™ Black Max®	38004 3 g tube 38050 1 oz. bottle 38061 1 lb. bottle	Close fitting parts	Black	0.006"	Ethyl	300	3,750	-65°F to 225°F	Fixture – 90 sec. Full – 24 hrs.	1.10	CFIA
		410™ Prism®	41004 3 g tube 41045 20 g bottle 41061 1 lb. bottle	Gap filling	Black	0.008"	Ethyl	3,500	3,200	-65°F to 225°F	Fixture – 90 sec. Full – 24 hrs.	1.07	CFIA
		411™ Prism®	41104 3 g tube 41145 20 g bottle 41161 1 lb. bottle	Clear gap filling	Clear	0.008"	Ethyl	5,000	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.07	N/A
		426™ Prism®	21921 10 g syringe 18398 20 g tube 17451 200 g tube 17529 300 g cartridge	Porous surfaces	Black	0.010"	Ethyl	Gel	3,000	-65°F to 210°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A
		480™ Prism®	48040 20 g bottle 48061 1 lb. bottle	General filling	Black	0.006"	Ethyl	200	3,800	-65°F to 180°F	Fixture – 90 sec. Full – 24 hrs.	1.10	NSF/ANSI 61
		435™ Prism®	41005 3 g tube 40994 20 g bottle 40995 1 lb. bottle	General purpose	Clear	0.006"	Ethyl	200	2,700	-65°F to 240°F	Fixture – 30 sec. Full – 24 hrs.	1.1	N/A
THERMALLY RESISTANT	SURFACE INSENSITIVE	438™ Prism®	41006 3 g tube 40997 20 g bottle 40996 1 lb. bottle	General purpose	Black	0.006"	Ethyl	200	2,800	-65°F to 240°F	Fixture – 30 sec. Full – 24 hrs.	1.1	N/A
		4203™ Prism®	28026 20 g tube 28027 1 lb. bottle	Close fitting parts	Clear	0.005"	Ethyl	375	2,200	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
		4204™ Prism®	26324 20 g tube 26325 1 lb. bottle	Gap filling	Clear	0.008"	Ethyl	4,000	2,100	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
LIGHT CURE	SURFACE INSENSITIVE	4205™ Prism®	28028 20 g tube 28029 200 g tube 28030 300 g cartridge	Porous surfaces	Clear	0.010"	Ethyl	Gel	2,300	-65°F to 250°F	Fixture – 30 sec. Full – 24 hrs.	1.10	N/A
		4306™ Flashcure®	37439 1 oz. bottle 37442* 1 lb. bottle	Close fitting	Clear/Pale Green/Fluorescent	0.004"	Ethyl	20	2,000‡	-65°F to 240°F	Fixture < 5 sec‡	1.1	ISO 10993
FLEXIBLE	SURFACE INSENSITIVE	4307™ Flashcure®	37441 1 oz. bottle 37443* 1 lb. bottle	Gap filling	Clear/Pale Green/Fluorescent	0.008"	Ethyl	900	2,000‡	-65°F to 240°F	Fixture < 5 sec‡	1.1	N/A
		4851™ Prism®	37732 20 g bottle 37733 1 lb. bottle	Flexible	Clear	0.006"	Alkyl	400	2,175	-65°F to 125°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A
FLEXIBLE	SURFACE INSENSITIVE	4861™ Prism®	37708 20 g bottle 37711 1 lb. bottle	Flexible	Clear	0.008"	Alkyl	4,000	2,465	-65°F to 125°F	Fixture – 20 sec. Full – 24 hrs.	1.10	N/A

* Grit blasted steel.

** Varies with substrates.

‡ Data generated using polycarbonate.

¥ Full Cure = 24 hours without UV exposure

(With UV exposure, see Technical data Sheets)

A complete line of surface primers, accelerators and cleaners are available to further enhance the performance of Loctite® instant adhesives. Refer to the Surface Preparation section.



Indicates worldwide availability.



Indicates TOP CHOICE products.

Loctite® Instant Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	TYPICAL USE	COLOR	GAP FILL	CATEGORY	VISCOSITY (cPA)	SHEAR STRENGTH* (PSI)	TEMPERATURE RANGE	CURE SPEED**	SPECIFIC GRAVITY	AGENCY APPROVALS	
GENERAL PURPOSE	382™ Tak Pak®	38203 20420 38240 38261	3 g tube 20 g kit † 20 g bottle 1 lb. bottle	Gap filling and ultra-performance wire tracking	Clear	0.008"	Ethyl	5,000	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	N/A
	404™ Quick Set™	46551 46548 46561	1/3 oz. bottle 4 oz. bottle 1 lb. bottle	Rubber o-ring bonder	Clear	0.005"	Ethyl	80	3,500	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	ABS, CFIA, Commercial item std. A-A-3097
	409™ Super Bonder®	40904 21922 40945 40974 18030	3 g tube 10 g syringe 20 g tube 200 g tube 300 g cartridge	General purpose gel	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 180°F	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	414™ Super Bonder®	41404 41450 41461	3 g tube 1 oz. bottle 1 lb. bottle	Plastic bonder	Clear	0.006"	Ethyl	110	3,200	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	CFIA, Commercial item std. A-A-3097
	415™ Super Bonder®	41550 41561	1 oz. bottle 1 lb. bottle	Gap filling metal bonder	Clear	0.008"	Methyl	1,500	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	416™ Super Bonder®	41650 41661	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	0.008"	Ethyl	1,500	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	CFIA, Commercial item std. A-A-3097
	420™ Super Bonder®	42050 42061	1 oz. bottle 1 lb. bottle	Wicking type plastic bonder	Clear	0.002"	Ethyl	2	2,900	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	422™ Super Bonder®	42250 42261	1 oz. bottle 1 lb. bottle	Gap filling plastic bonder	Clear	0.008"	Ethyl	2,500	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	CFIA, Commercial item std. A-A-3097
	430™ Super Bonder®	43004 43050 43061	3 g tube 1 oz. bottle 1 lb. bottle	Metal bonder for close fitting parts	Clear	0.005"	Methyl	80	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	444™ Tak Pak®	12292 20419 12294	20 g bottle 20 g kit † 1 lb. bottle	Tak Pak® wire tacking	Clear	0.007"	Ethyl	700	3,200	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097
	493™ Super Bonder®	49350 49361	1 oz. bottle 1 lb. bottle	Wicking type metal bonder	Clear	0.002"	Methyl	2	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	495™ Super Bonder®	49595 49504 49550 49561	0.07 fl. oz. Gluematic® Pen 3 g tube 1 oz. bottle 1 lb. bottle	General purpose	Clear	0.004"	Ethyl	45	2,750	-65°F to 180°F	Fixture – 20 sec. Full – 24 hrs.	1.05	Commercial item std. A-A-3097, ABS
	496™ Super Bonder®	49650 49661	1 oz. bottle 1 lb. bottle	General purpose rubber bonder	Clear	0.006"	Methyl	125	3,600	-65°F to 180°F	Fixture – 30 sec. Full – 24 hrs.	1.09	Commercial item std. A-A-3097
	498™ Super Bonder®	49850 49861	1 oz. bottle 1 lb. bottle	Thermal cycling	Clear	0.007"	Ethyl	500	3,000	-65°F to 180°F	Fixture – 50 sec. Full – 24 hrs.	1.10	N/A
	499™ Super Bonder®	49904 21924 49945 49974	3 g tube 10 g syringe 20 g tube 200 g tube	Thermal cycling gel	Clear	0.010"	Ethyl	Gel	3,200	-65°F to 200°F	Fixture – 75 sec. Full – 24 hrs.	1.10	N/A
	QuickTite®	39202	0.14 oz. bottle	General gel	Clear	0.010"	Ethyl	Gel	2,800	-65°F to 180°F	Fixture – 45 sec. Full – 24 hrs.	1.1	N/A

* Grit blasted steel.

** Varies with substrates.

‡ Contains Loctite® 382™ Tak Pak® Instant Adhesive (20 g bottle), Loctite® 7452™ Tak Pak® Accelerator (0.7 oz. net wt. aerosol can).

† Contains Loctite® 444™ Tak Pak® Instant Adhesive (20 g bottle), Loctite® 7452™ Tak Pak® Accelerator (0.7 oz. net wt. aerosol can).

A complete line of surface primers, accelerators and cleaners are available to further enhance the performance of Loctite® instant adhesives. Refer to the Surface Preparation section.



Indicates TOP CHOICE products.

Hot Melts

Loctite® Hysol® hot melt adhesives were developed to bond a variety of substrates, including difficult-to-bond plastics. These adhesives can handle today's toughest applications in a broad range of industries. Loctite® Hysol® hot melts are ideal for applications that require high speed manufacturing, bonding versatility, very large gap filling, fast green strength, and minimal shrinkage. Loctite® Hysol® hot melts are solvent-free and contain environmentally-friendly materials with no harmful VOCs.



SPRAYABLE/EVA-BASED

LOCTITE® 0420™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

Fast Setting

Formulated for spray applications. Has an open time of 2 minutes when sprayed and 45 seconds when bead applied.

LOCTITE® 0430™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

Medium Open Time

Suitable for bonding expanded polystyrene, polyethylene, and urethane foams. Can be used in applications where solvent-based aerosols are used.

LOCTITE® 0437™ HYSOL® SPRAYPAC™ HOT MELT ADHESIVE

Medium Open Time

Formulated to be spray applied to a wide variety of substrates.

LOCTITE® 0450™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

Extended Open Time

Formulated for spray applications, this adhesive is well suited for use on expanded polystyrene or urethane foams.



LOCTITE® 0452™ HYSOL® SPRAYPAC™ HOT MELT ADHESIVE

Extended Open Time

Formulated to be spray applied to a wide variety of substrates. Excellent for bonding expanded polystyrene or urethane foams.

POLYOLEFIN-BASED

LOCTITE® 3651™ HYSOL® HOT MELT ADHESIVE

Plastic Bonder

An adhesive for plastic bonding. Ideal for polyethylene and polyolefin plastics. Long open time of 80 to 100 seconds.



URETHANE-BASED

LOCTITE® 3631™ HYSOL® HOT MELT ADHESIVE

High Strength

A toughened, high strength adhesive for use on plastics. Flexible bond with an open time of 60 seconds.



www.loctite.com



Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

DISPENSING OPTIONS

Loctite® Hysol™ 050 / 050-HT 1/2" Superstick Dispensers are lightweight, ergonomically-designed, manual dispensers for industrial use. The dispenser contains a fixed precision thermostat control for consistent heating. 050-HT is designed for high temperature polyamides. For available spare parts and dispense nozzles, please visit

www.equipment.loctite.com.

Item Numbers: 98544 and 98545

Dimensions: 3.0" W x 10.25" L x 7.5" H

Weight: 1.15 lbs.



Loctite® Hysol™ Reactive Cartridge Dispenser is used to dispense reactive polyurethane hot melts from 300 ml cartridges. This electronically-heated, pneumatic dispenser includes a pressure-regulating stand with optional vertical application stand and foot switch for hands-free application. For available spare parts and dispense nozzles, please visit

www.equipment.loctite.com.

Item Number: 98011

Dimensions: 21 7/32" W x 11 13/16" L x 9 15/32" H

Weight: 3 lbs.



POLYAMIDE-BASED

LOCTITE® 7460™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

Sprayable

Formulated for spray applications. High heat resistance and fast set time. Suitable for bonding foams, fabric, and wood.

LOCTITE® 7500™ HYSOL® SPRAYPAC™ POLYSHOT™ HOT MELT ADHESIVE

Long Open Time

Formulated for long open time and high output for bonding surfaces up to 15 square feet.



LOCTITE® 7809FR™ HYSOL® HOT MELT ADHESIVE

Fire Retardant

Modified with fire retardant materials. It has a UL 94V-O flammability rating.

LOCTITE® 7811™ HYSOL® HOT MELT ADHESIVE

High Temperature

A high performance polyamide with exceptional high temperature resistance and impact at low temperatures.

LOCTITE® 7901™ HYSOL® HOT MELT ADHESIVE

Potting

Low viscosity polyamide used extensively for potting and encapsulating.

EVA-BASED

LOCTITE® 1X™ HYSOL® HOT MELT ADHESIVE

Fast Setting

Medium to fast setting, recommended for bonding paper, wood, fabric, and foam.

LOCTITE® 3X™ HYSOL® POLYSHOT™ HOT MELT ADHESIVE

Porous Substrates

Used extensively for bonding sand molds and other porous substrates.

LOCTITE® 0232™ HYSOL® HOT MELT ADHESIVE

Medium Open Time

A medium setting adhesive with an open time of 15 seconds.

LOCTITE® 1942™ HYSOL® HOT MELT ADHESIVE

General Purpose

Medium setting, general purpose hot melt adhesive. Excellent adhesion to wood and many plastics.



LOCTITE® 4046™ HYSOL® HOT MELT ADHESIVE

Extended Open Time

Highly flexible, 60-second open time for demanding substrates such as rubber and polyethylene.

LOCTITE® COOLMELT™ HYSOL® HOT MELT ADHESIVE

Low Temperature

Flexible material designed to be applied at low temperatures. Ideal for bonding heat-sensitive parts.

LOCTITE® SUPERPAC™ HYSOL® HOT MELT ADHESIVE

Cardboard Bonder

A medium setting material with a 30-second open time, it is formulated to bond cardboard and foams.





LOCTITE® WAXPAC™ HYSOL® HOT MELT ADHESIVE

Wax Coating Bonder

Medium setting, flexible-based material formulated to bond wax coated substrates and withstand low temperatures.



Loctite® Hysol® Hot Melt Adhesives Properties Chart


PRODUCT		Item Number	Package Type & Size	COLOR	ATTRIBUTES	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (PSI)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS
SPRAYABLE/EVA-BASED	0420™ Hysol® SprayPac™	83346	Polyshot™ 12 oz. sample bag	Cream	Fast setting	10,500	N/A	2 minutes sprayed	153°F	N/A	N/A	N/A
	0430™ Hysol® SprayPac™	83348 83349	Polyshot™ 12 oz. sample bag Polyshot™ 35 lb. carton	Cream	Medium open time	5,000	280	3.5 minutes sprayed	170°F	N/A	75	N/A
	0430™ Red Hysol® SprayPac™	83350 83351	Polyshot™ 12 oz. sample bag Polyshot™ 35 lb. carton	Pink	Medium open time	5,000	280	3.5 minutes sprayed	170°F	N/A	75	N/A
	0437™ Hysol® SprayPac™	83352	36 lb. carton bricks	Cream	Medium open time	5,200	270	3.5 minutes sprayed	170°F	N/A	75	N/A
	0450™ Hysol® SprayPac™ 	83353 83354	Polyshot™ 12 oz. sample bag Polyshot™ 35 lb. carton	Natural	Extended open time	4,500	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
	0450™ Red Hysol® SprayPac™	83355 83356	Polyshot™ 12 oz. sample bag Polyshot™ 35 lb. carton	Pink	Extended open time	4,500	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
	0452™ Hysol® SprayPac™	83257	SprayPac™ 21 lb. pucks	Natural	Extended open time	4,300	N/A	5 to 8 minutes	156°F	N/A	N/A	N/A
POLYURETHANE-BASED	3651™ Hysol® 	31303	12 kg squares	Beige	Plastic bonder	10,000	334	80 to 100 seconds	266°F	790	55	N/A
URETHANE-BASED	3631™ Hysol® 	31291 31279	300 ml cartridge 5 gallon pail	Off White	High strength	12,000	1,800	60 seconds	250°F	940	91	N/A
POLYAMIDE-BASED	7460™ Hysol® SprayPac™	83308	Polyshot™ 25 lb. pail	Pale/Amber	Sprayable	6,700	N/A	30 seconds	210°F	N/A	N/A	N/A
	7500™ Hysol® SprayPac™ 	83312 83313	Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Pale/Amber	Long open time	1,900	N/A	2 minutes	200°F	N/A	N/A	N/A
	7804™ Hysol®	83325 83326 83327 83328 83329 83330	5 lb. sample bag pellets 40 lb. carton pellets Superstick™ 10" 5 sample oz. bag Superstick™ 10" 32 lb. carton Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Amber	High viscosity	7,500	340	35 seconds	220°F	900	74	N/A
	7804FRM-HV™ Hysol®	83382 83383 83384 83386 83387	40 lb. carton pellets Superstick™ 10" 5 oz. sample bag Superstick™ 10" 30 lb. pail Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Off White	Fire retardant	6,000	245	35 seconds	220°F	300	N/A	UL94V-0
	7809FR™ Hysol®	83388 83390 83391	5 lb. sample bag pellets Superstick™ 10" 13 oz. sample bag Polyshot™ 13 oz. bag	Amber	Fire retardant	7,000	363	35 seconds	240°F	373	85	UL94V-0
	7811™ Hysol®	83337 83339 83340	5 lb. sample bag pellets Polyshot™ 10" 13 oz. sample bag Polyshot™ 25 lb. pail	Amber	High temperature	6,400	400	35 seconds	266°F	1,200	N/A	N/A
	7901™ Hysol®	83341 83342 83343 83344	5 lb. sample bag pellets 40 lb. carton pellets Polyshot™ 13 oz. sample bag Polyshot™ 25 lb. pail	Amber	Potting	750	260	35 seconds	300°F	80	84	N/A

 Indicates TOP CHOICE products.

Loctite® Hysol® Hot Melt Stick Chart

DESCRIPTION	DIAMETER	LENGTHS	LOCTITE® APPLICATORS BY ITEM #
Superstick™	0.50"	4" / 10"	98544, 98545, 98032, 98029
Maxistick™	0.75"	2.4"	98033, 98034
Polyshot™	1.75"	1.5"	98035, 98036, 98040, 98037, 98041

Loctite® Hysol® Hot Melt Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	ATTRIBUTES	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (PSI)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS	
EVA-BASED	1X™ Hysol®	83357 5 lb. sample bag pellets 83358 40 lb. carton pellets 83359 Maxistick™ 7 oz. sample bag 83360 Maxistick™ 35 lb. carton 83362 PT™ stick 36 lb. carton 83364 Superstick™ 10" 5 oz. sample bag 83365 Superstick™ 10" 25 lb. carton 83367 Polyshot™ 12 oz. bag 83368 Polyshot™ 35 lb. Carton	Light Yellow	Fast setting	2,000	370	15 seconds	150°F	90	N/A	FDA CFR175,105	
	3X™ Hysol®	83369 Polyshot™ 12 oz. sample bag 83370 Polyshot™ 35 lb. carton	Tan	Porous substrates	4,000	580	60 seconds	135°F	300	N/A	FDA CFR175,105	
	0232™ Hysol®	83237 5 lb. sample bag pellets 83239 40 lb. carton pellets 83241 Maxistick™ 35 lb. carton 83244 Superstick™ 10" 5 oz. sample bag 83245 Superstick™ 10" 25 lb. carton 83246 Polyshot™ 12 oz. sample bag 83247 Polyshot™ 35 lb. carton	Clear	Medium open time	11,000	N/A	15 seconds	153°F	N/A	N/A	FDA CFR175,105	
	236™ Hysol®	83251 Superstick™ 10" 5 oz. sample bag 83252 Superstick™ 10" 25 lb. carton	Clear	Medium viscosity	8,500	213	25 seconds	140°F	450	N/A	FDA CFR175,105	
	342™ Hysol®	83255 Polyshot™ 35 lb. carton	Cream	Fast setting	8,250	800	5 seconds	166°F	60	N/A	FDA CFR175,105	
	740™ Hysol®	83260 Superstick™ 10" 5 oz. sample bag 83261 Superstick™ 10" 25 lb. carton 83263 Polyshot™ 12 oz. sample bag 83264 Polyshot™ 35 lb. carton	Light Yellow	High strength	9,000	750	10 seconds	168°F	75	N/A	FDA CFR175,105	
	740LV™ Hysol®	83373 40 lb. carton pellets 83374 Polyshot™ 35 lb. carton	Light Yellow	High temperature	3,500	700	10 seconds	215°F	80	N/A	FDA CFR175,105	
	1942™ Hysol®	83266 5 lb. sample bag pellets 83267 40 lb. carton pellets 83268 Maxistick™ 7 oz. sample bag 83269 Maxistick™ 35 lb. carton 83271 PT™ stick 35 lb. carton 83272 Ministick™ 35 lb. carton 83273 Superstick™ 10" 5 oz. sample bag 83274 Superstick™ 10" 25 lb. carton 83275 Superstick™ 4" 25 lb. carton 83276 Polyshot™ 12 oz. sample bag 83277 Polyshot™ 35 lb. carton	Tan	General purpose	5,000	250	30 seconds	142°F	500	N/A	FDA CFR175,105	
		4046™ Hysol®	83278 Polyshot™ 12 oz. sample bag 83279 Polyshot™ 35 lb. carton	Cream	Extended open time	19,000	120	60 seconds	120°F	1,400	40	N/A
	6002™ Hysol®	83283 Superstick™ 10" 25 lb. carton 83285 Polyshot™ 35 lb. carton	Amber	Fast setting	3,500	700	10 seconds	150°F	200	N/A	FDA CFR175,105	
	CoolMelt™ Hysol®	83393 CoolMelt™ Maxistick™ 7 oz. sample bag 83394 CoolMelt™ Maxistick™ 35 lb. carton	Off White	Low temperature	7,200	195	15 seconds	140°F	800	N/A	FDA CFR175,105	
	SuperPac™ Hysol®	83402 Maxistick™ 7 oz. sample bag 83403 Maxistick™ 35 lb. carton 83404 Polyshot™ 12 oz. sample bag 83405 Polyshot™ 35 lb. carton	Light Yellow	Cardboard bonder	5,750	280	30 seconds	144°F	200	N/A	FDA CFR175,105	
	QuikPac™ Hysol®	83395 5 lb. sample bag pellets 83397 Maxistick™ 7 oz. sample bag 83398 Maxistick™ 35 lb. carton 83399 Polyshot™ 12 oz. sample bag 83400 Polyshot™ 35 lb. carton	Light Yellow	Low viscosity	4,645	N/A	15 seconds	174°F	N/A	N/A	FDA CFR175,105	
	WaxPac™ Hysol®	83408 Maxistick™ 7 oz. sample bag 83410 Polyshot™ 12 oz. sample bag	Tan	Wax coating bonder	2,700	730	30 seconds	150°F	N/A	N/A	FDA CFR175,105	

 Indicates TOP CHOICE products.

Light Cure Adhesives

Versatile Loctite® ultraviolet (UV) and visible light curing adhesives can be used in bonding, encapsulating, coating, tacking and sealing applications. These single-component, solvent-free products cure in seconds when exposed to UV/visible light sources. Some light cure adhesives can be combined with activator-curing methods to meet specific application requirements.



EPOXY ADHESIVES

LOCTITE® 3335™ LIGHT CURE ADHESIVE *UV Cationic Epoxy*

A one-part, medium viscosity, cationic epoxy. Excellent for surface cure – no oxygen inhibition. Low outgassing, very good high temperature resistance. Rigid, low shrinkage.

LOCTITE® 3336™ LIGHT CURE ADHESIVE

A UV cure, medium viscosity, two-part epoxy. UV cure effects fast gelation. Complete cure at room temperature or heat cure. Tough and durable. Designed for potting, bonding, and sealing.

LOCTITE® 3337™ LIGHT CURE ADHESIVE *UV Cationic Epoxy*

A one-part, flexible, medium viscosity, cationic epoxy. Excellent for surface cure with low shrinkage and low outgassing. Use for bonding, coating and tacking applications on metal, plastic or glass substrates.

LOCTITE® 3340™ LIGHT CURE ADHESIVE

UV Cationic Epoxy

A one-part, rigid, medium viscosity, cationic epoxy. Exhibits good thermal, water and chemical resistance with metal, plastic and glass substrates.



LOCTITE® 3355™ LIGHT CURE ADHESIVE

Pre-Activated Epoxy

A UV cure, medium viscosity, one-part epoxy. Unique delay feature allows UV cure of non-light-transmitting substrates. Extremely low shrinkage is ideal when alignment of small parts is critical. Low outgassing and acid free.

CYANOACRYLATE ADHESIVES

LOCTITE® 4306™/4307™ FLASHCURE® LIGHT CURE ADHESIVES

Instant Adhesive



New, patented technology. One-component, low or high viscosity fluorescent adhesives. Specifically formulated for extremely rapid UV or visible light cure and secondary cyanoacrylate cure mechanism. Eliminates the need for solvent-based accelerators.

SILICONE ADHESIVES

LOCTITE® 5031™ NUVA-SIL® SILICONE POTTING COMPOUND

High Adhesion/Visible Light



A UV or visible light curing silicone for high speed potting, coating and sealing applications. High adhesion for difficult-to-bond substrates.

LOCTITE® 5033™ NUVA-SIL® SILICONE ADHESIVE SEALANT

Paste/High Adhesion/Visible Light



A UV or visible light and moisture curing silicone for high speed adhesion and sealing applications. High adhesion for difficult-to-bond substrates.

LOCTITE® 5039™ NUVA-SIL® SILICONE ADHESIVE SEALANT

Cure-In-Place Gasketing Compound



A UV or visible light and moisture curing silicone for high speed adhesion, gasketing and sealing applications. High adhesion for difficult-to-bond substrates.



ACRYLIC ADHESIVES

LOCTITE® 352™ LIGHT CURE ADHESIVE

A high viscosity adhesive that creates a tough, flexible bond that is resistant to vibration and shock. Effective on a wide range of materials. Cures in minutes using an activator, UV light, or both.



LOCTITE® 3103™ LIGHT CURE ADHESIVE

Thixotropic, flexible, low modulus, medium viscosity, UV/visible light cure adhesive for flexible bonds and reduced stress cracking on plastics. Cures through UV blocked and tinted substrates. Also for potting, sealing, and gap filling.

LOCTITE® 3105™ LIGHT CURE ADHESIVE

A high strength, low viscosity, UV/visible light cure adhesive. Primarily designed for bonding rigid and flexible PVC to polycarbonate. Enables easy assembly of components with close-fitting tolerances. Recommended for applications involving small gaps less than 0.25 mm.

LOCTITE® 3106™ LIGHT CURE ADHESIVE

A high strength, medium viscosity, thixotropic, UV/visible light cure adhesive. Designed primarily for bonding rigid and flexible PVC to polycarbonate where large gap filling capabilities and a flexible joint are desired.



LOCTITE® 3107™ LIGHT CURE ADHESIVE

A low viscosity, UV/visible light cure adhesive for difficult-to-bond plastics including plasticized PVC. Very rapid cure. Flexible and fluorescent.

LOCTITE® 3108™ LIGHT CURE ADHESIVE

A low durometer, rubbery, UV cure adhesive for potting and sealing of plastic, glass, and metal. Very flexible and resilient.

LOCTITE® 3175™ LIGHT CURE ADHESIVE

A solvent-free adhesive designed for applications where a rapid cure and a dry-to-the-touch surface are required. Excellent for tacking and coating. Good adhesion to plastics.

LOCTITE® 3491™ LIGHT CURE ADHESIVE

A fast curing, medium viscosity adhesive designed for bonding glass-to-glass and to a variety of other surfaces.

LOCTITE® 3492™ LIGHT CURE ADHESIVE

A fast curing, low viscosity adhesive designed for bonding glass-to-glass and to a variety of other surfaces.

LOCTITE® 3494™ LIGHT CURE ADHESIVE

A durable, UV/visible cure, medium viscosity adhesive designed for glass and metal bonding.

LOCTITE® 3525™ LIGHT CURE ADHESIVE

A UV/visible cure, high viscosity adhesive. Fast cure, colorless bonds. Excellent flexibility, toughness, and durability to moisture exposure. Fluorescent. Used to bond glass, metal, and plastics.

LOCTITE® 3526™ LIGHT CURE ADHESIVE

A UV/visible/heat cure version of Loctite® 3525™ Light Cure Adhesive. All the properties of Loctite® 3525™ plus low temperature, rapid, heat cure capabilities (250°F). Fast cure even under low energy sources. Fluorescent.

LOCTITE® 3552™ / 3553™ INDIGO™ VISIBLE LIGHT CURE ADHESIVES

NEW

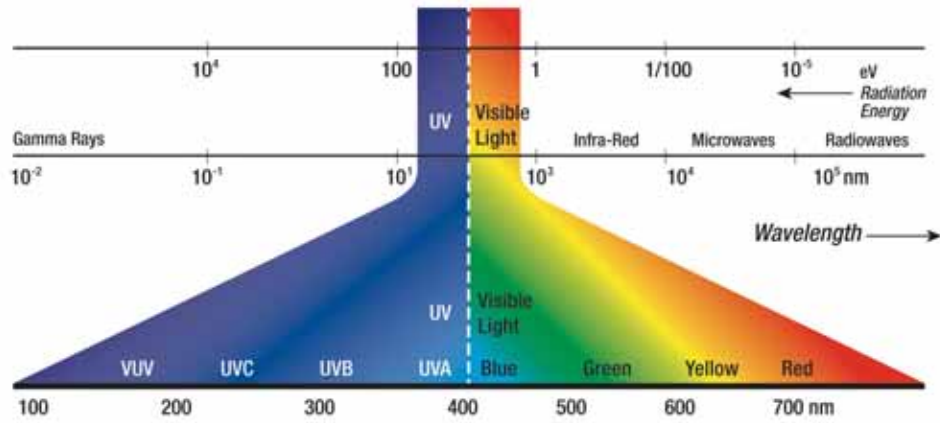
High and low viscosity adhesives that cure in the visible spectrum offering properties and performance similar to most UV/visible adhesives. Visible light adhesives cure with unique systems that minimize venting or specialized safety equipment. Benefits include lower initial investment and reduced maintenance costs.



www.visible.loctite.com

Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.

The Electromagnetic Spectrum



Loctite® Light Cure Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	APPEARANCE, CLARITY, AND COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP), BROOKFIELD, 25°C	ELONGATION AT BREAK (%)	SHORE HARDNESS	TEMPERATURE RANGE	AGENCY APPROVALS	
EPOXY ADHESIVES	3335™	30288 30289	25 ml syringe 1 liter bottle	Clear/Colorless	Ultraviolet, cationic	Metal, glass, thermoplastic	6,000	2	D 84	-65°F to 325°F	N/A
	3336™	31064 31065	42 ml dual syringe 400 ml dual syringe	Clear/Light Amber	Ultraviolet, room temperature, heat	Metal, thermoplastic	14,500	6	D 79	-65°F to 350°F	N/A
	3337™	36057 36058*	25 ml syringe 1 liter bottle	Clear	Ultraviolet, cationic	Metal, glass	5,000	7	D 80	-65°F to 350°F	N/A
	3340™	36906 36907*	25 ml syringe 1 liter bottle	Transparent	Ultraviolet, cationic	Metal, glass	6,000	5	D 83	-65°F to 350°F	N/A
	3355™	40792 40793	25 ml syringe 1 liter bottle	Hazy White	Ultraviolet, delay cure	Metal, plastic, glass, ceramic	5,000	11.5	D 77	-65°F to 350°F	N/A
CYANOACRYLATE ADHESIVES	4306™ Flashcure®	37439 37442	1 oz. bottle 1 lb. bottle	Clear/ Pale Green/ Fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	20	9	D 72	-65°F to 180°F	ISO-10993 Compliant
	4307™ Flashcure®	37441 37443	1 oz. bottle 1 lb. bottle	Clear/ Pale Green/ Fluorescent	Ultraviolet, visible, moisture	Elastomer, metal, polycarbonate, thermoplastic	900	6	D 477	-65°F to 180°F	ISO-10993 Compliant
SILICONE ADHESIVES	5031™ Nuva-Sil®	40086 40087	300 ml cartridge 40 lb. pail	Translucent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	5,500	100	A 34	-65°F to 350°F	N/A
	5033™ Nuva-Sil®	40088 40089	300 ml cartridge 40 lb. pail	Translucent/ Colorless/ Fluorescent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 g/min.†	170	A 55	-65°F to 350°F	N/A
	5039™ Nuva-Sil®	40438 40439	300 ml cartridge 40 lb. pail	Translucent/ Colorless/ Fluorescent	Visible, ultraviolet, moisture, acetoxo	Glass, metal, ceramic	220 g/min.†	210	A 37	-65°F to 350°F	N/A
	5083™ Nuva-Sil®	17528 17635	300 ml cartridge 40 lb. pail	Translucent/ Colorless	Ultraviolet, moisture, acetoxo	Glass, metal, ceramic	145 g/min.†	170	A 55	-65°F to 350°F	UL Classified for U.S.
	5091™ Nuva-Sil®	17412 18074	300 ml cartridge 40 lb. pail	Translucent/ Colorless	Ultraviolet, moisture, acetoxo	Glass, metal, ceramic	5,500	100	A 34	-65°F to 350°F	UL Classified for U.S.



Indicates worldwide availability.


* Made-to-order item.

† Extrusion rate, grams/minute, 1/8" orifice at 90 psi.



Indicates TOP CHOICE products.

Loctite® Light Cure Adhesives Properties Chart

PRODUCT		Item Number	Package Type & Size	APPEARANCE, CLARITY, AND COLOR	CURE TYPE	KEY SUBSTRATES	VISCOSITY (cP), BROOKFIELD, 25°C	ELONGATION AT BREAK (%)	SHORE HARDNESS	TEMPERATURE RANGE	SHEAR STRENGTH (PSI)
VISIBLE	3552™ Indigo™  	40971 40972	25 ml syringe 1 liter bottle	Clear/ Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	200	12	57	-65°F to 300°F	2,000 ³
	3553™ Indigo™  	40977 40973	25 ml syringe 1 liter bottle	Clear/ Light Yellow	Visible	Polycarbonate, thermoplastic, polyvinylchloride	3,400	30	74	-65°F to 300°F	1,500 ³
ULTRAVIOLET / VISIBLE	3100™ 	19862	25 ml syringe	Slightly Hazy/Straw	Ultraviolet, visible	Glass, metal, thermoset plastic	6,000	210	D 66	-65°F to 300°F	1,670 ²
	3102™ 	23690	1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic	3,750	265	D 59	-65°F to 300°F	2,291 ³
	3103™ 	23691 23692	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic	10,000 Thixotropic	260	D 51	-65°F to 300°F	2,849 ³
	3104™ 	23694 23693	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	160	50	D 69	-65°F to 300°F	3,155 ³
	3105™ 	23695 23696	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	300	265	D 64	-65°F to 300°F	3,640 ³
	3106™  	23697 23698	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Polycarbonate, thermoplastic, polyvinylchloride	5,000	250	D 53	-65°F to 300°F	3,392 ³
	3107™	28419 28466	6 ml tube 1 liter bottle	Clear/Straw/ Fluorescent	Ultraviolet, visible	Plasticized PVC, thermoplastic	500	220	D 27	-65°F to 300°F	783 ⁴
	3494™	30765 29487	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet, visible	Glass, metal	5,500	190	D 65	-65°F to 300°F	2,440 ¹
	3525™	30220 30221	25 ml syringe 1 liter bottle	Clear/Pale Straw/ Fluorescent	Ultraviolet, visible	Glass, metal, thermoset plastic	15,000	260	D 60	-65°F to 300°F	1,480 ¹
	3526™	30756 30764	25 ml syringe 1 liter bottle	Clear/Pale Straw/ Fluorescent	Ultraviolet, visible, heat	Glass, metal, thermoset plastic	17,800	185	D 62	-65°F to 300°F	1,530 ¹
ULTRAVIOLET	349™ Impruv® 	34931 34990	50 ml bottle 1 liter bottle	Clear/Straw	Ultraviolet	Glass, metal	9,500	300	D 70	-65°F to 266°F	1,600 ¹
	363™ Impruv®	36331 36390	50 ml bottle 1 liter bottle	Clear/Pale Straw	Ultraviolet	Metal, thermoset plastic	250	88	D 50	-65°F to 356°F	1,740 ¹
	3108™	28400 28465	25 ml syringe 1 liter bottle	Translucent/ Colorless	Ultraviolet	Thermoplastic, thermoset plastic	5,100	330	A 72	-65°F to 300°F	2,090 ³
	3175™	29505 29506	25 ml syringe 1 liter bottle	Clear/Straw	Ultraviolet	Various	4,000	14	D 70	-65°F to 300°F	370 ¹
	3491™	28366 17944	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet	Glass, metal	1,100	27	D 75	-65°F to 300°F	1,450 ¹
	3492™	28367 18666	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet	Glass, metal	500	5	D 79	-65°F to 300°F	1,200 ¹
	3493™	28368 18751	25 ml syringe 1 liter bottle	Clear/Pale Straw	Ultraviolet	Glass, metal	5,500	260	D 75	-65°F to 300°F	1,250 ¹
	3751™ LiteTak®	21362 21363	25 ml syringe 1 liter bottle	Clear/Colorless	Ultraviolet	Various	10,000	50	D 73	-65°F to 275°F	700 ³
	3761™ LiteTak®	21359 21360	25 ml syringe 1 liter bottle	Clear/Straw	Ultraviolet	Various	2,500	57	D 69	-65°F to 275°F	800 ³
	352™ 	35241 35286	50 ml bottle 1 liter bottle	Clear/Light Amber	Ultraviolet, heat, activator	Glass, metal	19,500	290	D 60	-65°F to 275°F	2,400 ¹
	366™ 	36631 12224	50 ml bottle 1 liter bottle	Clear/Light Amber	Ultraviolet, heat, activator	Glass, metal	7,500	240	D 45	-65°F to 230°F	1,450 ¹
	3101™ 	19861	25 ml syringe	Slightly Hazy/Straw	Ultraviolet, heat, activator	Glass, metal, thermoset plastic	6,000	220	D 66	-65°F to 300°F	1,820 ²



Indicates worldwide availability.

¹ Grit Blasted Steel to Glass

² Etched Aluminum

³ Polycarbonate to Polycarbonate

⁴ Polycarbonate to PVC



Indicates TOP CHOICE products.

Modified Silanes

Modified silane adhesives are our newest Loctite® product line. These products exhibit high flexibility and low durometer while maintaining high tensile strength and good adhesion to many substrates without the use of a primer. These products are isocyanate, and solvent free, non-corrosive, and are compatible with most paint systems.



When in contact with ambient moisture, modified silanes begin to cure in the same manner as silicones. Ideal for bonding and sealing a multitude of substrates, as well as many applications where silicones cannot be used due to their incompatibility with paint systems.

LOCTITE® MS 930™ ELASTIC SEALANT **NEW**

High elongation and good peel strength make this product a great choice for aggressive seam sealant applications.

LOCTITE® MS 939™ ELASTIC ADHESIVE **NEW** *Adhesive/Sealant*

High elongation and tensile strength give this product the best of both worlds. With good adhesion to many substrates, and good impact and peel resistance, this product is a great fit for both bonding and sealing applications.



LOCTITE® MS 9360™ ELASTIC ADHESIVE **NEW**

This product exhibits the highest shear strength on a majority of substrates versus the other products in this line.

DISPENSING OPTIONS

Loctite® 300 ml Pneumatic Cartridge Dispenser is a manually-controlled, pneumatically-operated unit for dispensing modified silanes packaged in 300 ml cartridges. The operator controls the amount and rate of application using the dispense pressure, orifice size, and manual trigger. For available valves, spare parts, accessories and dispense tips, please visit www.equipment.loctite.com.



Item Number: 97002

Dimensions: 8" H x 13.5" L x 1.5" D

Weight: 18 lbs. (800 g)

Loctite® Stainless Steel Poppet Valve is a double-acting dispense valve. Easily adapts to 300 ml cartridges or pail pump systems to dispense medium to high viscosity, modified silanes. This valve features suck-back capability and operates at fluid pressures up to 650 psi. For available spare parts, accessories and dispense tips, please visit www.equipment.loctite.com.

Item Number: 982621

Dimensions: 5.28" H x 2.00" D

Weight: 4.2 lbs. (1.9 kg)



See our **Loctite® Equipment Sourcebook, LT-3669** or visit us at www.equipment.loctite.com for more details.



Loctite® MS Polymer Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	SPECIFIC GRAVITY	EXTRUSION RATE (g/minute) **	CURE METHOD	SKIN OVER TIME	TEMPERATURE RANGE	DUROMETER (SHORE A)	ELONGATION	TENSILE STRENGTH (PSI)	SHEAR STRENGTH* (PSI)	IMPACT STRENGTH (J/in ²)	T-PEEL (PLI)
MS 930™ NEW	41378	300 ml cartridge	Black	1.44 to 1.50	150 to 250	Moisture	10 to 40 minutes	-40°F to 200°F	20 to 30	490	135	120	1.3	18.7
	41385	20 kg pail												
	41383	250 kg drum												
MS 939™ NEW 	41380	300 ml cartridge	Black	1.43 to 1.49	20 to 160	Moisture	3 to 12 minutes	-40°F to 200°F	52 to 62	500	390	270	2.4	20.1
	41387	25 kg pail												
	41382	250 kg drum												
MS 9360™ NEW	41379	300 ml cartridge	Black	1.32 to 1.42	20 to 120	Moisture	6 to 20 minutes	-40°F to 200°F	55 to 60	225	475	425	1.72	17.5
	41386	25 kg pail												
	41384	250 kg drum												

* Tensile Strength tested on grit blasted steel.

** Evaluated at 23°C, 3.5 mm diameter, 3 bar, for 15 seconds.

Indicates TOP CHOICE products.

DISPENSING OPTIONS

LOCTITE® HIGH VISCOSITY PASTE PUMP SYSTEMS

These systems are designed specifically to dispense paste products packaged in open-top pails or drums. Various pump ratios are suited for pumping medium to high-viscosity pastes. High viscosity paste pump systems are fully assembled and consist of an air motor, pump tube, and pressure ram.



Item Number	Ratio	Output per Stroke	Material	Package Size	Maximum Product Viscosity (cP)
988715	22:1	6.7 in ³	Carbon Steel	250 kg	500,000
988716	22:1	6.7 in ³	Carbon Steel	25 kg	500,000
988717	22:1	6.7 in ³	Inert Metal	250 kg	500,000
988718	22:1	6.7 in ³	Inert Metal	25 kg	500,000
988843	22:1	6.7 in ³	Carbon Steel w/Inert Seals	25 kg	500,000
988846	22:1	6.7 in ³	Carbon Steel w/Inert Seals	250 kg	500,000
988719	44:1	6.7 in ³	Carbon Steel	250 kg	1,000,000
988720	44:1	6.7 in ³	Carbon Steel	25 kg	1,000,000
988721	44:1	6.7 in ³	Inert Metal	250 kg	1,000,000
988722	44:1	6.7 in ³	Inert Metal	25 kg	1,000,000
988844	44:1	6.7 in ³	Carbon Steel w/Inert Seals	25 kg	1,000,000
988847	44:1	6.7 in ³	Carbon Steel w/Inert Seals	250 kg	1,000,000
988723	64:1	4.6 in ³	Carbon Steel	250 kg	4,000,000
988724	64:1	4.6 in ³	Carbon Steel	25 kg	4,000,000
988725	64:1	4.6 in ³	Inert Metal	250 kg	4,000,000
988726	64:1	4.6 in ³	Inert Metal	25 kg	4,000,000
988845	64:1	4.6 in ³	Carbon Steel w/Inert Seals	25 kg	4,000,000
988848	64:1	4.6 in ³	Carbon Steel w/Inert Seals	250 kg	4,000,000

Solvent - Based Adhesives

Loctite® solvent-based aerosol and liquid adhesives provide a combination of cure speed, impact resistance, strength, temperature range, and solvent and moisture resistance to meet tough on-the-job requirements.



SOLVENT-BASED

LOCTITE® BLACK CONTACT ADHESIVE

A professional, solvent-based adhesive with neoprene that blends in with black colored fabrics, rubbers, weather-stripping and other porous materials. Withstands temperature extremes and is resistant to gasoline, kerosene, and other solvents. Fast drying and waterproof. Allows repositioning of the parts after initial contact.

LOCTITE® CONTACT ADHESIVE

A fast-drying, solvent-based adhesive with neoprene that bonds rubber, insulation, weather-stripping, and other porous materials. Sets to a tack-free surface in 3 to 4 minutes, and the early strength is enough to hold most parts together. Allows repositioning of the parts after initial contact.

SPRAY ADHESIVES

LOCTITE® MAXIMUM STRENGTH HEADLINER ADHESIVE

A high strength, aerosol product designed for bonding foam, carpet, fabrics, plastics, rubber, etc. Loctite® Maximum Strength Headliner Adhesive is resistant to extreme seasonal temperatures, is water-resistant, and sprays on clear.

LOCTITE® ALL-PURPOSE SPRAY ADHESIVE

Bonds lightweight, porous, and non-porous surfaces. Allows for repositionable and permanent bonds. Fast drying; won't shrink or bleed. Resists water and humidity. Contains no ozone-depleting compounds.

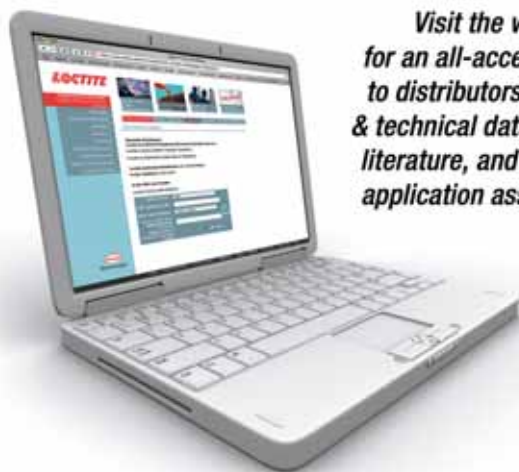


Loctite® Rubber-Based Adhesives Properties Chart

PRODUCT		Item Number	Package Type & Size	TEMPERATURE RANGE	COLOR/ APPEARANCE	FIXTURE/ BOND TIME	FULL CURE	COMMON SURFACES ADHESIVE WILL BOND	AGENCY APPROVALS
SOLVENT-BASED	Black Contact Adhesive	30540	5 fl. oz. tube	Up to 180°F	Black Gel	Let breathe 2-3 minutes, sets up in 5 to 15 minutes.	24 hours at ambient temperature	Weather-stripping, vinyl, rubber, wood, and metal	CFIA
	Contact Adhesive	30537	5 fl. oz. tube	Up to 180°F	Yellow Gel				CFIA
SPRAY ADHESIVES	Maximum Strength Headliner Adhesive	37312	16.75 oz. net wt. aerosol	Up to 170°F	Clear Drying, Semi-Translucent Foam	Let dry 15 to 20 minutes before assembly. Spray both sides for maximum strength.	24 hours at ambient temperature	Foam, carpet, fabrics, plastics, and rubber	N/A
	All-Purpose Spray Adhesive	30544	10.5 oz. net wt. aerosol	Up to 120°F					N/A

1.800.LOCTITE (562.8483)

www.loctite.com/distributor



Visit the web for an all-access pass to distributors, safety & technical data sheets, literature, and product application assistance.



Helpful Hints

For faster fixturing of these solvent-based contact adhesives, apply the adhesive to both sides of the parts, and allow to breathe for one to two minutes. When the surface starts to appear dry, apply a small additional amount of adhesive to one side and assemble the sides together.

The bond will be instant!

Structural Acrylic Adhesives

Loctite® 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



Two-Step No-Mix Structural Acrylic Adhesives – when in contact with a liquid activator, these no-mix materials cure rapidly at room temperature to a weather-resistant bond. Ideal for close-fitting parts and where extended open time is required.

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.



LOCTITE® 330™ DEPEND® ADHESIVE

General Purpose

A general purpose, high viscosity adhesive for a wide range of materials, including metal, wood, ferrite, ceramic, and plastic.



Helpful Hints

- Activators are used to promote the cure speed of any Loctite® 2-step acrylic adhesive. Select the right Loctite® activator for your application.

Loctite® Activators	Base	For Use with Loctite® Product
7075™	Acetone	324™ and 325™ Speedbonder™ Adhesives
7380™	Solvent-free	All Speedbonder™ Adhesives
7387™	Heptane/Isopropanol	Most Speedbonder™ Adhesives

For ordering information, please see pages 98-99 in the Surface Preparation Section

Two-Part Structural Acrylic Adhesives – when statically mixed, these adhesives develop a tough, durable bond to a wide variety of substrates, including metals, plastics, and composites. Loctite® two-part structural acrylics are ideal for large gap filling applications. They are available in mixer-friendly packaging to minimize waste and process time. Refer to the *Loctite® Equipment Sourcebook, LT-3669*, for available dual cartridge dispensers and mix nozzles, or visit our equipment website at www.equipment.loctite.com.

GENERAL PURPOSE

LOCTITE® H3000™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Medium Fixture

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

LOCTITE® H3101™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Medium Fixture/Open time

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



LOCTITE® H3300™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Fast Fixture

A non-sag, fast fixturing structural adhesive for bonding a variety of substrates.

METAL BONDING

LOCTITE® H3151™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Extended Open time

Extended open time allows for adjustment of parts. Excellent bond strength on aluminum and steel. Impact and peel resistant.



LOCTITE® H4500™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Fast Fixture

High strength structural adhesive for metals. Fixtures in 10 minutes.

LOCTITE® H4720™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Corrosion Resistant

Maintains superior strength in corrosive environments. Excellent general purpose metal bonder.

PLASTIC/COMPOSITE BONDING

LOCTITE® H4000™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Non-Sag

A fast fixturing structural adhesive for bonding various plastic and composite substrates, including epoxy coat and glass fiber reinforced polyester.

LOCTITE® H4200™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Toughened

A plastic and composite bonder with high peel and impact resistance. Fixtures in 15 minutes.

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® H6051™ SPEEDBONDER™ STRUCTURAL ADHESIVE

UV Resistance

A white UV resistant adhesive ideal for bonding gel-coated surfaces. Excellent non-sagging properties. Longer open time allows for the adjustment of larger parts.



HIGH TOUGHNESS

LOCTITE® H8000™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Fast Fixture

Features fast fixture time and excellent peel strength on multiple substrates, especially aluminum.



LOCTITE® H8500™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Ultra Tough

Excellent peel strength on steel and aluminum. Provides extended open time making it ideal for assembly and adjustment of large parts.

HIGH TEMPERATURE/ CHEMICAL RESISTANCE

LOCTITE® H8600™ SPEEDBONDER™ STRUCTURAL ADHESIVE

Galvanized Bonder

Excellent impact and shear strength on steel and aluminum. Especially designed for severe environments.



POLYOLEFIN BONDING

LOCTITE® 3032™ STRUCTURAL ADHESIVE

Fast Fixture

A fast curing thixotropic acrylic adhesive. Designed to bond low energy plastic substrates. Excellent polypropylene bonder.



LOCTITE® 3034™ STRUCTURAL ADHESIVE

Toughened

Extended open time allows for adjustment of parts. Excellent peel and shear strength on polyethylene plastics.



DISPENSING OPTIONS

Loctite® 50 ml Hand Pumps are portable, precision, bottle-top applicators that thread directly onto any 50 ml Loctite® bottle. They are designed to dispense at any angle from 0.01 to 0.04 ml without leaks or product waste.

For available spare parts, accessories and dispense tips, please visit www.equipment.loctite.com.

Item Number: 98414
 Dimensions - Pump: 4" H x 5.75" W x 1.5" D
 Dimensions - Stand: 4.5" H x 3.75" W x 2.25" D



Loctite® Dispense Tips

Henkel offers a comprehensive line of Loctite® tapered polyethylene and flexible polypropylene dispense tips. All tips are designed to stay intact during the toughest applications and provide reliable and consistent dispensing shot after shot.

For available accessories and dispense tips, please visit www.equipment.loctite.com.

Loctite® Cartridge Dispense Tip,
 1/4" Male NPT
 Item Number: 98128



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

PRODUCT	Item Number	Package Type & Size	TYPICAL USE	COLOR	GAP FILL	VISCOSITY (cP) at 20 RPM	SHEAR STRENGTH* (PSI)	TEMPERATURE RANGE	CURE SPEED	RECOMMENDED PRIMER	SPECIFIC GRAVITY	AGENCY APPROVALS
312™ Speedbonder™	03333 00144 31231 31243	10 ml kit ¹ 50 ml kit ² 50 ml bottle 1 liter bottle	Fast cure on close fitting parts	Amber	0.003"	1,000	3,000	-65°F to 300°F	Fixture – 30 sec.* Full – 24 hrs.	736™	1.08	N/A
324™ Speedbonder™	32430 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™	32530 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™	32629 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
330™ Depend®	20253 20251 20252 33058 33064 33081	3 ml kit ³ 25 ml kit ⁴ 250 ml kit ⁵ 250 ml tube 300 ml cartridge 1 liter bottle	Rough or porous surfaces	Pale Yellow	0.030"	67,500	3,300	-65°F to 250°F	Fixture – 5 min.* Full – 24 hrs.	7387™ or 7380™	1.05	CFIA
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.

- 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.

Indicates worldwide availability.

Indicates TOP CHOICE products.

DISPENSING OPTIONS

Loctite® Caulking Gun Conversion Kits for 50 ml Cartridges provide an inexpensive means of converting a household caulking gun into a hand held meter mix dispenser. Ideal for 1:1, 2:1, and 10:1 ratio two-part adhesives.

For available spare parts and dispense tips, please visit www.equipment.loctite.com.



Item Number: 98415

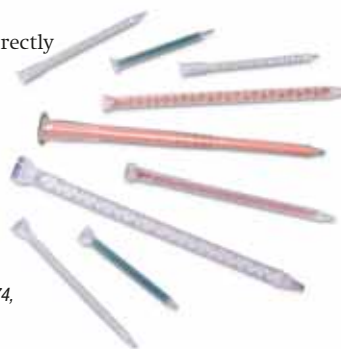


Item Number: 98466

Loctite® Mix Nozzles are plastic, disposable nozzles that attach directly to Loctite® Speedbonder™ dual cartridges. They are designed to automatically mix adhesive as it travels through the static-mix nozzle.

For available dispense tips and package sizes, please visit www.equipment.loctite.com.

Item Numbers: 98473, 98454, 98463, 98474, 98459, and 98461



Loctite® Two-Part Structural Acrylics Properties Chart

PRODUCT		Item Number	Package Type & Size	MIX RATIO	VISCOSITY (cP) (Part A / Part B)	COLOR (MIXED)	OPEN TIME IN MINUTES	FIXTURE TIME IN MINUTES	PEEL STRENGTH (PLI)	IMPACT STRENGTH (kJ/m ²)	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	H3000™ Speedbonder™	83001 83000	50 ml dual cartridge 400 ml dual cartridge	1:1	65,000 / 24,000	Cream	5	12 to 15	45	25	2,360	3,830	>1,740	>1,495	1,550	2,510	N/A
	H3101™ Speedbonder™	83007 83006	50 ml dual cartridge 400 ml dual cartridge	1:1	95,000 / 57,000	Cream	15 to 20	25	35	20 to 25	1,610	2,510	>1,810	>1,565	1,420	2,080	N/A
	H3300™ Speedbonder™	83020 83019 83024* 83022*	50 ml dual cartridge 400 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	1:1	105,000 / 120,000	Yellow	5	6	35 to 40	20	1,700	3,350	>1,650	>1,425	1,880	990	N/A
METAL BONDING	H3151™ Speedbonder™	83015 83014	50 ml dual cartridge 400 ml dual cartridge	1:1	70,000 / 70,000	Pale Yellow	35 to 40	60†	40	>42	3,600	3,770	>1,835	>1,440	1,570	1,590	N/A
	H4500™ Speedbonder™	83041	490 ml dual cartridge	10:1	54,000 / 54,000	Pale Yellow	8 to 10	10†	40	40	4,020	4,130	>1,760	>1,455	1,560	2,200	N/A
	H4720™ Speedbonder™	39011	490 ml dual cartridge	10:1	700,000 / 800,000	Grey	50 to 80	100	40	38	3,900	4,200	1,700	1,700	N/A	>490	N/A
PLASTIC/COMPOSITE BONDING	H4000™ Speedbonder™	83025 83031* 83028*	490 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	10:1	100,000 / 70,000	Pale Yellow	8	14	45	20 to 25	2,580	3,500	>1,645	>1,500	790	1,980	NSF® ANSI 61
	H4100™ Speedbonder™	83032	490 ml dual cartridge	10:1	95,000 / 145,000	Pale Yellow	2	3-5	13	8	710	3,140	>1,725	>1,405	2,270	2,850	N/A
	H4200™ Speedbonder™	83038	490 ml dual cartridge	10:1	95,000 / 45,000	Pale Yellow	5	15	55	>42	2,870	4,020	>1,640	>1,520	740	2,440	N/A
	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 to 25	35	50	>42	1,810	3,930	>1,725	>1,590	530	2,090	N/A
	H6051™ Speedbonder™	83062 83065 83063	490 ml dual cartridge 38 lb. pail, adhesive 60 lb. pail, activator	10:1	100,000 / 95,000	White	30 to 35	50	35	N/A	1,400	2,400	900	1,000	N/A	N/A	N/A
HIGH TOUGHNESS	H8000™ Speedbonder™	36160 35939* 35940*	490 ml dual cartridge 35 lb. pail, adhesive 45 lb. pail, activator	10:1	160,000 / 40,000	Green	10 to 15	15 to 20	50 to 60	>42	3,000	3,500	>1,600	>1,500	460	1,740	N/A
	H8500™ Speedbonder™	40884 40888* 40889*	490 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	10:1	600,000 / 900,000	Grey	20 to 30	15 to 20	70 to 80	>42	2,600	2,900	1,100	1,600	N/A	>960	N/A
HIGH TEMP./CHEMICAL RESISTANCE	H8600™ Speedbonder™	40875 38762 38760* 38761*	50 ml dual cartridge 400 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	2:1	80,000 / 95,000	Blue	10 to 15	40 to 45	40	35 to 40	4,500	5,500	>1,900	1,600	N/A	>800	N/A
POLYOLEFIN BONDING	3030™	37220	35 ml dual cartridge	10:1	30,000 / 5,000	Off White	2 to 3	10	2 to 4	6	975	1,450	N/A	N/A	1,330	2,000	N/A
	3032™	40759 40760	35 ml dual cartridge 490 ml dual cartridge	10:1	15,000 / 3,000	Clear Yellow	2 to 3	10	2 to 4	6	N/A	N/A	N/A	N/A	N/A	N/A	N/A
	3034™	960971 960973	35 ml dual cartridge 490 ml dual cartridge	10:1	69,000 / 2,000	Translucent	10 to 15	60	5 to 7	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

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

* Made-to-order item.
† Fixture time measured on steel.

Indicates TOP CHOICE products.

Structural Epoxy & Urethane Adhesives

Henkel offers a complete line of one-part and two-part epoxy and urethane adhesives for structural bonding. This Loctite® Hysol® line contains a wide range of application-specific products designed to outperform the competition in all aspects:

- Better Adhesion
- Better Flow
- Less Odor
- Higher Strength
- Greater Durability
- Improved Clarity

From fast setting to high temperature properties, Loctite® Hysol® epoxy and urethane adhesives offer a variety of performance benefits to meet your assembly requirements.



FAST SETTING

LOCTITE® E-00CL™ HYSOL® EPOXY ADHESIVE

Low Odor

A clear, flowable, fast setting epoxy with a 5-minute worklife.

LOCTITE® E-00NS™ HYSOL® EPOXY ADHESIVE

Non-Sag

A translucent, controlled flow, low odor epoxy with a 5-minute worklife.

LOCTITE® E-05CL™ HYSOL® EPOXY ADHESIVE

Toughened

An ultra clear, high peel, low odor epoxy with a 5-minute worklife.

LOCTITE® 608™ HYSOL® EPOXY ADHESIVE

High Strength

A fast setting, low odor epoxy with a 5-minute worklife. Cures at room temperature to form a clear bondline.



LOCTITE® D609™ HYSOL® EPOXY ADHESIVE

Clear

A high performance epoxy with a 5-minute worklife. Low odor, very fast room temperature cure, heat resistant to 180°F.

LOCTITE® 615™ HYSOL® EPOXY ADHESIVE

Sandable

A high strength, low odor epoxy with a 10-minute worklife. Blue, fast cure, gap filling.

GENERAL PURPOSE

LOCTITE® 0151™ HYSOL® EPOXY ADHESIVE

Ultra Clear

A general purpose, thixotropic paste epoxy with a 50-minute worklife. Allows for extended adjustment time.

LOCTITE® E-30CL™ HYSOL® EPOXY ADHESIVE

Glass Bonder

An ultra clear, low viscosity, impact resistant epoxy with a 30-minute worklife.



LOCTITE® E-40FL™ HYSOL® EPOXY ADHESIVE

Flexible

A grey, impact resistant, toughened epoxy with a 40-minute worklife.

LOCTITE® E-60NC™ HYSOL® EPOXY ADHESIVE

Non-Corrosive/Potting

An electronics-grade potting compound with a 60-minute worklife. Black, opaque, low viscosity, potting compound with excellent cure-through depth.

LOCTITE® E-90FL™ HYSOL® EPOXY ADHESIVE

Flexible

A grey, impact resistant, toughened epoxy with a 90-minute worklife.

LOCTITE® U-09FL™ HYSOL® URETHANE ADHESIVE

Highly Flexible

A two-part, high performance urethane adhesive for plastic bonding with a 10-minute worklife. Ultra clear, impact resistant, high peel.

GENERAL PURPOSE CONT.

**LOCTITE® U-09LV™ HYSOL®
URETHANE ADHESIVE***Low Viscosity*

A two-part, high performance urethane adhesive for plastic bonding with a 10-minute worklife.

**HIGH TEMPERATURE/
CHEMICAL RESISTANCE****LOCTITE® 1C™ HYSOL®
EPOXY ADHESIVE***Gap Filling*

A high viscosity paste with a 20-minute worklife. Excellent gap filling capability and performance properties.

**LOCTITE® E-20NS™ HYSOL®
EPOXY ADHESIVE***Metal Bonder*

A light tan, non-sag, high peel, high shear epoxy with a 20-minute worklife.

**LOCTITE® E-214HP™ HYSOL®
EPOXY ADHESIVE***High Strength*

A one component, heat cure epoxy. Grey, temperature resistant, non-sag.

LOCTITE® 9340™ HYSOL® EPOXY ADHESIVE*Environmental Resistance*

A green, high viscosity epoxy with a 90-minute worklife. Excellent high temperature and chemical resistance.

**LOCTITE® 9432NA™ HYSOL®
EPOXY ADHESIVE***Non-Sag*

A grey, one component paste, heat cure epoxy. Excellent high temperature performance, excellent chemical resistance, surface insensitive.

**LOCTITE® 9459™ HYSOL® EPOXY ADHESIVE***High Temperature Resistance*

A one component, heat cure epoxy. Low viscosity, self-leveling. Light grey, excellent high temperature performance, excellent chemical resistance.

HIGH TOUGHNESS**LOCTITE® E-20HP™ HYSOL®
EPOXY ADHESIVE***Fast Setting*

A high strength epoxy with a 20-minute worklife. Off white, toughened, high peel, high shear.

**LOCTITE® E-60HP™ HYSOL®
EPOXY ADHESIVE***Toughened*

A high strength epoxy with a 60-minute worklife. Off white, high peel, high shear.

**LOCTITE® E-120HP™ HYSOL®
EPOXY ADHESIVE***Ultra Strength*

An amber, non-sag, aerospace grade epoxy with a 120-minute worklife.

**LOCTITE® 3981™/3982™/3984™
HYSOL® EPOXY ADHESIVES***High Performance/Various Substrates*

Highly fluorescent, one component, heat cure epoxy adhesives offering superior physical, environmental and performance properties.

LOCTITE® 3985™ HYSOL® EPOXY ADHESIVE*Non-Sag*

A one component, heat cure epoxy. Ideal for bonding wires to motor armatures.

LOCTITE® 9430™ HYSOL® EPOXY ADHESIVE*High Strength*

An off white, toughened, light paste, high peel, high shear strength epoxy with a 40-minute worklife.

LOCTITE® 9433™ HYSOL® EPOXY ADHESIVE*Self-Leveling*

A high strength epoxy with a 30-minute worklife. Cream in color, flowable, toughened, high peel resistance.

LOCTITE® 9460™ HYSOL® EPOXY ADHESIVE*Non-Sag*

A grey, impact resistant, high viscosity, high peel, high shear epoxy with a 30-minute worklife.

**LOCTITE® U-05FL™ HYSOL®
URETHANE ADHESIVE***High Strength*

A two-part, high performance urethane adhesive for metal bonding with a 5-minute worklife. Off white, highly flexible, impact and moisture resistant, high peel, high shear.

DISPENSING OPTIONS

Loctite® 50 ml Dual Cartridge Manual Applicator provides a convenient, cost-effective method to apply product with minimal waste. This applicator is compatible with 1:1 and 2:1 mix ratio products. For additional accessories, dispense tips and spare parts, please visit www.equipment.loctite.com.

Item Number: 98472



Loctite® 200/400 ml Dual Cartridge Manual Applicators are ideally suited for production line applications and provide a convenient, cost-effective method to apply product with minimal waste. These applicators are available for 1:1, 2:1 and 10:1 mix ratio products. For additional accessories, dispense tips and spare parts, please visit www.equipment.loctite.com.

Item Numbers:
983436, 983438
and 985246



Loctite® Hysol® Structural Epoxy & Urethane Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	FEATURES	COLOR	VISCOSITY AT 25°C	WORKLIFE	MIX RATIO BY VOLUME (RESIN:HARDENER)	PEEL STRENGTH (PIW)	OVERLAP SHEAR STRENGTH* (PSI)	Tg °C	HARDNESS (SHORE D)	AGENCY APPROVALS	
FAST SETTING	E-00CL™ Hysol®	29289 29290 29291	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Fast setting, flowable, low odor	Clear	Resin – 9,300 cPA Hardener – 2,700 cPA	3 to 5 min.	1:1	1-5	2,000 to 4,000	20	80	CFIA
	E-00NS™ Hysol®	29294 29295 29296	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Non-sag, controlled flow, low odor	Trans-lucent	Resin – 375,000 cPA Hardener – 2,800 cPA	3 to 5 min.	1:1	1-5	2,000 to 4,000	20	80	CFIA
	E-05CL™ Hysol®	29299 29300 29301 29302** 29303**	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Toughened, high peel, low odor	Ultra Clear	Resin – 1,900 cPA Hardener – 2,800 cPA	3 to 5 min.	1:1	5-30	2,000 to 4,000	10	55	CFIA
	608™ Hysol®	83086 83075 83082 83083** 83088** 83087**	4 g foil pack 50 ml dual cartridge EPK 2.8 oz. kit 5 lb. kit 45 lb. pail, resin 45 lb. pail, hardener	Fast cure, clear, high strength	Clear	Resin – 325,000 cPA Hardener – 30,000 cPA	5 min.	1:1	N/A	2,000	N/A	80	CFIA
	D609™+ Hysol®	83089	50 ml dual cartridge	Fast cure, clear, high strength	Clear	Resin – 15,000 cPA Hardener – 15,000 cPA	5 min.	1:1	N/A	2,800	N/A	75	N/A
	615™ Hysol®	83094 83095**	EPK 3.2 oz. kit 12 lb. kit	Fast cure, gap filling, sandable	Blue	Resin – 700,000 cPA Hardener – 140,000 cPA	10 min.	1:1	N/A	2,500	N/A	65	CFIA
GENERAL PURPOSE	0151™ Hysol®	83069 83176 83179 83178 83181** 83180**	50 ml dual cartridge EPK 3.3 oz. kit 2.6 lb. kit 10.7 lb. kit 40 lb. pail, resin 6.8 lb. can, hardener	General purpose, ultra clear, extended work life	Clear	Resin – 70,000 cPA Hardener – 60,000 cPA	50 min.	2.7:1	N/A	1,850	58	85	CFIA
	E-30CL™ Hysol®	29329 29330 29331	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Glass bonder, low viscosity, impact resistant	Ultra Clear	Resin – 10,500 cPA Hardener – 2,200 cPA	30 min.	2:1	5-30	2,000 to 4,000	70	85	CFIA
	E-40FL™ Hysol®	29304 29305 29306	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Toughened, flexible, impact resistant	Grey	Resin – 75,000 cPA Hardener – 65,500 cPA	40 min.	1:1	5-40	1,000 to 3,000	30	75	CFIA
	E-60NC™ Hysol®	29324 29325 29326	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Potting††, electrically non-corrosive, low viscosity	Black Opaque	Resin – 6,200 cPA Hardener – 13,000 cPA	60 min.	1:1	1-5	1,000 to 3,000	55	85	CFIA
	E-90FL™ Hysol®	29309 29310 29311 29312** 29313**	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Toughened, flexible, impact resistant	Grey	Resin – 71,500 cPA Hardener – 19,000 cPA	90 min.	1:1	5-40	1,000 to 3,000	-5	60	CFIA
	U-09FL™ Hysol®	29460 29461** 29462** 29370** 29371**	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 45 gallon pail, resin 5 gallon pail, hardener	Plastic bonder, highly flexible, high peel	Ultra Clear	Resin – 10,000 cPA Hardener – 1,150 cPA	10 min.	1:1	5-30‡	500 to 2,000	-20	45	N/A
	U-09LV™ Hysol®	38588 38589 38590** 38591**	50 ml dual cartridge 200 ml dual cartridge 45 gallon pail, resin 5 gallon pail, hardener	Plastic bonder, highly flexible, high peel, low viscosity	Ultra Clear	Resin – 920 cPA Hardener – 1,030 cPA	10 min.	1:1	N/A	500 to 2,000	N/A	45	N/A
	6C™ Hysol®	83211	EPK 4 oz. kit	General purpose, bonds and seals, machinable, gap filling	Grey	Resin – 235,000 cPA Hardener – 710,000 cPA	25 min.	2.5:1	N/A	1,750	98	80	CFIA
	11C™ Hysol®	83186	EPK 4 oz. kit	General purpose, bonds and seals, machinable	Black	Resin – 235,000 cPA Hardener – 710,000 cPA	25 min.	2.5:1	N/A	1,750	98	80	CFIA
	907™ Hysol®	83098	EPK 2.2 oz. kit	General purpose, minimal surface preparation	Light Blue	Resin – 100,000 cPA Hardener – 150,000 cPA	20 min.	1:1	N/A	3,100	N/A	79	CFIA
	9412™ Hysol®	83108 83107	2 lb. kit 10 lb. kit	Potting††, high strength, self-leveling	Pink	Resin – 15,000 cPA Hardener – 40 cPA	60 min.	3.5:1	35‡	4,000	N/A	75	N/A

* Tested on aluminum lap shears.
** Made-to-order item.
† Formerly Dexter® Hysol® 609.

† ASTM D3167.
EPK = Epoxi-Patch® Kit.
‡ Varies with substrates

†† For additional Potting and Encapsulating products, please see pages 76-81.

 Indicates TOP CHOICE products.



Loctite® Hysol® Epoxy & Urethane Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	FEATURES	COLOR	VISCOSITY AT 25°C	WORKLIFE	MIX RATIO BY VOLUME (RESIN:HARDENER)	PEEL STRENGTH (PIW)	OVERLAP SHEAR STRENGTH* (PSI)	T _g °C	HARDNESS (SHORE D)	AGENCY APPROVALS	
HIGH TEMPERATURE / CHEMICAL RESISTANCE	1C™ Hysol®	83200 83202 83201 83206** 83183**	EPK 4 oz. kit 4 lb. kit 17 lb. kit 60 lb. pail, resin 43 lb. pail, hardener	High temperature, gap filling	White	Resin – 235,000 cPA Hardener – 710,000 cPA	20 min.	2.5:1	N/A	1,750	98	80	CFIA
	1C-LV™ Hysol®	83208 83207	50 ml dual cartridge 200 ml dual cartridge	High temperature, gap filling, impact resistant, low viscosity	Light Tan	Resin – 82,000 cPA Hardener – 36,200 cPA	20 min.	2:1	N/A	2,100	N/A	75	N/A
	E-20NS™ Hysol®	29334 29335 29336	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Metal bonder, non-sag, high peel, high shear	Light Tan	Resin – 60,000 cPA Hardener – 30,000 cPA	20 min.	2:1	5-30	2,000 to 4,000	87	90	CFIA
	E-214HP™ Hysol®	29339 29340	30 ml cartridge 300 ml cartridge	High strength, temperature resistant, non-sag	Grey	150,000 cPA	Heat cure	1 part	30-70	3,000 to 6,000	120	85	N/A
	9340™ Hysol®	83104 83105	EPK 2.7 oz. kit 5 lb. kit	High temperature resistance, high chemical resistance	Green	Resin – paste Hardener – paste	90 min.	1:1	N/A	2,300	N/A	80	CFIA
	9432NA™ Hysol®	83217** 83216	2 lb. can 55 lb. pail	Non-sag, surface insensitive, high temperature	Grey	225,000 cPA	N/A	1 part	8	3,800	N/A	90	N/A
	9437™ Hysol®	83653 83668**	50 ml dual cartridge 200 ml dual cartridge	Transparent, high temperature and chemical resistance, machinable, sandable	Grey	Resin – 60,000 cPA Hardener – 50,000 cPA	50 min.	1:1	5	3,000	N/A	50	N/A
	9459™ Hysol®	83126	10 lb. can	High temperature resistance, self-leveling, high chemical resistance	White	39,000 cPA	6 min.	1 part	N/A	3,000	N/A	N/A	N/A
	9739™ Hysol®	83149** 83150**	42 lb. pail, hardener 3x56 lb. pail, resin	High temperature resistance, high chemical resistance	Black	Resin – 1,400,000 cPA Hardener – 2,250,000 cPA	90 min.	3.3:1	N/A	2,500	N/A	N/A	N/A

* Tested on aluminum lap shears.
** Made-to-order item.
EPK = Epoxi-Patch® Kit.

Indicates TOP CHOICE products.



Loctite® Hysol® Structural Epoxies & Urethanes Properties Chart

PRODUCT	Item Number	Package Type & Size	FEATURES	COLOR	VISCOSITY AT 25°C	WORKLIFE	MIX RATIO BY VOLUME (RESIN:HARDENER)	PEEL STRENGTH (PIW)	OVERLAP SHEAR STRENGTH* (PSI)	Tg °C	HARDNESS (SHORE D)	AGENCY APPROVALS
HIGH TOUGHNESS	E-20HP™ Hysol®	29314 50 ml dual cartridge 29315 200 ml dual cartridge 29316 400 ml dual cartridge 29317 5 gallon pail, resin 29318 5 gallon pail, hardener	High strength, rubber toughened, high peel, high shear, fast setting	Off White	Resin – 65,000 cPA Hardener – 7,000 cPA	20 min.	2:1	20-70	3,000 to 5,000	60	80	CFIA
	E-60HP™ Hysol®	29319 50 ml dual cartridge 29320 200 ml dual cartridge 29321 400 ml dual cartridge 29322** 5 gallon pail, resin 29323** 5 gallon pail, hardener	High strength, toughened, high peel, high shear	Off White	Resin – 67,500 cPA Hardener – 7,000 cPA	60 min.	2:1	20-70	3,000 to 5,000	70	80	CFIA
	E-120HP™ Hysol®	29353 50 ml dual cartridge 29354 200 ml dual cartridge 29355 400 ml dual cartridge 29356** 5 gallon pail, resin 29357** 5 gallon pail, hardener	Ultra strength, non-sag, aerospace grade	Amber	Resin – 41,500 cPA Hardener – 2,800 cPA	120 min.	2:1	20-50	3,000 to 6,000	90	85	CFIA
	U-05FL™ Hysol®	29348 50 ml dual cartridge 29349 200 ml dual cartridge 29350 400 ml dual cartridge 29351 5 gallon pail, resin 29352 5 gallon pail, hardener	Metal bonder, highly flexible, high strength	Off White	Resin – 640 cPA Hardener – 35,000 cPA	5 min.	1:2	5-30 †	1,000 to 3,000	48	45	CFIA
	3981™ Hysol®	36766 30 ml cartridge 37297 1 liter bottle	Fluorescent, environmental resistance	Transparent Yellow	5,300 cPA	30 min. at 125°C	1 part	N/A	2,000	56	70	ISO-10993
	3982™ Hysol®	36767 30 ml cartridge 37298 1 liter bottle	Fluorescent, environmental resistance	Off White	8,000 cPA	30 min. at 125°C	1 part	N/A	2,000	89	75	ISO-10993
	3984™ Hysol®	36768 30 ml cartridge 37299* 1 liter bottle	Fluorescent, environmental resistance	Light Grey	25,500 cPA	30 min. at 125°C	1 part	N/A	2,000	74	75	ISO-10993
	3985™ Hysol®	40870 1 liter bottle 34731** 5 gallon pail	Non-sag, armature bonding	Black	47,500 cPA	10 min. at 121°C	1 part	N/A	N/A	N/A	N/A	N/A
	9430™ Hysol®	83114 2 lb. kit 83113 10 lb. kit	High strength, high peel	Off White	Resin – 300,000 cPA Hardener – 40 cPA	40 min.	4:1	60 †	4,700	N/A	75	N/A
	9433™ Hysol®	83119 50 ml dual cartridge	Self-leveling, high strength, high peel	Cream	Resin – 174,000 cPA Hardener – 115,000 cPA	30 min.	2:1	45 †	3,800	N/A	75	N/A
	9460™ Hysol®	83129 50 ml cartridge 83128 200 ml cartridge 83127** 400 ml cartridge 83131 5 lb. kit 83130 20 lb. kit 83133 50 lb. pail, hardener 83134 50 lb. pail, resin	High peel, impact resistant, high viscosity, non-sag	Grey	Resin – 225,000 cPA Hardener – 175,000 cPA	40 min.	1:1	35 †	3,200	N/A	80	N/A
	9460F™ Hysol®	83225 50 ml dual cartridge 83224** 200 ml dual cartridge 83226 50 lb. pail, resin 83227 50 lb. pail, hardener	Impact resistant, high shear, high peel	Grey	Resin – 225,000 cPA Hardener – 175,000 cPA	20 min.	1:1	40 †	3,800	N/A	80	N/A
	9460PB™ Hysol®	83233 5 lb. kit 83232 20 lb. kit 83230** 50 lb. pail, resin 83231** 50 lb. pail, hardener	Bonds printing blanket stock, high strength	Grey	Resin – 225,000 cPA Hardener – 100,000 cPA	100 min.	1:1	N/A	2,000	N/A	N/A	N/A
	9462™ Hysol®	83142 50 ml cartridge 83135** 200 ml cartridge	Impact resistant, toughened, non-sag	Beige	Resin – 82,500 cPA Hardener – 52,500 cPA	50 min.	1:1	20 †	3,500	N/A	77	N/A

* Tested on aluminum lap shears.

** Made-to-order item.

* Formerly Dexter® Hysol® 609.

† ASTM D3167.

EPK = Epoxi-Patch® Kit.

†† For additional Potting and Encapsulating products, please see pages 76-81.

 Indicates TOP CHOICE products.

Substrate Selector Guide

Simply determine which substrates you're bonding and find the adhesive recommendations in the table below. Refer to the previous charts for typical performance properties of the recommended adhesive. These recommendations should be used as a starting point only. It is recommended that you evaluate the selected product in your application to determine suitability.

Loctite® Hysol® Epoxy & Urethane Adhesives Bond to a Variety of Substrates

	Metals	Thermoplastics	Thermoset Plastics	Rubber	Glass	Ceramic	Masonry	Wood	Leather	Paper/Hardboard
Metals	E-20NS™ E-214HP™ U-05FL™	U-05FL™ E-40FL™ E-20HP™ 9430™	E-20NS™ E-20HP™ E-120HP™ 608™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-30CL™ E-20NS™ U-05FL™ 0151™	E-20HP™ E-30CL™ E-20NS™ 9430™	E-20HP™ E-120HP™ E-20NS™ 9432NA™	E-00NS™ E-20HP™ E-40FL™ 608™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-05CL™ E-440FL™ E-00CL™ D609™
Thermoplastics	U-05FL™ E-40FL™ E-20HP™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ E-20HP™ 615™	E-05CL™ E-40FL™ E-20HP™ 11C™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ E-40FL™ E-20HP™ 9433™
Thermoset Plastics	E-20HP™ E-20NS™ E-120HP™ 615™	U-05FL™ U-09LV™ E-40FL™ 615™	E-20HP™ E-120HP™ E-214HP™ 615™	U-05FL™ E-20HP™ E-40FL™ 9460™	E-30CL™ E-20HP™ E-00CL™ 0151™	E-30CL™ E-20HP™ E-40FL™ 9433™	E-20HP™ E-120HP™ E-00CL™ 9432NA™	E-20HP™ E-40FL™ E-00NS™ 11C™	E-05CL™ U-09LV™ E-40FL™ 615™	E-40FL™ E-00CL™ U-05FL™ D609™
Rubber	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	U-05FL™ E-40FL™ E-20HP™ 9433™	E-40FL™ E-90FL™ E-20HP™ 9460™	U-05FL™ E-40FL™ U-09LV™ 9460™	U-05FL™ E-40FL™ U-09LV™ 9460™	E-40FL™ E-90FL™ E-05CL™ 9460™	E-40FL™ E-05CL™ E-20HP™ 9433™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™
Glass	E-20NS™ E-30CL™ U-05FL™ 0151™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-00CL™ E-30CL™ U-05FL™ D609™	E-05CL™ U-05FL™ U-09LV™ 9460™	E-30CL™ E-00CL™ U-09LV™ D609™	E-30CL™ E-20NS™ U-05FL™ 0151™	E-30CL™ E-00NS™ E-20HP™ 0151™	E-30CL™ E-40FL™ E-00CL™ D609™	E-40FL™ E-05CL™ U-09LV™ 615™	E-05CL™ E-40FL™ E-30CL™ 9460™
Ceramic	E-20NS™ E-30CL™ E-20HP™ 9430™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-20HP™ E-30CL™ 9433™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-30CL™ E-00CL™ U-09LV™ D609™	E-20HP™ E-30CL™ E-120HP™ 9433™	E-00NS™ E-20HP™ E-20NS™ 608™	E-20HP™ E-20HP™ E-00NS™ 608™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-40FL™ E-05CL™ E-00CL™ D609™
Masonry	E-20NS™ E-20HP™ E-120HP™ 9433™	E-40FL™ E-20HP™ E-05CL™ 9433™	E-20HP™ E-120HP™ E-00CL™ D609™	E-40FL™ E-90FL™ E-05CL™ 615™	E-30CL™ E-00NS™ E-20HP™ 0151™	E-00NS™ E-20HP™ E-20NS™ 9433™	E-20HP™ E-00NS™ E-120HP™ 608™	E-20HP™ E-00NS™ E-40FL™ 9433™	E-05CL™ E-40FL™ U-05FL™ 9460™	E-05CL™ E-00CL™ E-20HP™ D609™
Wood	E-20HP™ E-40FL™ E-00NS™ 9433™	E-40FL™ E-05CL™ E-20HP™ 11C™	E-20HP™ E-40FL™ E-00NS™ 9433™	E-40FL™ E-05CL™ E-20HP™ 9433™	E-30CL™ E-40FL™ E-00CL™ 0151™	E-20HP™ E-40FL™ E-00NS™ 608™	E-20HP™ E-00NS™ E-40FL™ 608™	E-00CL™ E-20HP™ E-40FL™ 9433™	E-05CL™ E-40FL™ E-90FL™ 615™	E-00CL™ E-40FL™ U-05FL™ D609™
Leather	E-40FL™ U-05FL™ U-09LV™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ U-09LV™ E-40FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-40FL™ E-05CL™ U-09LV™ 960™	E-05CL™ E-40FL™ U-05FL™ 615™	E-05CL™ E-40FL™ E-90FL™ 9460™	U-05FL™ U-09LV™ E-40FL™ 9460™	E-05CL™ E-40FL™ U-05FL™ 9460™
Paper/Hardboard	E-40FL™ E-05CL™ E-00CL™ D609™	E-40FL™ E-05CL™ E-20HP™ 9433™	E-40FL™ E-05FL™ U-05FL™ 9460™	E-40FL™ E-05CL™ U-09LV™ 9460™	E-05CL™ E-40FL™ E-30CL™ 0151™	E-40FL™ E-05CL™ E-00CL™ D609™	E-05CL™ E-00CL™ E-20HP™ D609™	E-00CL™ E-20HP™ E-40FL™ 9460™	E-05CL™ E-40FL™ U-05FL™ 615™	E-05CL™ E-40FL™ E-00CL™ D609™

Thermoplastics: ABS, PC, Acrylic, Nylon, SAN, PVC
 Thermoset Plastics: Epoxy, Phenolic, Polyester, DAP
 Rubber: Butyl, Neoprene, Nitrile, SBR, Natural, EPDM