

Technical Data Sheet Product 330

Worldwide Version, October 1998

PRODUCT DESCRIPTION

LOCTITE® Product 330 is a single component high viscosity structural adhesive for a wide range of materials. The product cures when confined between close fitting parts with the aid of Activator 7387.

TYPICAL APPLICATIONS

This general purpose adhesive is used to bond metal, wood, ferrite, ceramic and plastic materials. Applications include tool handles, appliances, sporting goods and decorative trim.

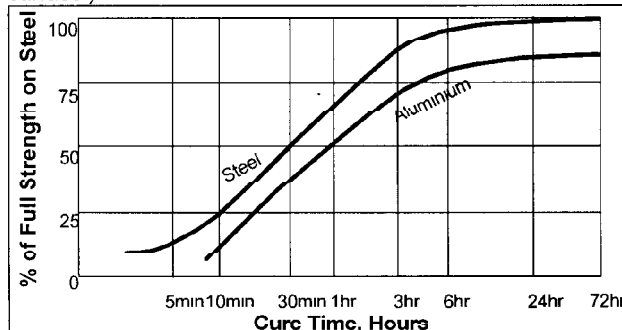
PROPERTIES OF UNCURED MATERIAL

	Value	Typical Range
Chemical Type	Modified methacrylate ester	
Appearance	Light amber liquid	
Specific Gravity @ 25°C	1.05	
Viscosity @ 25°C, mPa·s (cP)		
Brookfield RVT		
Spindle 7 @ 20 rpm	67,500	45,000 to 90,000
DIN 54463, SV		
D = 20 s ⁻¹ after t=180secs	50,000	30,000 to 70,000
Flash Point (TCC), °C	87	

TYPICAL CURING PERFORMANCE

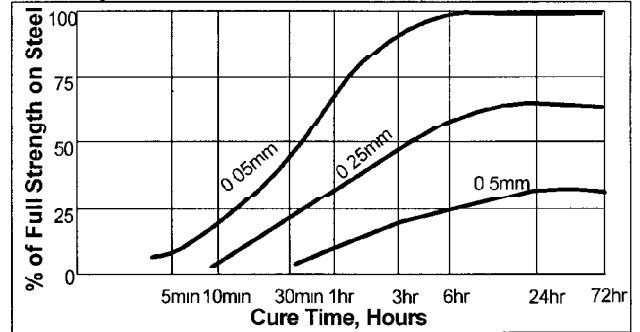
Cure speed vs. substrate

The rate of cure will depend on 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 ASTM D1002 (Activator 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 ASTM D1002 (Activator applied to one surface).



TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Coefficient of thermal expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W m ⁻¹ K ⁻¹	0.1
Specific Heat, kJ kg ⁻¹ K ⁻¹	0.3

PERFORMANCE OF CURED MATERIAL

(After 24 hr at 22°C, Act 738 on grit blasted mild steel (GBMS), 1 side)

	Value	Typical Range
Shear Strength, ASTM D1002, N/mm ²	22.5	15 to 30
(psi)	(3300)	(2200 to 4400)
Shear Strength, DIN 53283, N/mm ²	22.5	15 to 30
(psi)	(3300)	(2200 to 4400)
Tensile Strength, DIN 53288, N/mm ²	17	12 to 22
(psi)	(2500)	(1700 to 3200)

NOT FOR PRODUCT SPECIFICATIONS

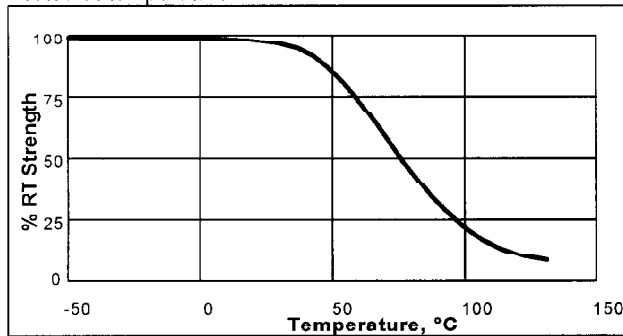
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY

PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT
ROCKY HILL, CT FAX +1 (860)-571-5473 DUBLIN, IRELAND FAX. +353-(1)-451-9959

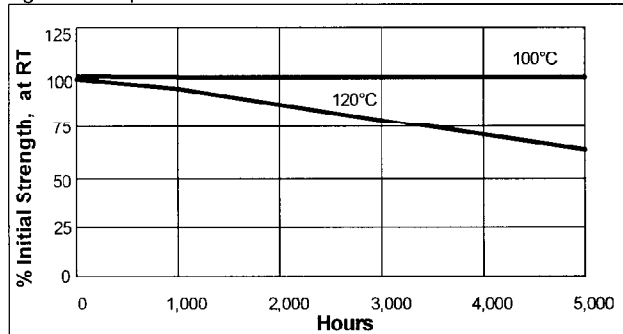
TYPICAL ENVIRONMENTAL RESISTANCE

Test Procedure Shear strength ASTM D1002
 Substrate Grit blasted mild steel laps
 Cure procedure 1 week at 22°C/Activator 7387

Hot Strength
 Tested at temperature



Heat Ageing
 Aged at temperature indicated and tested at 22°C



Chemical / Solvent Resistance
 Aged under conditions indicated and tested at 22°C.

Solvent	Temp	% Initial Strength retained at	
		350 hr	700 hr
Acetone	22°C	10	10
Motor Oil	87°C	90	66
Unleaded Petrol	22°C	20	20
Phosphate Ester	87°C	93	75
Water/Glycol (50%/50%)	87°C	60	60

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 oxidising materials.

For safe handling information on this product, consult the Material Safety Data Sheets, (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.

Directions for use

For best performance bond surfaces should be clean and free of grease. To ensure a fast and reliable cure, Activator 7387 should be applied to one of the bond surfaces and the adhesive to the other surface. The recommended bondline gap is 0.1mm. Where bond gaps are large, (up to a maximum of 0.5mm), or faster cure speed is required, activator should be applied to both surfaces. Parts should be assembled immediately, (within 15 minutes). Excess adhesive can be wiped away with organic solvent. Bond should be held clamped until adhesive has fixtured. Joint should be allowed to develop full strength before subjecting to any service loads.

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labelled. 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 further specific shelf life information, contact your local Technical Service Centre.

Data Ranges

The data contained herein may be reported as a typical value and/or range (based on the mean value ±2 standard deviations). Values are based on actual test data and are verified on a periodic basis.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a licence under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.