

LOCTITE® AA 3275

August 2023

Product description

LOCTITE® AA 3275 provides the following product characteristics:

Technology	Acrylate
Appearance	Clear amber
Cure	Anaerobic
Application	Instant adhesive
Key substrates	Galvanized steel

LOCTITE® AA 3275 low viscosity, structural anaerobic adhesive is developed for bonding rigid assemblies. The product cures when confined in the absence of air between close fitting parts with the aid of LOCTITE® SF 7649 and LOCTITE® 7471 activators.

LOCTITE® AA 3275 is used to bond a wide variety of close-fitting metals where good joint flexibility is required.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield RVT, 25°C, mPa.s

Spindle 4, speed 20 rpm	2500–4000
Specific gravity @ 25°C	1.05
Flash point, (TCC), °C	>93

TYPICAL PROPERTIES OF CURED MATERIAL

Sample cured 24 hours @ 22°C with activator LOCTITE® SF 7649 on one side

Adhesion properties

Shear strength, ASTM A1002, N/mm ²	
on steel	≥15.2
on galvanized steel	≥8.5
T-peel strength, ISO 11339, N/mm	
on steel	≥1.0

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

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.

Storage:

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

Optimal Storage: 8 to 28°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 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.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on the specifications of this product.

Conversions

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

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Reference 1