LOCTITE® 3350

April 2004

PRODUCT DESCRIPTION

LOCTITE® 3350 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Modified acrylic ester
Appearance	Translucent paste[LMS]
Components	One part - requires no mixing
Cure	Activator
Application	Bonding

LOCTITE® 3350 is a single component multicure acrylic adhesive designed primarily to provide fast fixture speed. The product has the capability to produce tough, durable bonds with outstanding impact and peel resistance. ACTIVATOR 7380 or 7387 may be used to cure the product. This product is a fast, rose odor modification of Product 392. This product is suitable for applications which require very fast assembly. This product is particularly suited to DC motor assembly, magnet bonding and bonding of pre-coated sheet metal. Automated assembly lines with short cycle times will benefit from the rapid cure characteristics of LOCTITE® 3350.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.09
Viscosity, Brookfield - HBT, 25 °C, mPa·s (cP):	
Spindle TA, speed 2.50 rpm	20,000 to 80,000[LMS]
Spindle TA, speed 20 rpm	6,500 to 17,500[LMS]
Thixo ratio	4.30

TYPICAL CURING PERFORMANCE

Cure performance of this product will vary according to specific applications. Exploratory testing is recommended as these figures may be conservative. Typical value for fixture time is given below.

Fixture Time

The fixture time is the time required for the adhesive to achieve sufficient strength to support a 3 kg weight for 10 seconds in a lap joint assembly. The assembly consists of two 2.54 cm x 10.16 cm strips overlapped to produce a 3.2 cm² bond area. The force is applied in a tensile shear mode.

Fixture Time, s:	
Steel with 7380, no induced gap	21
Steel with 7387, no induced gap	20

TYPICAL PERFORMANCE OF CURED MATERIAL

Activator Cure

After 24 hours at 23 °C, ACTIVATOR 7380 or 7387 on 1 side

Lap Shear Strength, ISO 4587:		
Steel to Steel	N/mm²	≥11.70[LMS]
	(psi)	(1,700)

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).

Loctite Material Specification[LMS]

LMS dated , . 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 Loctite 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 Technical Service Center or Customer Service Representative.

Note

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Conversions
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm^2 x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·mm x 0.142 = oz·in
mPa·s = cP

Trademark usage
LOCTITE is a Trademark of Henkel Loctite