

[Loctite® Plastic / Composite Bonding Structural Adhesives Properties Chart]

LOCTITE® PRODUCT	ITEM NUMBER	PACKAGE TYPE / SIZE	FEATURES	CHEMISTRY	COLOR	VISCOSITY (cP)	MIX RATIO	WORK LIFE (minutes)	FIXTURE TIME (minutes)	CURE TIME (hours)	SHEER STRENGTH ¹ (psi)	IMPACT STRENGTH ¹ (kJ/m ²)	PEEL STRENGTH ⁴ (pli)
H4100™ SPEEDBONDER™	83032	490 ml dual cartridge	Ultra-Fast Fixture	Two-Part Acrylic	Pale Yellow	100,000	10:1	2	5	24	3,140	8	13
H4200™ SPEEDBONDER™	83038	490 ml dual cartridge	Fast Fixture	Two-Part Acrylic	Pale Yellow	90,000	10:1	5	15	24	4,020	>42	55
H4000™ SPEEDBONDER™	83025 83031* 83028	490 ml dual cartridge 40 lb. pail, adhesive 40 lb. pail, activator	Non-Sag	Two-Part Acrylic	Pale Yellow	130,000	10:1	8	14	24	3,500	20	45
H6051™ SPEEDBONDER™	83062 83065 83063	490 dual cartridge 38 lb. pail, adhesive 60 lb. pail, activator	UV Resistant	Two-Part Acrylic	White	100,000	10:1	35	50	24	2,400	Not Tested	35
H4800™ SPEEDBONDER™	996515 83045 83047* 83046*	50 ml dual cartridge 490 ml dual cartridge 40 lb. pail, adhesive 36 lb. pail, activator	Impact Resistant	Two-Part Acrylic	Light Yellow	50,000	10:1	25	35	24	3,930	>42	50
E-120HP™ HYSOL®	29353 29354 29355 29356* 29357*	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge 5 gallon pail, resin 5 gallon pail, hardener	High Temp/ Chemical Resistant	Two-Part Epoxy	Amber	30,000	2:1	120	180	24	4,300	Not Tested	20 to 50
3982™ HYSOL®	36767 37298	30 ml syringe 1 liter bottle	Fluorescent Heat Cure	One-Part Epoxy	Off- White	8,000	N/A	N/A	N/A	0.5 @ 257°F (125°C)	5,830 ⁴	1.5	Not Tested
E-119HP™ HYSOL®	1078992 1080008	30 ml syringe 300 ml cartridge	Heat Cure Carbon-fiber bonder	One-Part Epoxy	Beige	Thixotropic	N/A	N/A	N/A	0.5 @ 252°F (122°C)	4,930	Not Tested	Not Tested

HIGH TOUGHNESS

ITEMS IN RED = *Source's PICK*

* Made-to-order item
¹ Steel
² Aluminum

³ Block shear on high density polyethylene
⁴ Block shear – grit-blasted steel

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GENERAL BONDING	H3000™ SPEEDBONDER™	83001	50 ml dual cartridge	Fast Fixture	Two-Part Acrylic	Cream	45,000	1:1	5	15	24	3,830	25	45
		83000	400 ml dual cartridge											
	H3300™ SPEEDBONDER™	83020	50 ml dual cartridge	Ultra-Fast Fixture	Two-Part Acrylic	Yellow	110,000	1:1	5	6	24	3,350	20	40
		83019	400 ml dual cartridge											
		83024*	40 lb. pail, adhesive											
83022*		40 lb. pail, activator												
E-04SS™	902242	400 ml dual cartridge	Seam Sealing	Two-Part Epoxy	Stainless Steel	Light Paste	1:1	3	5-6	24	1,100	Not Tested	Not Tested	
	901428	46 lb. pail, hardener												
	901426	50 lb. pail, resin												
U-09FL™ HYSOL®	29460	50 ml dual cartridge	Flexible	Two-Part Urethane	Clear	5,000	1:1	10	120	72	1,459	5 to 30	Not Tested	
	29461*	200 ml dual cartridge												
	29462*	400 ml dual cartridge												
	29370*	5 gallon pail, resin												
	29371*	5 gallon pail, hardener												
H3101™ SPEEDBONDER™	83007	50 ml dual cartridge	Medium Work Life	Two-Part Acrylic	Cream	75,000	1:1	15	25	24	2,510	20	35	
	83006	400 ml dual cartridge												
POLYOLEFIN BONDING	3032™	1051591	50 ml dual cartridge	Fast Fixture	Two-Part Acrylic	Off-White	14,000	10:1	3	25**	24	≥870	6.7**	5.1 ²
		40760*	490 ml dual cartridge											
		1057610*	5 gallon pail, adhesive											
		1070646*	5 gallon pail, activator											
	3034™	1051330	50 ml cartridge	Toughened	Two-Part Acrylic	Translucent	63,000	10:1	14	55**	24	≥1,160	>13.6**	30 ²
		960973	490 ml dual cartridge											
		1057671*	5 gallon pail, adhesive											
		1070646*	5 gallon pail, activator											

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** HDPE