Product Description Sheet

LOCTITE® AA H3000

Known as
LOCTITE® Speedbonder® H3000
October 2015

Description

Loctite® AA H3000 is a general purpose, two component, room temperature curing, 1:1 mix ratio, methacrylate adhesive system. Loctite® AA H3000 is formulated to yield high peel and shear strength. This adhesive forms resilient bonds and maintains its strength over a wide range of temperatures. Loctite® AA H3000 is suitable for bonding a variety of substrates with a minimum of surface preparation.

Recommended Substrates: PVC, polycarbonate, acrylic, ABS, stainless steel and FRP

Features

Non-sagging gaps filled to .375 inch
Superior impact and peel strength
Little or no surface preparation
Offers excellent tolerance to off-ratio mixing
Rapid room temperature cure
100% reactive
Excellent environmental resistance

Typical Uncured Properties	Part A	Part B	Mixed
Open Time @ 70°F, mins	---	---	4 to 6
Fixture Time @ 70°F, mins	---	---	12 to 15
Color	Cream	Tan	Cream
Viscosity, cP	45,000 to 85,000	8,000 to 40,000	---
Specific Gravity	1.07	1.06	1.07
Weight per Gallon, Lbs	8.92	8.91	8.91
Mix Ratio			
By weight	1	1	---
By volume	1	1	---

Typical Cured Properties	Typical Value
Tensile Strength, psi, ASTM D 638	4,100 to 4,300
Elongation, %, ASTM D 638	20 to 30
Shear Strength @ 180°F, psi, Etched Aluminum ASTM D 1002	1,900 to 2,100

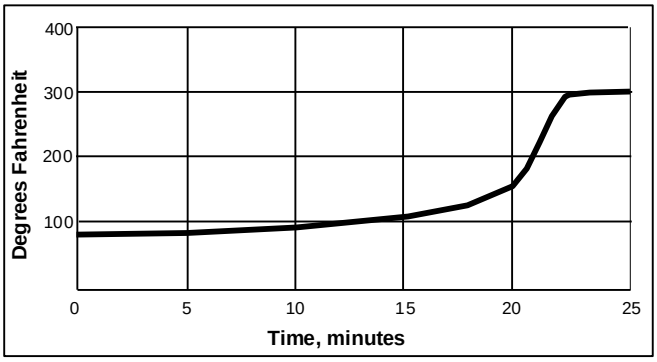
Shear Strength, psi, ASTM D1002	Typical Value
Etched Aluminum	4000
Aluminum	2940
Anodized Aluminum	1840
Steel	4150
Stainless Steel	3540
Zinc Dichromate	1980
Polycarbonate	960
Fiberglas	1740
Gelcoat	1490

T-peel, pli, ASTM D1876	Typical Value
Steel	45
Aluminum	20
Etched Alumunum	30

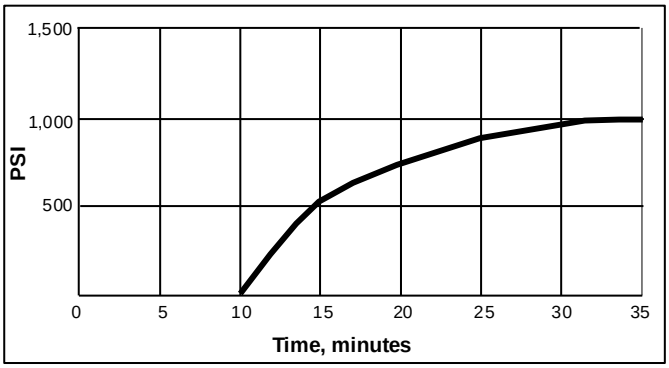
Side Impact Strength, kJ/m^2, GM9751P test	Typical value
Aluminum	25 to 30

Shear Strength after Environmental Exposure, psi, ASTM D 1002		
	2 Weeks	4 Weeks
120°F/100% RH	1250	2170

Peak Exotherm Curve –10 Gram Mass



Development of Bond Strength
Strength Build on FRP



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).
Handling and Application

Mixing: It is highly recommended that either meter mix equipment or cartridges with static mix nozzles be used to properly ratio and dispense the adhesive. For hand mixing, combine Part A and Part B in the correct ratio and mix thoroughly. Once mixed, Loctite® AA H3000 should achieve a uniform color. This is important! Heat buildup during and after mixing is normal. To reduce the likelihood of exothermic reaction or excessive heat buildup, mix less than 100 grams at a time. Mixing smaller amounts will minimize heat buildup.

Applying: Bonding surfaces should be clean, dry, and free of contamination. Extensive surface preparation is not required for Loctite® AA H3000, and good bonds can be formed on most substrates after a solvent wipe. To assure maximum bond strength, surfaces must be mated within the adhesive's open time. Use enough material to completely fill the joint when parts are clamped.

Curing: Parts should remain undisturbed during the interval of time between the material's open time and fixture time. After the fixture time is achieved the material has reached handling strength. Temperature below 55°F will slow the cure; above 85°F will accelerate the cure rate.

Clean Up: It is important to clean up excess adhesive from the work area and application equipment before it cures. Denatured alcohol and many common industrial solvents are suitable for removing uncured adhesive. Loctite® AA H3000 is flammable. Keep containers tightly closed after use. Keep away from heat, sparks, and open flames.

Storage
Loctite® AA H3000 should be stored in unopened containers in a dry location at 40ºF +/- 5 F. For further specific shelf life information, contact your local Technical Service Center.

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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