

[Loctite® Metal Bonding Structural Adhesives Properties Chart]

	LOCTITE® PRODUCT	ITEM NUMBER	PACKAGE TYPE / SIZE	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (minutes)	FIXTURE TIME (min)	CURE TIME (hours)	SHEAR STRENGTH ¹ (psi)	IMPACT STRENGTH ² (kJ/m ²)	PEEL STRENGTH ³ (psi)	HOT STRENGTH ⁴ (psi)
GENERAL PERFORMANCE	H4710™ SPEEDBONDER™	1056941 39317	50 ml dual cartridge 490 ml dual cartridge	Fast Set, Corrosion Resistant	Two-Part Acrylic	Grey	15,000	10:1	5	15	48	4,520	>14	16	1,350
	H4720™ SPEEDBONDER™	996452 39011	50 ml dual cartridge 490 ml dual cartridge	Extended Work Life, Corrosion Resistant	Two-Part Acrylic	Teal	70,000	10:1	65	100	48	4,200	8.5	25.3	1,100
	H4500™ SPEEDBONDER™	996512 83041	50 ml dual cartridge 490 ml dual cartridge	Fast Fixture	Two-Part Acrylic	Pale Yellow	45,000	10:1	6	15	24	3,100	11.5	10.7	950
	H3151™ SPEEDBONDER™	83015 83014	50 ml dual cartridge 400 ml dual cartridge	Extended Work Life	Two-Part Acrylic	Light Yellow	70,000	1:1	60	120	24	3,800	7.7	15	900
HIGH TEMPERATURE / CHEMICAL RESISTANT	E-20NS™ HYSOL®	29334 29335 29336	50 ml cartridge 200 ml dual cartridge 400 ml dual cartridge	Low Sag	Two-Part Epoxy	Tan	60,000	2:1	20	150	24	2,790 ⁵	1.5	Not Tested	1,116
	E-60HP™ HYSOL®	29319 29320 29321 29322* 29323*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Performance	Two-Part Epoxy	Off-White	47,000	2:1	60	240	24	4,320 ⁵	Not Tested	Not Tested	430 ⁵
	E-214HP™ HYSOL®	29339 29340	30 ml cartridge 300 ml cartridge	High Strength	One-Part Epoxy	Grey	Paste	N/A	N/A	N/A	0.66 @ 218°F (120°C)	4,820 ⁵	Not Tested	Not Tested	3,172 ⁵
	9432NA™ HYSOL®	83217* 83216	2 lb. can 55 lb. pail	High Temperature	One-Part Epoxy	Grey	225,000	N/A	N/A	N/A	0.5 @ 218°F (120°C)	3,000	2.7	Not Tested	300
	3050™	1059617 1059616	50 ml dual cartridge 400 ml dual cartridge	Paint Process Compatible	Two-Part Acrylic	Yellow	75,000	2:1	6	Not Tested	24	2,900	>13	16	Not Tested
	H8700™ SPEEDBONDER™	1064166 1064321	50 ml dual cartridge 400 ml dual cartridge	Weld-Through Capable	Two-Part Acrylic	Blue	40,000	2:1	9	Not Tested	24	3,900	>21	45	Not Tested
GALVANIZED BONDING	H8610™ SPEEDBONDER™	1055263 1055839	50 ml dual cartridge 400 ml dual cartridge	Fast Fixture	Two-Part Acrylic	White	105,000	2:1	10	15	48	3,400	12	4.8	In Testing
	H8600™ SPEEDBONDER™	40875 38762 38760* 38761*	50 ml dual cartridge 400 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Medium Work Life	Two-Part Acrylic	Blue	86,000	2:1	25	55	48	3,355	38	22.6	460
	E-50GW™ HYSOL®	1078249 1077864	50 ml dual cartridge 400 ml dual cartridge	Extended Work Life	Two-Part Epoxy	Grey	37,000	4:1	50	75	24	1,900 ⁶	Not Tested	Not Tested	1,273 (500 hrs)
STEEL BONDING	H8500™ SPEEDBONDER™	996514 40884 40888* 40889*	50 ml dual cartridge 490 ml dual cartridge 5 gallon pail, adhesive 5 gallon pail, activator	Fast Fixture	Two-Part Acrylic	Grey	60,000	10:1	10	25	72	2,899	26.3	46.4	960
	H8510™ SPEEDBONDER™	996513 1107651	50 ml dual cartridge 490 ml dual cartridge	Extended Work Life	Two-Part Acrylic	Grey	65,000	10:1	28	30	72	3,440	>14	58	413
ALUMINUM BONDING	H8000™ SPEEDBONDER™	996453 36160 35939* 35940*	50 ml dual cartridge 490 ml dual cartridge 35 lb. pail, adhesive 45 lb. pail, activator	Medium Work Life	Two-Part Acrylic	Green	190,000	10:1	15	30	24	3,250	>42	40	450
	H8100™ SPEEDBONDER™	1056942 1056943	50 ml dual cartridge 490 ml dual cartridge	Fast Fixture	Two-Part Acrylic	Green	190,000	10:1	8	15	24	3,450	15.1	49	Not Tested
	H8010™ SPEEDBONDER	1056929 40594	50 ml dual cartridge 490 ml dual cartridge	Gap Control	Two-Part Acrylic	Grey	250,000	10:1	15	20	24	2,680	Not Tested	9 ⁷	Not Tested
FLEXIBLE BONDING	U-05FL™ HYSOL®	29348 29349 29350 29351 29352	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Strength	Two-Part Urethane	Off-White	100,000	1:2	5	–	24	930 ³	636 ⁷	Not Tested	280
HEAT CURE	3984™ HYSOL®	36768 37299*	30 ml syringe 1 liter bottle	High Performance	One-Part Epoxy	Light Grey	25,000	One Part	–	–	25 min @ 212°F (100°C)	>2,000 ⁵	2.0	Not Tested	400

ITEMS IN RED = Source's PICK

* Made-to-order item.
¹ Steel

² 220°F (104°C) shear on steel
³ Grit-blasted steel
⁴ Aluminum

⁵ Etched aluminum
⁶ Galvanized steel
⁷ Abraded and etched aluminum