Product Description Sheet

LOCTITE® AA 326 BLUE UV

Known as
Loctite® 326 Blue
September 2015

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 -65ºF to 225ºF.

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, @ 25ºC, cP	
Brookfield RVT	
Spindle #6 @ 20 RPM	8,000 - 20,000
Flash Point, ºF	>200

PROPERTIES OF CURED MATERIAL

Physical Properties

Hardness (Barcol) ASTM D 2240	>60
Thermal Expansion, ASTM D 696	10^{-4} in/in/ºF

	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
72ºF	3000
120ºF	2200
200ºF	1300
250ºF	650

Chemical / Solvent Resistance (ASTM D 1002)

Steel specimens cured 72 hours at RT.
Immersed in solvent 2 weeks at 188ºF 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.

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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.

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