

[Loctite® Multiple Surface Bonding Structural Adhesives Properties Chart]

	LOCTITE® PRODUCT	ITEM NUMBER	PACKAGE TYPE / SIZE	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (minutes)	FIXTURE TIME	CURE TIME (hours)	SHEER STRENGTH ¹ (hours)	TEMPERATURE RESISTANCE
POTTING	U-09LV™ HYSOL®	38588 38589 38590 38591	50 ml dual cartridge 200 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Medium Work Life, Low Viscosity	Two-Part Urethane	Clear	1,000	1:1	10	>180 min	24	1,146	122°F (50°C)
	E-60NC™ HYSOL®	29324 29325 29326	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Extended Work Life, Non-Corrosive	Two-Part Epoxy	Black	8,000	1:1	60	>180 min	24	2,630	250°F (121°C)
FLEXIBLE BONDING	E-05CL™ HYSOL®	29299 29300 29301	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Fast Fixture	Two-Part Epoxy	Clear	2,500	1:1	3	15 min	24	1,430	300°F (148°C)
	E-40FL™ HYSOL®	29304 29305 29306	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Medium Fixture	Two-Part Epoxy	Opaque Grey	70,000	1:1	40	130 min	24	640	350°F (177°C)
	E-90FL™ HYSOL®	29309 29310 29311 29312* 29313*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Extended Work Life	Two-Part Epoxy	Opaque Grey	40,000	1:1	90	>180 min	24	810	350°F (177°C)

ITEMS IN RED = Source's PICK

* Made-to-order item

¹ Grit-blasted steel

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NO MIX / SMALL GAP	A-533™ ^{AA} NEW	1254145 1254144	50 ml bottle 1 liter bottle	Ultra-Fast Fixture	Two-Step Acrylic	Grey	15,000	N/A	N/A	15-30 sec	1	3,500	325°F (163°C)
	326™ SPEEDBONDER™ ^{AA}	32629 32685	50 ml bottle 1 ml bottle	Fast Fixture	Two-Step Acrylic	Light Amber	17,000	N/A	N/A	1 min	24	3,500	250°F (121°C)
	330™ DEPEND® ⁵	20253 20251 20252 33058 33064 33081	3 ml kit ⁴ 25 ml kit ⁵ 250 ml kit ⁶ 250 ml tube 300 ml cartridge 1 liter bottle	General Purpose	Two-Step Acrylic	Pale Yellow	67,500	N/A	N/A	5 min	24	3,300	250°F (121°C)
CLEAR BONDING	D609™ HYSOL®	83089	50 ml dual cartridge	Fast Fixture UV Resistant	Two-Part Epoxy	Clear	15,000	1:1	5	15 min	24	2,970	180°F (82°C)
	E-00CL™ HYSOL®	29289 29290 29291	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Fast Fixture Flowable	Two-Part Epoxy	Clear	10,000	1:1	5	15 min	24	2,160	180°F (82°C)
	E-05MR™ HYSOL®	1087601 1086598 1086600 1086599 1087602 1087603	25 ml dual cartridge 50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Moisture Resistant	Two-Part Epoxy	Ultra-Clear	25,000	1:1	5	15 min	24	3,200	250°F (121°C)
	608™ HYSOL®	83086 83075 83082 83083* 83088* 83087*	4 g foil pack 50 ml dual cartridge EPK 2.8 oz. kit 5 lb. kit 45 lb. pail, resin 45 lb. pail, hardener	Fast Fixture Non-Sag	Two-Part Epoxy	Clear	100,000	1:1	5	15 min	24	2,980	180°F (82°C)
	E-00NS™ HYSOL®	29294 29295 29296	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Fast Fixture Low Odor	Two-Part Epoxy	Translucent	100,000	1:1	5	15 min	24	3,000	180°F (82°C)
	E-30CL™ HYSOL®	29329 29330 29331	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Medium Work Life, Chemical Resistant	Two-Part Epoxy	Clear	10,000	2:1	30	160 min	24	3,100	350°F (177°C)
	0151™ HYSOL®	83069 83176 83179 83178 83181* 83180*	50 ml dual cartridge EPK 3.3 oz. kit 2.6 lb. kit 10.7 lb. kit 40 lb. pail, resin 6.8 lb. can, hardener	Extended Work Life	Two-Part Epoxy	Clear	60,000	2.7:1	60	>180 min	24	2,675	350°F (177°C)

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¹ Grit-blasted steel

² Block grit-blasted mild steel

³ Etched aluminum

⁴ Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.

⁵ Contains 25 ml syringe of Loctite® 330™ Depend® Adhesive and 25 g aerosol can of Loctite® 7387™ Depend® Activator.

⁶ Contains 0.2 fl. oz. tube of Loctite® 330™ Depend® Adhesive and 0.7 fl. oz. ampule of Loctite® 7387™ Depend® Activator.

⁷ Formerly National Adhesives Product. See product description for more details.

^A Use with Loctite® A-534R™ Activator

^{AA} Use with Loctite® 7649 Primer N™

^V Use with Loctite® 7387™ Depend® Activator

^W Use with Loctite® 7075™ Activator

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HIGH TOUGHNESS	324™ SPEEDBONDER™ ¹ 	32430 32490	50 ml bottle 1 liter bottle	No Mix/ Small Gap	Two-Step Acrylic	Amber	17,000	N/A	N/A	5	24	3,600	300°F (148°C)
	E-30UT™ HYSOL®	1078234 1078235	50 ml dual cartridge 400 ml dual cartridge	Ultra-Tough	Two-Part Epoxy	Purple	12,200	2:1	35	180	24	5,090	Not Tested
	E-20HP™ HYSOL®	29314 29315 29316 29317 29318	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	Easy Mix	Two-Part Epoxy	Off-White	30,000	2:1	20	120	24	3,270	350°F (177°C)
	9460™ HYSOL®	83129 83128 83127* 83131 83130 83133 83134	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 lb. kit 20 lb. kit 50 lb. pail, hardener 50 lb pail, resin	Non-Sag	Two-Part Epoxy	Grey	200,000	1:1	50	>180	24	3,500 ²	350°F (177°C)
	9430™ HYSOL®	83114 83113	2 lb. kit 10 lb. kit	Impact Resistant	Two-Part Epoxy	Off-White	12,000	3.78:1	50	>180	24	4,230	180°F (82°C)
	E-60HP™ HYSOL®	29319 29321 29322* 29323*	50 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Performance	Two-Part Epoxy	Off-White	45,000	2:1	60	>180	24	4,320	350°F (177°C)
	9462™ HYSOL®	83142 83135*	50 ml dual cartridge 200 ml dual cartridge	High Strength	Two-Part Epoxy	Beige	70,000	1:1	50	>180	24	4,180	350°F (177°C)
	3981™ HYSOL®	36766 37297	30 ml cartridge 1 liter bottle	Flowable Heat Cure	One-Part Epoxy	Transparent Yellow	5,000	N/A	N/A	N/A	0.5 @ 257°F (125°C)	4,930	250°F (121°C)
	3985™ HYSOL®	40870 34731*	1 liter bottle 5 gallon pail	Non-Sag Heat Cure	One-Part Epoxy	Black	50,000	N/A	N/A	N/A	0.5 @ 272°F (150°C)	Not Tested	Not Tested
	HIGH TEMPERATURE / CHEMICAL RESISTANT	332™ ⁴	33201 33275 33290	25 ml syringe 300 ml cartridge 1 liter bottle	No Mix/ Small Gap	Two-Step Acrylic	Amber	100,000	N/A	N/A	3	24	3,000
1C™ HYSOL®		83200 83202 83201 83206* 83183*	EPK 4 oz. kit 4 lb. kit 17 lb. kit 60 lb. pail, resin 43 lb. pail, hardener	Gap Filling	Two-Part Epoxy	White	350,000	2.5:1	25	210	24	1,750 ³	350°F (177°C)
E-40HT™ HYSOL®		1086065 1086081	50 ml dual syringe 400 ml dual cartridge	High Strength	Two-Part Epoxy	Off-White	430,000	2:1	45	165	24	5,000 ³	400°F (204°C)
E-50CR™ HYSOL®		1079594 1079593	50 ml dual syringe 400 ml dual cartridge	Flowable	Two-Part Epoxy	Black	5,000	2:1	50	285	24	2,500 ³	350°F (177°C)
9340™ HYSOL®		83104 83105	EPK 2.7 oz. kit 5 lb. kit	Non-Sag	Two-Part Epoxy	Grey	Paste	2:1	90	>180	24	2,300 ³	>180°F (82°C)
9459™ HYSOL®		83126	10 lb. can	Self-Leveling Heat Cure	One-Part Epoxy	Light Grey	40,000	N/A	N/A	N/A	1 @ 250°F (121°C)	3,000 ³	>300°F (148°C)
SANDABLE	615™ HYSOL®	83094 83095*	EPK 3.2 oz. kit 12 lb. kit	Fast Fixture	Two-Part Epoxy	Light Blue	200,000	1:1	10	25 min	24	3,825	350°F (177°C)

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