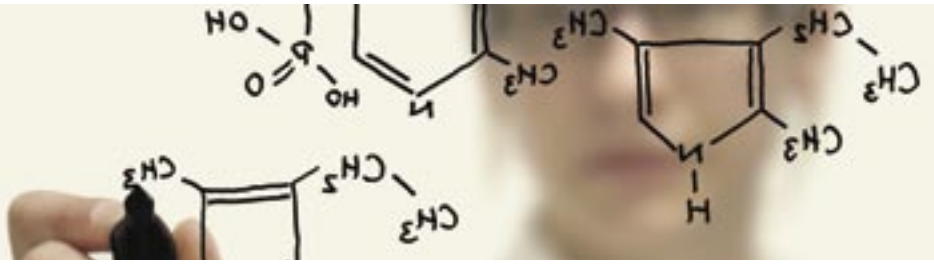


LOCTITE[®]

Speedbonder™
Structural Acrylic Adhesives

**Specially Formulated Adhesives for
Structural Bonding**





- ✓ Elimination or significant reduction of costly mechanical fastening methods such as rivets, screws, and welds
- ✓ Improved aesthetics compared to mechanical fasteners
- ✓ Fast processing speeds
- ✓ Reduction in labour costs
- ✓ Excellent resistance to severe environmental conditions
- ✓ Bonding of dissimilar materials, such as metal to plastic
- ✓ Filling of large gaps between parts
- ✓ Solvent-free formulations available
- ✓ User-friendly packaging

For more than 130 years, Henkel has been a leader in the development of adhesive technologies for manufacturing and assembly processes. As a result, today's manufacturers have come to rely on Henkel and its complete line of Loctite® Structural Adhesives to provide design advantages, improve overall product performance and appearance, speed assembly time, and reduce overall costs.

The Loctite® Speedbonder™ 2-Part Acrylics featured have been specifically formulated to provide tough, durable bonds to a wide variety of surfaces including metals, plastics and composite materials.

GENERAL PURPOSE

LOCTITE® H3300 HYSOL® STRUCTURAL ADHESIVE

Fast Fixture

A non-sag, fast fixturing structural adhesive for bonding a variety of substrates.

HIGH TOUGHNESS

LOCTITE® H8000 HYSOL® STRUCTURAL ADHESIVE

Fast Fixture

Features fast fixture time and excellent peel strength on multiple substrates, especially aluminium.

PLASTIC / COMPOSITE BONDING

LOCTITE® H4800 HYSOL® 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.

HIGH TEMPERATURE / CHEMICAL RESISTANCE

LOCTITE® H8600 HYSOL® STRUCTURAL ADHESIVE

Galvanised Bonder

Excellent impact and shear strength on steel and aluminium. Especially designed for severe environments.



		Plastic/Composite Bonding	Plastic/Composite Bonding	Gel Coated Bonding	Metal Bonding	Galvanised Steel Bonding
		<i>Fast Cure</i>	<i>High Performance</i>	<i>Slow Fixture</i>	<i>High Performance</i>	<i>Difficult Substrates</i>
PRODUCT		H3300	H4800	H6051	H8000	H8600
Mix Ratio		1:1	10:1	10:1	10:1	2:1
Colour – Mixed		Light Yellow	Light Yellow	White	Green	Blue
Gap Fill		10mm	25mm	12.7mm	12.7mm	12.7mm
Viscosity cP	Part A	85,000 – 125,000	30,000 – 70,000	90,000 – 110,000	160,000 – 22,0000	60,000 – 110,000
	Part B	80,000 – 160,000	50,000 – 60,000	75,000 – 120,000	4,0000 – 70,000	70,000 – 120,000
Open Time @ 21°C mixed		4 – 6 min	20 – 25 min	30 – 35 min	10 – 15 min	20 – 25 min
Fixture Time @ 21°C		6 – 12 min	35 – 55 min	40 – 60 min	15 – 20 min	50 – 60 min
Full Cure Time		24 hrs	24 hrs	24 hrs	24 hrs	24 hrs
Specific Gravity		1.04	1.02	1.05	0.96	–
PERFORMANCE						
Peel Strength, PLI ¹		45 – 55	60	35	35 – 45	35
Side Impact Strength, kJ/m ²		25 – 30	>42	–	>42	13
Shear Strength N/mm ² ASTM D1002	Aluminium	22.4	12.5	16.5	20.6	23
	Steel	26.3	27.1	16.5	24.1	23
	Fibreglass	>11.4	11.9	6.2	11.0	13.1
	Gel Coat	>9.8	11.0	6.9	10.3	11.0
	ABS ³	13.0	3.6	–	–	–
	PVC ³	14.6	14.4	–	6.2	6.2
Elongation % ASTM D 638		20 – 40	25 – 30	25 – 35	50 – 100	–
Hardness Shore D		75 – 80	75 – 80	–	–	–
PACKAGING SIZES / PART No.						
50ml dual cartridge		83020	–	–	–	40875
400ml dual cartridge		83019	–	–	–	38762
490ml dual cartridge		–	83045	83062	36160	–
Pail Part A (Adhesive)		* 83024 (18kg)	* 83047 (18kg)	83065 (17kg)	–	* 38760 (18kg)
Pail Part B (Activator)		* 83022 (18kg)	* 83046 (16kg)	83063 (27kg)	–	* 38761 (18kg)

¹ Measured on steel ² GM9751P test on as received aluminium ³ ASTM D4501 * Stocked to order
* Achieves >80% strength after 24 hours, 100% strength after 48hrs



Loctite® offers a comprehensive range of automated dispensing equipment for the management of large applications.

Contact your product and equipment supplier for details of our extended equipment range.



Henkel Australia Pty. Ltd.
 135-141 Canterbury Road,
 Kilsyth, Victoria, 3137
 Phone: 1300 88 555 6
www.loctite.com.au

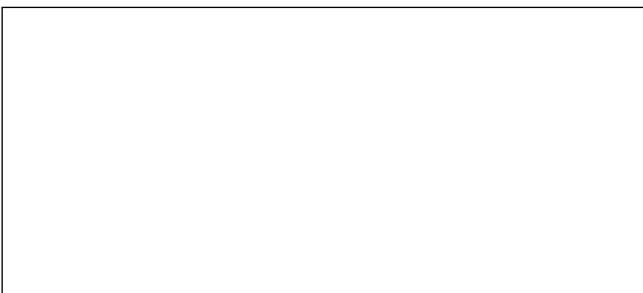
Henkel New Zealand Ltd.
 PO Box 58 493
 Greenmount 1730
 Auckland, New Zealand
 Phone: (64) 09/272 6710
 Fax: (64) 09/272 6711
www.loctite.co.nz

Loctite® Handheld Applicators

Product	Part Number	Used to Dispense	Ratio	Viscosity Range	Type
50ml Dual Cartridge Manual Applicator (not for S-50 Cartridges)	96001	Two component Epoxies, Urethanes and Acrylics (50ml)	1:1 & 2:1	Low to High	Manual
50ml Dual Cartridge Pneumatic Applicator (not for S-50 Cartridges)	97042	Two component Epoxies, Urethanes and Acrylics (50ml)	1:1 & 2:1	Low to High	Pneumatic
400ml Dual Cartridge Manual Applicator	983438	Two component Epoxies, Urethanes and Acrylics (400ml)	1:1 & 2:1	High to Paste	Manual
400ml Dual Cartridge Pneumatic Applicator	983439	Two component Epoxies, Urethanes and Acrylics (400ml)	1:1 & 2:1	High to Paste	Pneumatic
490ml Dual Cartridge Manual Applicator	985246	Two component Epoxies, Urethanes and Acrylics (490ml)	10:1	High to Paste	Manual
490ml Dual Cartridge Pneumatic Applicator	985249	Two component Epoxies, Urethanes and Acrylics (490ml)	10:1	High to Paste	Pneumatic

Loctite® Mix Nozzles

Part Number	Package Qty	Description	Ratio
98473	10	50ml Static Mix Nozzle, 5.3mm Square Combo Tip	1:1, 2:1
98463	10	50ml Static Mix Nozzle, 5.4mm Stepped Tip	10:1
98456	10	400ml Static Mix Nozzle, 6mm Slip End	1:1, 2:1
98457	10	400ml Static Mix Nozzle, 8mm Stepped End	1:1, 2:1
98461	10	490ml Static Mix Nozzle, 10mm Stepped End	10:1



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