



Loctite® brand structural acrylic adhesives were developed for structural bonding applications that require tensile, shear and peel strength combined with maximum impact, stress and shock resistance. Available in two major categories:

- Two-Step No Mix Structural Acrylics
- Two-Part Structural Acrylics

BONDING

ACRYLIC ADHESIVES

TWO-STEP NO MIX STRUCTURAL ACRYLIC ADHESIVES – when in contact with a liquid activator, these no mix materials cure rapidly at room temperature to a weather-resistant bond. Ideal for close fitting parts and where extended open time is required.

Loctite® 324™ Speedbonder™ Structural Adhesive

High Impact

Ideal for large gap applications. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Specially formulated for toughness and impact strength.

Loctite® 325™ Speedbonder™ Structural Adhesive

High Temperature

Solvent resistant, activator-cured in minutes. Forms flexible bonds on gaps up to 0.40". Designed for severe environments and temperatures to 350°F.

Loctite® 326™ Speedbonder™ Structural Adhesive

Fast Fixture

An all purpose bonder. Offers the strength of an epoxy and the speed of an instant adhesive. Solvent resistant. Cures in minutes. Ideal for applications requiring fast fixturing.

Loctite® 330™ Depend® Adhesive

No-Mix

A no mix high viscosity adhesive for a wide range of materials, including metal, wood, ferrite, ceramic, and plastic.

Loctite® 332™ Structural Adhesive

Severe Environment

An activator-cured, no mix adhesive that provides high temperature capability with thermal durability up to 350°F.

Loctite® 392™ Structural Adhesive

Fast Fixture/Magnet Bonder

Single component dual-cure acrylic. Provides fast fixture speed and tough reliable bonds.

TWO-PART STRUCTURAL ACRYLIC ADHESIVES – when statically mixed, these adhesives develop a tough, durable bond to a wide variety of substrates, including metals, plastics, and composites. Loctite® brand two-part structural acrylics are available in mixer-friendly packaging to minimize waste and process time. Refer to the Dispensing section for available dual cartridge dispensers and mix nozzles.

**Loctite® H3000™
Speedbonder™
Structural Adhesive**

General Purpose

A low viscosity adhesive ideal for bonding plastics and composites.

**Loctite® H3300™
Speedbonder™
Structural Adhesive**

General Purpose/Fast Fixturing

A non-sag, fast fixturing structural adhesive for bonding plastics and composites.

**Loctite® H3151™
Speedbonder™
Structural Adhesive**

Metal Bonder

Extended open time allows for adjustment of parts. Excellent bond strength on aluminum and steel. Impact and peel resistant.

**Loctite® H4000™
Speedbonder™
Structural Adhesive**

Non-Sag

A two component and room temperature cure methacrylate adhesive that fixtures rapidly. Bonds various plastic substrates, stainless steel, epoxy coated metal, and many fiber reinforced plastics, such as glass fiber reinforced polyester.

**Loctite® H4100™
Speedbonder™
Structural Adhesive**

Ultra Fast

Fast fixturing structural adhesive. Forms strong bonds to plastics and composites.

**Loctite® H4200™
Speedbonder™
Structural Adhesive**

Toughened

A general purpose plastic and composite bonder with high peel and impact resistance. Fixtures in 15 minutes.

**Loctite® H4500™
Speedbonder™
Structural Adhesive**

Metal Bonder

High strength structural adhesive for metals. Fixtures in 10 minutes.

**Loctite® H4800™
Speedbonder™
Structural Adhesive**

Toughened

Provides extended open time, making it ideal for the assembly and adjustment of large parts. Excellent peel and impact resistance. Provides high bond strengths on composites.

**Loctite® H8000™
Speedbonder™
Structural Adhesive**

Fast Fixture

Features fast fixture time and excellent bond strength on multiple substrates, including metals and composites.

Loctite® 3030™ Adhesive

Polyolefin Bonder

A fast curing thixotropic acrylic adhesive. Designed to bond low energy substrates.


NEW

**REQUIRED
EQUIPMENT**


Equipment is sold separately. Please refer to the Dispensing section on pages 106 & 107 for a complete line of dual cartridge dispensers and mix nozzles.



LOCTITE® BRAND STRUCTURAL ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Typical Use	Color	Gap Fill	Viscosity cP @ 20 RPM	Shear Strength (psi)*	Temperature Range	Cure Speed	Recommended Primer	Specific Gravity	Agency Approvals
312™ Speedbonder™	03333	10 ml kit ¹	Fast cure on close fitting parts	Amber	.003"	1,000	3,000	-65°F to 225°F	Fixture - 30 sec.* Full - 24 hrs.	736™	1.08	-
	00144	50 ml kit ²										
	31231	50 ml bottle										
	31243	1 liter bottle										
324™ Speedbonder™	32430	50 ml bottle	High impact applications	Amber	.040"	17,000	2,175	-65°F to 275°F	Fixture - 5 min. Full - 24 hrs.	7075™	1.11	-
	32490	1 liter bottle										
325™ Speedbonder™	32530	50 ml bottle	High temperature applications	Amber	.040"	20,000	2,200	-65°F to 350°F	Fixture - 5 min. Full - 24 hrs.	7075™	1.11	-
	32586	1 liter bottle										
326™ Speedbonder™	32629	50 ml bottle	Fast fixturing applications	Amber	.020"	18,000	2,700	-65°F to 225°F	Fixture - 1 min. Full - 24 hrs.	7649™	1.10	-
	32685	1 liter bottle										
330™ Depend® 	20253	3 ml kit ³	Rough or porous surfaces	Amber	.030"	67,500	3,300	-65°F to 250°F	Fixture - 5 min.* Full - 24 hrs.	7387™	1.05	CFIA
	20251	25 ml kit ⁴										
	20252	250 ml kit ⁵										
	33058	250 ml tube										
	33064	300 ml cartdg.										
	33081	1 liter bottle										
332™	33201	25 ml syringe	High temperature applications	Pale yellow	.020"	200,000	3,500	-65°F to 400°F	Fixture - 3 min. Full - 24 hrs.	7387™/ 7380™	0.97	-
	33275	300 ml cartdg.										
	33290	1 liter bottle										
334™	33403	25 ml syringe	Tough magnet bonder	Pale yellow	.020"	80,000/ 140,000 Thixotropic	2,800	-65°F to 300°F	Fixture - 90 sec. Full - 24 hrs.	7387™/ 7380™	1.05	-
	33470	300 ml cartdg.										
392™	39250	50 ml tube	Fast fixturing magnet bonder	Amber	.020"	60,000	2,800	-65°F to 300°F	Fixture - 60 sec. Full - 24 hrs.	7387™/ 7380™	1.16	-
	39275	300 ml cartdg.										
	39280	1 liter bottle										

* Varies with substrates.

 Indicates worldwide availability.

¹ Contains 10 ml bottle of Loctite® 312™ Speedbonder™ and 40 gm aerosol can of Loctite® 736™ Primer NF™.

² Contains 50 ml bottle of Loctite® 312™ Speedbonder™ and 6 oz. aerosol can of Loctite® 736™ Primer NF™.

³ Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.

⁴ Contains 25 ml syringe of Loctite® 330™ Depend® Adhesive and 25 gm aerosol can of Loctite® 7387™ Depend® Activator.

⁵ Contains 250 ml tube of Loctite® 330™ Depend® Adhesive and 4.5 fl. oz. aerosol can of Loctite® 7387™ Depend® Activator.



LOCTITE® BRAND SPEEDBONDER™
PLASTIC AND COMPOSITE
BONDERS PROPERTIES CHART

PRODUCT	Item Number	Container	Viscosity cP (part A / part B)	Color (mixed)	Open Time in Minutes	Fixture Time in Minutes	Peel Strength, pli	Impact Strength, kJ/m ²	Aluminum Shear Strength, psi	Steel Shear Strength, psi	Fiberglass Shear Strength, psi	Gelcoat Shear Strength, psi	ABS Shear Strength, psi	PVC Shear Strength, psi	Agency Approvals
1:1 Products															
H3000™ Speedbonder™	83001 83000	50 ml dual cartridge 400 ml dual cartridge	65,000/ 24,000	Tan	5	12-15	-45	25	2,360	3,830	1,740	1,495	1,550	2,510	-
H3101™ Speedbonder™	83007 83006	50 ml dual cartridge 400 ml dual cartridge	95,000/ 65,000	Cream	15-20	25	35	20-25	1,610	2,510	1,810	1,565	1,420	2,080	-
H3300™ Speedbonder™	83020 83019 83024* 83022*	50 ml dual cartridge 400 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	150,000/ 85,000	Yellow	5	6	35-40	20	1,700	3,350	1,650	1,425	1,880	990	-
10:1 Products															
3030™ Speedbonder™	37220	35 ml dual cartridge	30,000/ 5,000	Off white	2-3	10	2-4	6	975	1,450	N/A	N/A	1,330	2,000	-
H4000™ Speedbonder™	83025 83031* 83028*	490 ml dual cartridge 40 lb pail, adhesive 40 lb. pail, activator	100,000/ 70,000	Pale yellow	8	14	45	20-25	2,580	3,500	1,645	1,500	790	1,980	NSF/ ANSI 61
H4100™ Speedbonder™	83032	490 ml dual cartridge	95,000/ 145,000	Pale yellow	2	3-5	13	8	710	3,140	1,725	1,405	2,270	2,850	-
H4200™ Speedbonder™	83038	490 ml dual cartridge	95,000/ 45,000	Pale yellow	5	15	55	>42	2,870	4,020	1,640	1,520	740	2,440	-
H4800™ Speedbonder™	83045 83047* 83046*	490 ml dual cartridge 40 lb. pail, adhesive 36 lb. pail, activator	50,000/ 55,000	Light yellow	20-25	35	50	>42	1,810	3,930	1,725	1,590	530	2,090	-
H8000™ Speedbonder™	36160 35939* 35940*	490 ml dual cartridge 35 lb. pail, adhesive 45 lb. pail, activator	160,000/ 40,000	Cream	10-15	15-20	50-60	>42	3,000	3,500	1,600	1,500	460	1,740	-

Peel Strength measured on steel.
Impact Strength measured on as-received aluminum.
* Made-to-order item.

LOCTITE® BRAND
SPEEDBONDER™ METAL BONDERS
PROPERTIES CHART

PRODUCT	Item Number	Container	Viscosity cP (part A / part B)	Color (mixed)	Open Time in Minutes	Fixture Time in Minutes	Peel Strength, pli	Impact Strength, kJ/m ²	Aluminum Shear Strength, psi	Steel Shear Strength, psi	Fiberglass Shear Strength, psi	Gelcoat Shear Strength, psi	ABS Shear Strength, psi	PVC Shear Strength, psi
1:1 Products														
H3151™ Speedbonder™	83015 83014	50 ml dual cartridge 400 ml dual cartridge	70,000/ 70,000	Pale yellow	35-40	60	40	>42	3,600	3,770	1,835	1,440	1,570	1,590
10:1 Products														
H4500™ Speedbonder™	83041	490 ml dual cartridge	54,000/ 54,000	Pale yellow	8-10	10	40	40	4,020	4,130	1,760	1,455	1,560	2,200

Peel Strength measured on steel.
Impact Strength measured on as-received aluminum.