

PRODUCT DESCRIPTION

LOCTITE® AA 326 Blue UV is a rapid curing adhesive which develops strong bonds through gaps up to 0.020" when cured with LOCTITE® SF 7649. LOCTITE® AA 326 Blue UV will also cure rapidly when exposed to high intensity UV light in the range of 365 nanometers. It is suitable for bonding or coating a wide range of materials. This products temperatures ranging from -65°F to 225°F.

Use areas include glass bonding, metal joining where a cured fillet is required, electrical component potting and wire tacking.

PROPERTIES OF UNCURED MATERIAL

| | Typical Value |
|-----------------------|------------------------|
| Chemical Type | Modified Acrylic Ester |
| Appearance | Blue |
| Odor | Mild |
| Specific Gravity | 1.1 |
| Viscosity, @ 25°C, cP | |
| Brookfield RVT | |
| Spindle #6 @ 20 RPM | 8,000 - 20,000 |
| Flash Point, °F | >200 |

PROPERTIES OF CURED MATERIAL

Physical Properties

| | |
|-------------------------------|---------------------------|
| Hardness (Barcol) ASTM D 2240 | >60 |
| Thermal Expansion, ASTM D 696 | 10 ⁻⁴ in/in/°F |

| | Bondline Gap | |
|---|--------------|--------|
| | 2 mil | 10 mil |
| Shear Strength, Sandblasted Steel, ASTM D 1002, psi | 3,000 | 2,000 |
| Impact Strength, ASTM D 950, ft-lbs. | 14 | 13 |
| Tensile Strength, ASTM D 882 | 5,000 | - |

TYPICAL ENVIRONMENTAL RESISTANCE

Hot Strength (ASTM D 1002)

Sandblasted steel specimens cured at 72 hours at RT. Specimens aged one hour at temperature before testing.

| Test Temperature | Strength, psi |
|------------------|---------------|
| 72°F | 3000 |
| 120°F | 2200 |
| 200°F | 1300 |
| 250°F | 650 |

Chemical / Solvent Resistance (ASTM D 1002)

Steel specimens cured 72 hours at RT. Immersed in solvent 2 weeks at 188°F before testing.

| | |
|-------------------------|-------|
| Air Reference, psi | 2,300 |
| Motor Oil, psi | 3,000 |
| Transmission Fluid, psi | 3,500 |
| Gasoline, psi | 1,300 |
| Water, psi | 500 |

CURE CHARACTERISTICS

LOCTITE® AA 326 Blue UV is an ultraviolet curable anaerobic adhesive and thus can be cured with LOCTITE® SF 7649, ultraviolet light and combinations. The adhesive gives good bonds to thermoset plastics.

Approximate Fixture Times with LOCTITE® SF 7649:

| Bondline Gap | Fixture Time |
|--------------|--------------|
| 2 mil | 10 sec. |
| 5 mil | 2 min. |

Since most assemblies have several points of close contact, practical experience indicates fixture times are generally 15 seconds to 2 minutes, regardless of gap.

Factors Affecting UV Cure Rate and Strength:

1. Cure lamp intensity and wavelength
2. Distance from light source
3. Temperature
4. Light transmittance of parts being bonded

Higher intensity light will develop faster cures. Factors reducing intensity will promote slower fixtures and cure times. High intensity light is necessary for curing LOCTITE® AA 326 Blue UV to a dry surface.

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 Material Safety Data Sheet, (MSDS).

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). It is recommended to confirm compatibility of the product with such substrates.

Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

Data Ranges

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

Note

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 Corporation, Resin Technology Group, Inc., 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.

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.

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.