

## LOCTITE® AA 330

Known as LOCTITE® 330™  
June 2022

### PRODUCT DESCRIPTION

LOCTITE® AA 330 provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Urethane methacrylate ester
<b>Appearance (uncured)</b>	Slightly cloudy, colorless to pale yellow liquid <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	High
<b>Cure</b>	With activator
<b>Application</b>	Bonding

LOCTITE® AA 330 is a general purpose adhesive that is used to bond metal, wood, ferrite, ceramic and plastic materials. Applications include tool handles, appliances, sporting goods and decorative trim.

### NSF International

**Registered to NSF Category P1** for use as a sealant where there is no possibility of food contact in and around food processing areas. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

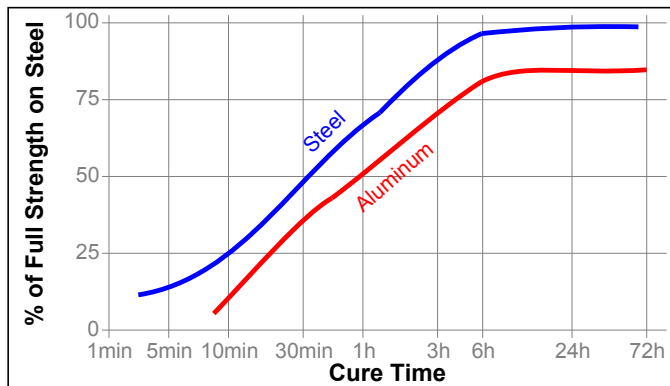
Specific Gravity @ 25 °C	1.05
Viscosity, Brookfield - RVT, 25°C, mPa·s (cP):	
Spindle 7., speed 20 rpm	45,000 to 90,000 <sup>LMS</sup>
Viscosity, EN 12092 - SV, 25 °C, after 180 s, mPa·s (cP):	
Shear rate 20 s <sup>-1</sup>	30,000 to 70,000

Flash Point - See SDS

### TYPICAL CURING PERFORMANCE

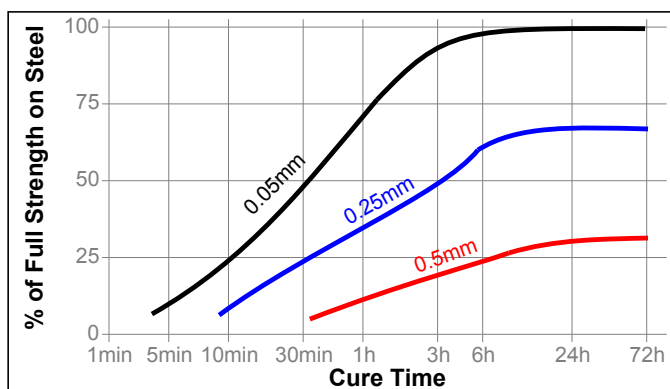
#### Cure Speed vs. Substrate

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 and tested according to ISO 4587. (Activator 7387™ applied to one surface).



#### Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows the shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ISO 4587. (Activator 7387™ applied to one surface).



### TYPICAL PROPERTIES OF CURED MATERIAL

#### Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup>	151×10 <sup>-6</sup>
Temperature Range: -25°C to 100°C	
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

### TYPICAL PERFORMANCE OF CURED MATERIAL

#### Adhesive Properties

After 24 hours @ 22°C, Activator 7387™ on 1 side

Lap Shear Strength ISO 4587:

Mild steel (grit blasted)	N/mm <sup>2</sup>	15 to 30
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(psi) (2,175 to 4,350)

Tensile Strength, ISO 6922:  
Mild steel (grit blasted)

N/mm<sup>2</sup> 12 to 22  
(psi) (1,740 to 3,190)

After 24 hours @ 22°C, Activator 7387™ or 7386™ on 2 sides

Lap Shear Strength ISO 4587:

Mild Steel (grit blasted) N/mm<sup>2</sup> ≥16.5<sup>LMS</sup>  
(psi) (≥2,390)

**TYPICAL ENVIRONMENTAL RESISTANCE**

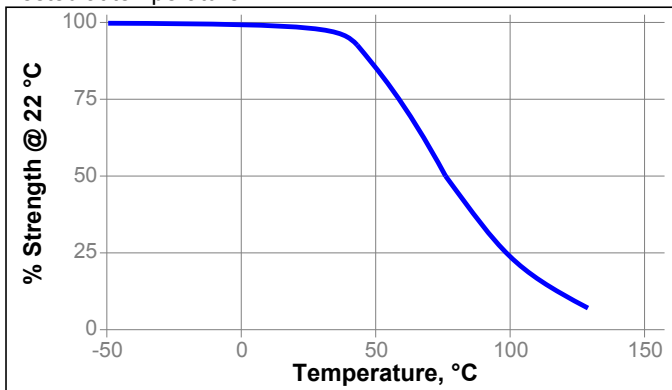
Cured for 1 week @ 22°C, Activator 7387™ on 1 side

Lap Shear Strength ISO 4587:

Mild steel (grit blasted):  
0.25 mm gap

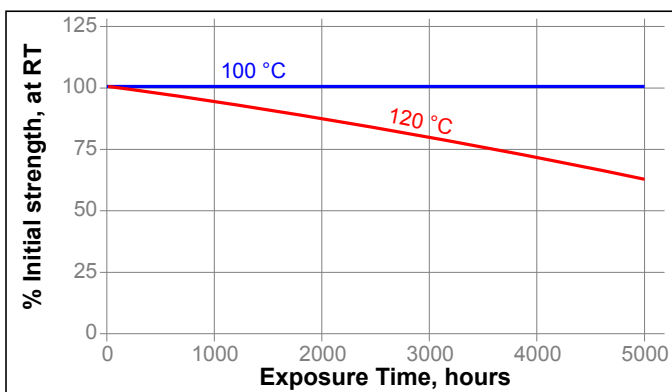
**Hot Strength**

Tested at temperature



**Heat Aging**

Aged at temperature indicated and tested @ 23 °C



**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 23°C

Environment	°C	% of initial strength	
		350 h	720 h
Acetone	22	10	10
Motor oil (MIL-L-46152)	87	90	66
Unleaded gasoline	22	20	20
Phosphate ester	87	93	75
Water/glycol 50/50	87	60	60

**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.

**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 7387 or 7386 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 7387 or 7386 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).

**Loctite Material Specification<sup>LMS</sup>**

LMS dated March 11, 1996. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**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.

**Conversions**

(°C x 1.8) + 32 = °F



kV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 µm / 25.4 = mil  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 N/mm<sup>2</sup> x 145 = psi  
 MPa x 145 = psi  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = 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.

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Reference **N/A**



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