

LOCTITE® AA 326

Known as LOCTITE® 326
August 2020

PRODUCT DESCRIPTION

LOCTITE® AA 326 provides the following product characteristics:

| | |
|-----------------------------|---|
| Technology | Acrylic |
| Chemical Type | Polyurethane methacrylate |
| Appearance (uncured) | Transparent, yellow to light amber liquid |
| Components | One component - requires no mixing |
| Viscosity | High |
| Cure | Anaerobic |
| Secondary Cure | Activator |
| Application | Bonding |
| Specific Benefits | Room temperature cure |

LOCTITE® AA 326 is a general purpose structural adhesive that is used for fast cure and high shear strength. Typical applications include bonding ferrites to plated materials in electric motors, loudspeaker hardware and jewelry where fast fixturing is required.

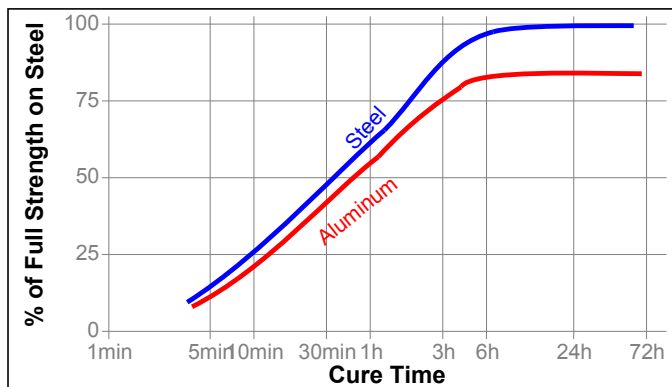
TYPICAL PROPERTIES OF UNCURED MATERIAL

| | |
|---|--------|
| Specific Gravity @ 23°C | 1.05 |
| Viscosity 25 °C, mPa.s (cP) | 18,000 |
| Brookfield – RVT Spindle 6, speed 20rpm | |
| Viscosity 25 °C, after 180 s, mPa.s (cP) | 15,000 |
| EN 12092- MV shear rate 36 s ⁻¹ | |

TYPICAL CURING PERFORMANCE

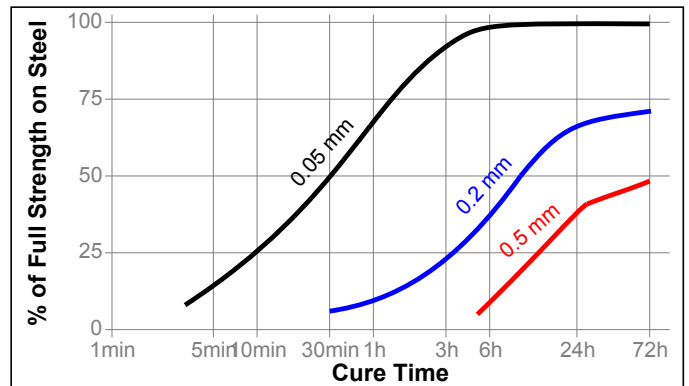
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587. (Activator 7649 applied to one surface)



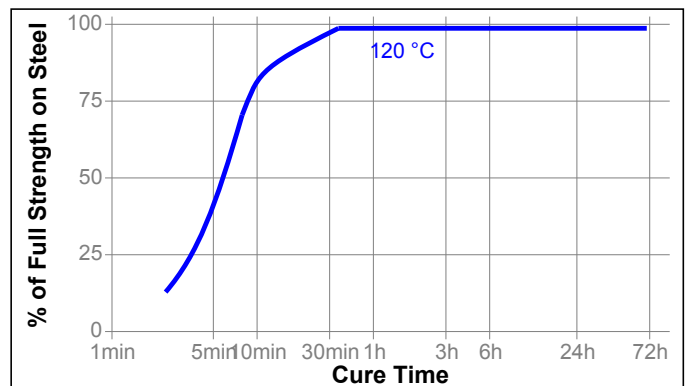
Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ISO 4587. (Activator 7649 applied to one surface)



Cure Speed vs. Temperature

The rate of cure will depend on the ambient temperature. The graph below shows shear strength developed with time at 120 °C on grit blasted steel lap shears and tested according to ISO 4587.



TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 7 days @ 23°C

Physical Properties:

| | |
|--------------------------------------|-----------------------|
| Elongation, at break. ISO 527-3, % | 135 |
| Tensile Strength | N/mm ² 34 |
| ISO 527-2 | (psi) (4,900) |
| Tensile Modulus, | N/mm ² 300 |
| ISO 527-2 | (psi) (44,000) |
| Coefficient of Thermal Expansion, | 80×10 ⁻⁶ |
| ISO 11359-2, K-1 | |
| Coefficient of Thermal Conductivity, | 0.1 |
| ISO 8302, W/(m.K) | |
| Specific Heat, kJ/(kg·K) | 0.3 |

Electrical Properties:Dielectric Constant / Dissipation
Factor, IEC 60250:

| | |
|--------|------------|
| 100-Hz | 5.6 / 0.03 |
| 1-kHz | 5.3 / 0.03 |
| 1-MHz | 4.6 / 0.04 |

Dielectric Breakdown Strength,
IEC 60243-1, kV/mm

30

Volume Resistivity, IEC 60093, $\Omega \cdot \text{cm}$ 2×10^{13} Surface Resistivity, IEC 60093, Ω 2×10^{17} **Adhesive Properties**

After 24 hours @ 23 °C, Activator 7649™ on 1 side

Lap Shear Strength, ISO 4587:

| | | |
|----------------------|-------------------|---------|
| Steel (grit blasted) | N/mm ² | 15.2 |
| | (psi) | (2,200) |

)

Tensile Strength, ISO 6922:

| | | |
|----------------------|-------------------|---------|
| Steel (grit blasted) | N/mm ² | 24 |
| | (psi) | (3,500) |

)

After 24 hours @ 23 °C, Activator 7649™ on 2 sides

Lap Shear Strength, ISO 4587:

| | | |
|------------------------|-------------------|---------|
| Steel (grit blasted) : | | |
| 0.25 mm gap | N/mm ² | 13.8 |
| | (psi) | (2,000) |

TYPICAL ENVIRONMENTAL RESISTANCE

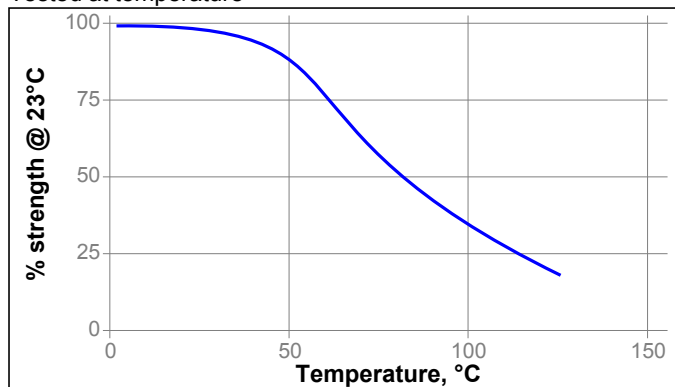
Cured for 1 week @ 23 °C, Activator 7649™ on 1 side

Lap Shear Strength ISO 4587:

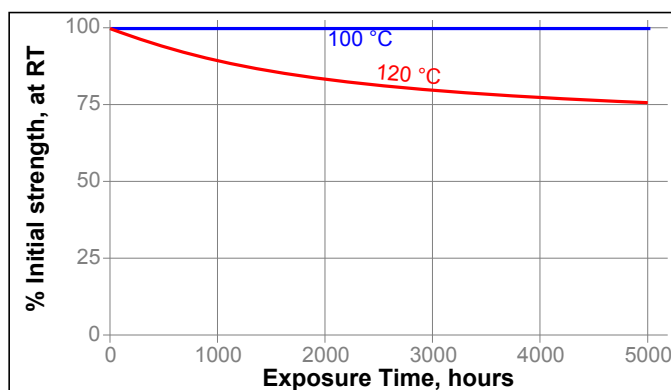
Steel (grit blasted)

Hot Strength

Tested at temperature

**Heat Aging**

Aged at temperature indicated and tested @ 23 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ °C

| Environment | °C | % of initial strength | | | |
|-------------------------|----|-----------------------|-------|--------|--------|
| | | 100 h | 500 h | 1000 h | 5000 h |
| Motor oil (MIL-L-46152) | 87 | 100 | 100 | 100 | 100 |
| Leaded Petrol | 22 | 100 | 60 | 60 | 60 |
| ATF (Dextron II oil) | 87 | 100 | 100 | - | - |
| Phosphate ester | 87 | 100 | 100 | - | - |
| Humidity, 98% RH | 40 | 85 | 50 | 45 | 45 |
| Water/glycol 50/50 | 87 | 100 | 40 | 40 | 40 |

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use

1. For best performance bond surfaces should be clean and free from grease.
2. To ensure a fast and reliable cure, Activator 7649™ should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes.
3. The recommended bondline gap is 0.1 mm. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, Activator 7649™ should be applied to both surfaces. Parts should be assembled immediately (within 1 minute).
4. Excess adhesive can be wiped away with organic solvent.
5. Bond should be held clamped until adhesive has fixtured.
6. Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel representative.

Product Specification

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and Certificate

Please contact a Henkel representative for related approval or certificate of this product.

Data Ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23±2 °C / 50 ±5% RH

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation or Henkel Canada, Inc. the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 1.2

