

## LOCTITE® AA 3030™

Known as LOCTITE® 3030™  
January 2015**PRODUCT DESCRIPTION**

LOCTITE® AA 3030™ provides the following product characteristics:

<b>Technology</b>	Acrylic
Chemical Type	Acrylic
Appearance, Resin (Component A)	Clear yellow liquid <sup>LMS</sup>
Appearance, Hardener (Component B)	Transparent yellow liquid with visible glass beads, Black particles may be observed, not criteria for batch rejection <sup>LMS</sup>
Components	Two component - requires mixing
Viscosity	Medium, thixotropic
Cure	Two part acrylic
Mix Ratio, by volume - Part A: Part B	10 : 1
<b>Application</b>	Bonding
Specific Benefit	Fast curing

LOCTITE® AA 3030™ is designed primarily to bond to many low energy substrates such as low and high density polyethylene and polypropylene but can be used as a general purpose adhesive on many other substrates as well. The product contains 0.25mm glass beads for bondline thickness control. The thixotropic nature of LOCTITE® AA 3030™ reduces the migration of liquid product after application to the substrate.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

## Part A Properties:

Specific Gravity @ 25 °C	1.08
Viscosity, Cone & Plate, mPa·s (cP): Cone CP50-2 @ shear rate 3,000 s <sup>-1</sup>	32 to 80 <sup>LMS</sup>
Infrared Spectroscopy	To match standard <sup>LMS</sup>
Flash Point - See SDS	

## Part B Properties:

Specific Gravity @ 25 °C	1.08
Viscosity, Brookfield - RVT - Small Sample, 25 °C, mPa·s (cP): Spindle 16, speed 2.5 rpm,	11,000 to 29,000 <sup>LMS</sup>
Spindle 16, speed 20 rpm	2,000 to 11,000 <sup>LMS</sup>
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE**

This product cures rapidly when the components are dispensed through a LOCTITE® branded static mixer at room temperature.

**Fixture Time**

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

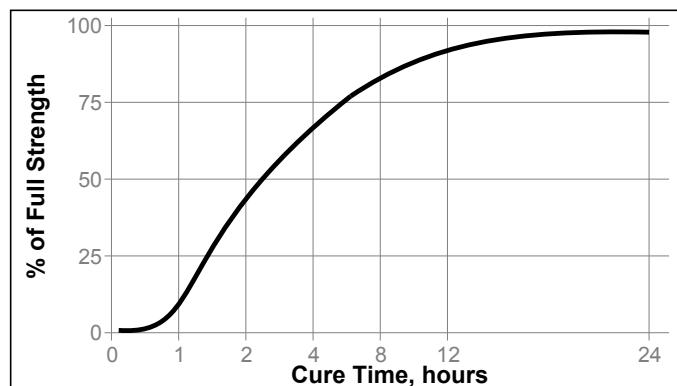
Fixture Time, mixed, minutes:	
Steel	10

**Open Time**

Open Time, mixed, minutes	
	3

**Strength vs. Time**

The graph below shows the bond strength developed with time with a 0.25mm gap and tested according to ISO 13445.

**TYPICAL PROPERTIES OF CURED MATERIAL**

## Physical Properties:

Elongation, at break, ISO 527-3, %	76
Tensile Strength, at break, ISO 527-3	N/mm <sup>2</sup> 6.3
	(psi) (915)
Tensile Modulus, ISO 527-3	N/mm <sup>2</sup> 43.4
	(psi) (6,300)

**TYPICAL PERFORMANCE OF CURED MATERIAL**

## Adhesive Properties

Cured for 24 hours @ 22 °C

Block Shear Strength, ISO 13445:

HDPE	N/mm <sup>2</sup> ≥6 <sup>LMS</sup> (psi) (≥870)
Polypropylene	N/mm <sup>2</sup> 13.6 (psi) (1,970)
LDPE	N/mm <sup>2</sup> *4.3 (psi) (*630)



ABS	N/mm <sup>2</sup>	15.4
PVC	(psi)	(2,230)
Polycarbonate	N/mm <sup>2</sup>	7.9
	(psi)	(1,150)
Polybutylene	N/mm <sup>2</sup>	7.3
Terephthalate (PBT)	(psi)	(1,060)
Epoxyglass	N/mm <sup>2</sup>	9.3
	(psi)	(1,350)
Acetal	N/mm <sup>2</sup>	11.3
	(psi)	(1,640)
	N/mm <sup>2</sup>	1.4
	(psi)	(200)

\* substrate failure

#### Lap Shear Strength, ISO 4587:

Steel	N/mm <sup>2</sup>	4.8
	(psi)	(700)
Aluminum	N/mm <sup>2</sup>	4.9
	(psi)	(710)
Stainless steel	N/mm <sup>2</sup>	4.5
	(psi)	(650)
Nylon	N/mm <sup>2</sup>	1.2
	(psi)	(170)
EPDM	N/mm <sup>2</sup>	0.15
	(psi)	(20)
SBR	N/mm <sup>2</sup>	0.55
	(psi)	(80)

#### "T" Peel Strength, ISO 11339:

Aluminum	N/mm	0.55
	(lb/in)	(3)

#### Impact Strength, ISO 9653, kJ/m<sup>2</sup>:

Steel	6
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#### TYPICAL ENVIRONMENTAL RESISTANCE

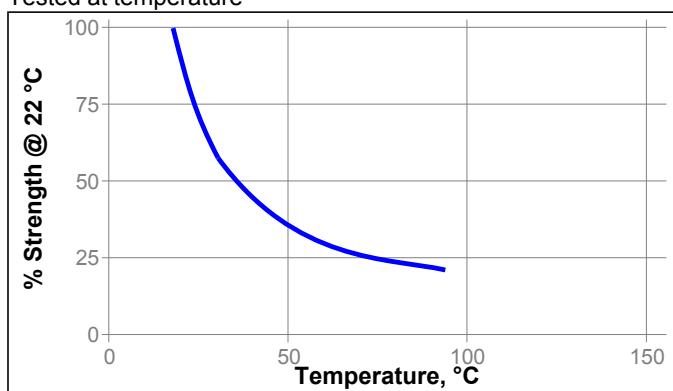
Cured for 24 hours @ 22 °C

#### Block Shear Strength, ISO 13445:

Polypropylene
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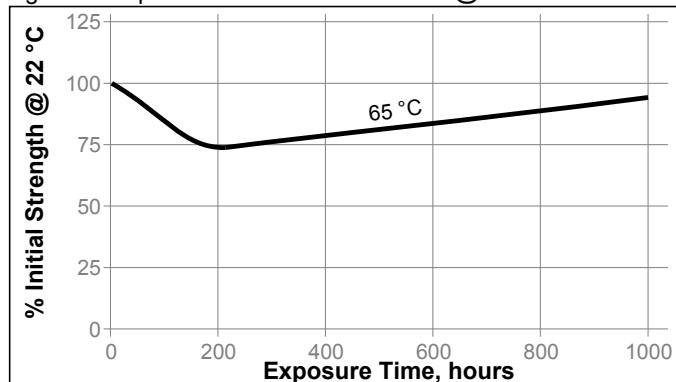
#### Hot Strength

Tested at temperature



#### Heat Aging

Aged at temperature indicated and tested @ 22 °C



#### Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22°C.

Environment	°C	% of initial strength	
		500 h	1000 h
Humidity, 100% RH	49	75	75
Salt fog, 95% RH	35	80	105
Water immersion	65	60	80
Unleaded gasoline	25	75	20

#### 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 Safety Data Sheet (SDS).

#### Directions for use:

1. For best performance bond surfaces should be clean and free from grease.
2. place cartridge in LOCTITE® applicator with plunger.
3. Actuate gun to ensure that both adhesive and activator are free flowing.
4. Attach Loctite® static mix nozzle.
5. Discard a small amount of mixed adhesive from mix nozzle prior to dispensing product on actual parts.

#### Clean-up

1. Uncured material may be cleaned from dispenser components and surfaces with a variety of solvents; including LOCTITE® 7360™, LOCTITE® Equipment Flushing Solvent™, IPA, acetone, MEK, methylene chloride, etc..
2. Always wash and dry thoroughly prior to re-use of dispenser components.
3. Removal of material that has been mixed should be done quickly as polymerization occurs rapidly.
4. After use, the static mixer may be used in place of the cap.
5. When the product is reused, a new static mixer must be used.

6. Contact your equipment supplier to ensure that any solvents used are compatible with individual components.

### Loctite Material Specification<sup>LMS</sup>

LMS dated March 25, 2003 (Part A) and LMS dated May 16, 2003 (Part B). 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. Material removed from containers may be contaminated during use. Do not return liquid to original container. 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.

Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those recommended. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

### Conversions

(°C x 1.8) + 32 = °F  
 KV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 µm / 25.4 = mil  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 N/mm<sup>2</sup> x 145 = psi  
 MPa x 145 = psi  
 N·m x 8.851 = lb-in  
 N·m x 0.738 = lb-ft  
 N·mm x 0.142 = oz-in  
 mPa·s = cP

### 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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### Reference 2.3