



LOCTITE® 326

May 2004

PRODUCT DESCRIPTION

LOCTITE® 326 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Polyurethane methacrylate
Appearance (uncured)	Transparent yellow to light amber liquid ^{LMS}
Components	One component - requires no mixing
Viscosity	High
Cure	Anaerobic with activator
Cure Benefit	Room temperature cure
Application	Bonding

LOCTITE® 326 typical applications include bonding ferrites to plated materials in electric motors, loudspeaker hardware and jewelry where fast fixturing is required.

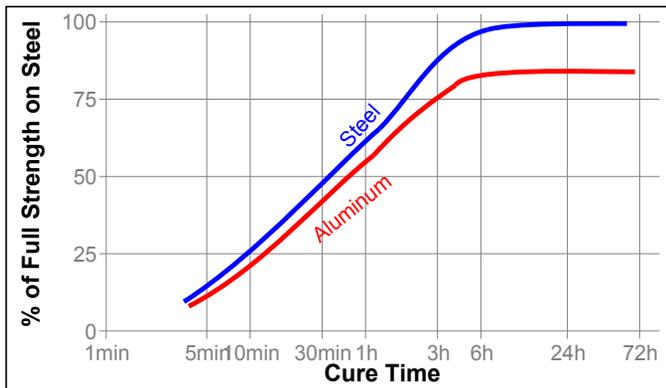
TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.10
Flash Point - See MSDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 6, speed 20 rpm	14,000 to 22,000 ^{LMS}
Viscosity, EN 12092 - MV, 25 °C, after 180 s, mPa·s (cP):	
Shear rate 36 s ⁻¹	10,000 to 20,000

TYPICAL CURING PERFORMANCE

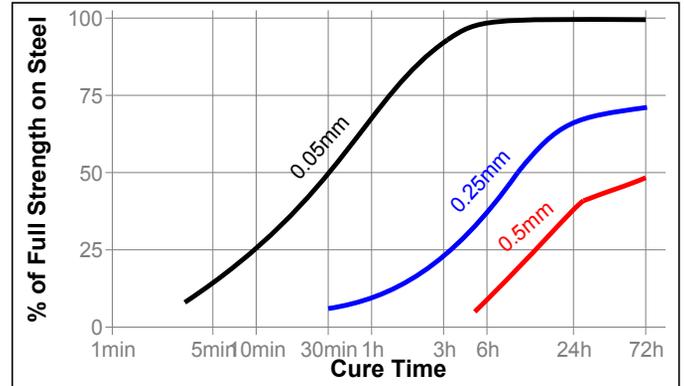
Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587. (Activator 7649 applied to one surface)



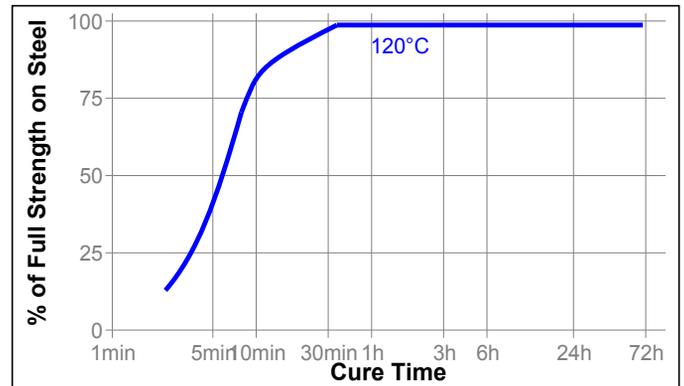
Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ISO 4587. (Activator 7649 applied to one surface)



Cure Speed vs. Time, Temperature

The rate of cure will depend on the ambient temperature. The graph below shows shear strength developed with time at 120 °C on grit blasted steel lap shears and tested according to ISO 4587.



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

Coefficient of Thermal Expansion, ASTM D 696, K ⁻¹	80×10 ⁻⁶
Coefficient of Thermal Conductivity, ASTM C 177, W/(m·K)	0.10
Specific Heat, kJ/(kg·K)	0.30
Tensile Strength, ASTM D 412	N/mm ² 34 (psi) (4,900)
Tensile Modulus, ASTM D 638	N/mm ² 300 (psi) (44,000)
Elongation, at break, ASTM D 412, %	135

Electrical Properties:

Dielectric Constant / Dissipation Factor, ASTM D 150:	
100 Hz	5.60 / 0.03
1 kHz	5.30 / 0.03
1 MHz	4.60 / 0.04
Volume Resistivity, ASTM D 257, Ω·cm	2×10 ¹³
Surface Resistivity, ASTM D 257, Ω	2×10 ¹⁷
Dielectric Breakdown Strength, ASTM D 149, kV/mm	30

TYPICAL PERFORMANCE OF CURED MATERIAL**Adhesive Properties**

After 24 hours @ 22 °C, Activator 7649 on 1 side

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ²	≥15.20 ^{LMS}
	(psi)	(2,200)

Tensile Strength, ISO 6922:

Steel (grit blasted)	N/mm ²	24
	(psi)	(3,500)

After 24 hours @ 22 °C, Activator 7649 on 2 sides

Lap Shear Strength, ISO 4587:

Steel (grit blasted): 0.25 mm gap	N/mm ²	≥13.80 ^{LMS}
	(psi)	(2,000)

TYPICAL ENVIRONMENTAL RESISTANCE

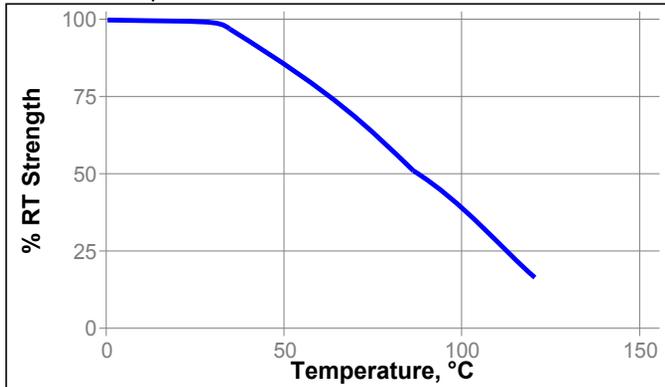
Cured for 1 week @ 22 °C, Activator 7649 on 1 side

Lap Shear Strength, ISO 4587:

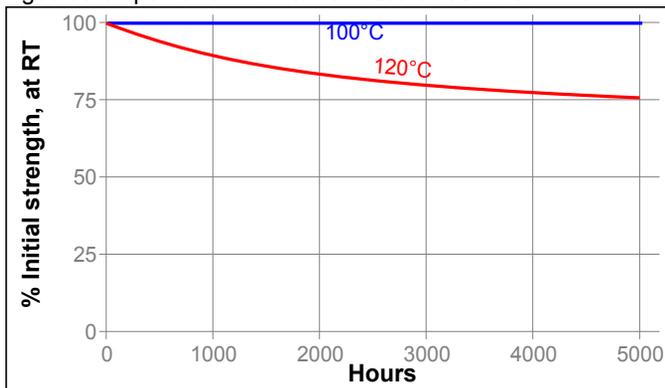
Steel (grit blasted)

Hot Strength

Tested at temperature

**Heat Aging**

Aged at temperature indicated and tested at 22°C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested at 22°C.

Environment	°C	% of initial strength			
		100 hr	500 hr	1000 hr	5000 hr
Motor Oil	87	100	100	100	100
Leaded Petrol	22	100	60	60	60
ATF (Dextron II oil)	87	100	100	-	-
Phosphate ester	87	100	100	-	-
Humidity (98 % RH)	40	85	50	45	45
Water Glycol 50/50	87	100	40	40	40

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). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use

- For best performance bond surfaces should be clean and free from grease.
- To ensure a fast and reliable cure, Activator 7649 should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes.
- The recommended bondline gap is 0.1mm. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, Activator 7649 should be applied to both surfaces. Parts should be assembled immediately (within 1 minute).
- Excess adhesive can be wiped away with organic solvent.
- Bond should be held clamped until adhesive has fixtured.
- Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

Conversions

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

Loctite Material Specification^{LMS}

LMS dated March 24, 1997. 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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Reference 1