

Magnet Bonding



Henkel –
Your partner worldwide



Loctite® Structural Adhesives for magnet bonding combine the benefits of fast process speeds with tough, durable, environmentally resistant bond strengths, making them ideal for bonding ferrite, alnico and neodymium iron boron permanent magnets used in electric motors, small engines, speakers, transformers and other devices. Magnets assembled with adhesives provide a wealth of benefits, including:

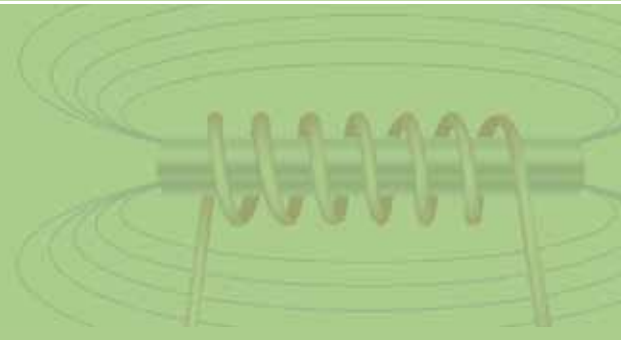
- Ability to use lower cost components
- Decreased inventory cost
- Easier to automate
- Will not chip magnets
- Prevent vibrational noise
- Prevent corrosion
- Acid-free
- Higher impact strength
- Higher temperature resistance
- Lower odor



Visit
henkelna.com/magnetbonding
to request a product sample, a training seminar or a call from a Loctite® Adhesives Specialist.



Magnet Bonding Guide



Henkel Corporation
Engineering Adhesives
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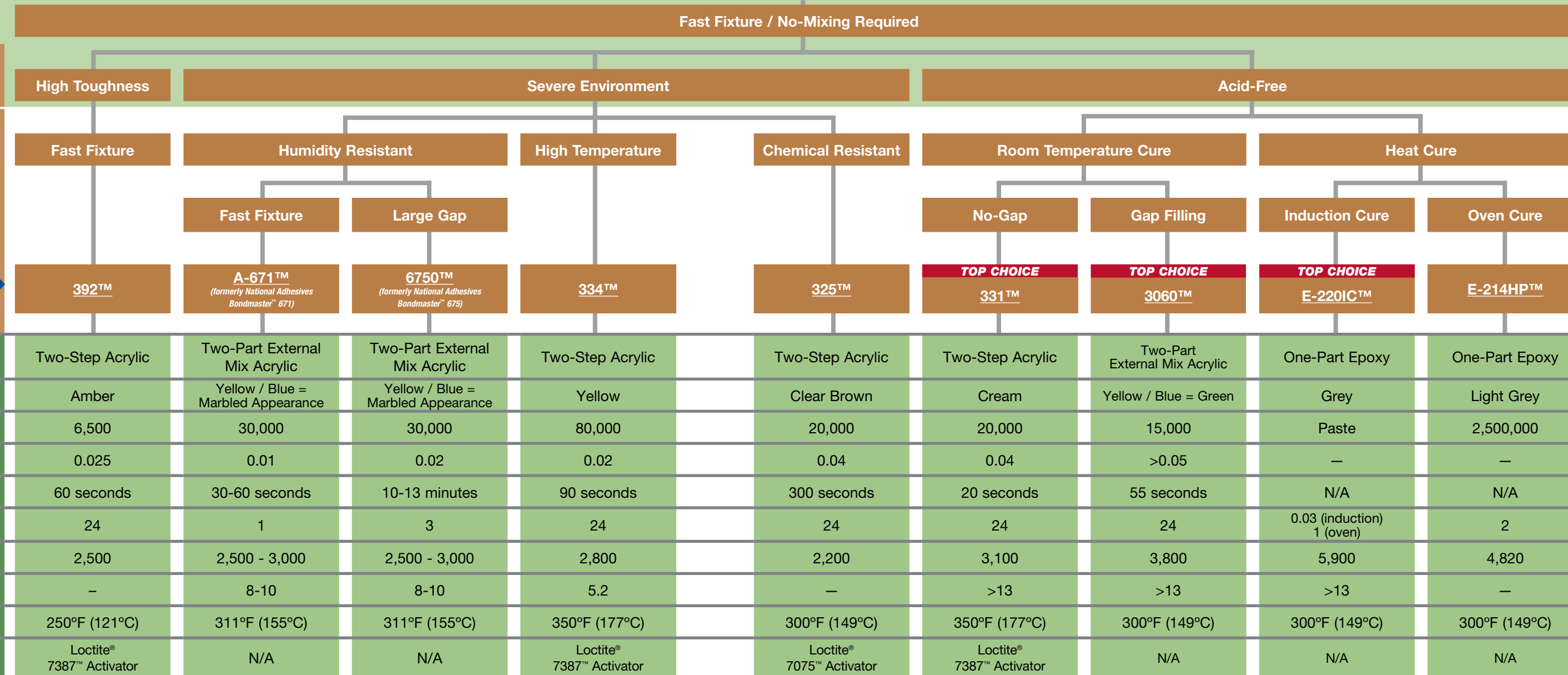
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Your Application



Solution



Product Description

Loctite® 392™ Structural Adhesive
Fast Fixture / Toughened
Single component, dual-cure acrylic. Provides fast fixture speed and tough, reliable bonds.

Loctite® A-671™ Structural Adhesive
(formerly National Adhesives Bondmaster™ 671)
Gap Filling
Two-component external mix acrylic requires no static mixing or activators. Excellent humidity resistance and gap filling capability. Fast fixturing.

Loctite® A-6750™ Structural Adhesive
(formerly National Adhesives Bondmaster™ 675)
Extended Worklife
Two-component external mix acrylic requires no static mixing or activators. Excellent humidity resistance and gap filling capability. Extended 5-minute work life to allow added time to position parts.

Loctite® 334™ Structural Adhesive
High Temperature
Single component, dual-cure acrylic. Forms tough, flexible bonds on gaps up to 0.02".

Loctite® 325™ Speedbonder™ Structural Adhesive
Chemical Resistant
Solvent resistant, activator-cured acrylic that fixtures in minutes. Forms flexible bonds on gaps up to 0.04". Designed for severe environments and temperatures to 300°F (149°C).

Loctite® 331™ Structural Adhesive
Ultra-Fast Fixture
Single component, toughened, activator-cure acrylic. Acid-free, non-corrosive to sensitive parts. Fixtures in 20 seconds and develops full strength in 30 minutes. Excellent high temperature resistance. Ideal for bonding close-fitting metals and magnets.

Loctite® 3060™ Structural Adhesive
Gap Filling
Two-component, acid-free, toughened external-mix acrylic requires no static mixing or activators. Turns green when mixed. Excellent high temperature resistance. Ideal for bonding large metal parts and ferrite or rare earth magnets. Non-corrosive to sensitive parts. Excellent gap filling capability.

Loctite® E-220IC™ Hysol® Epoxy Adhesive
Induction Cure
A one-component, acid-free, adhesive designed for induction cure operations. A fast curing paste that is formulated to reduce the risk of localized heating. Well-suited for metal and magnet bonding. Non-corrosive to sensitive parts.

Loctite® E-214HP™ Hysol® Epoxy Adhesive
Oven Cure
A one-component, acid-free, heat cure epoxy. Light grey, temperature resistant, high strength, non-sag. Non-corrosive to sensitive parts.

* Steel
** Made to order item

Magnet Bonding Equipment Selection

| Loctite® Equipment | Equipment Item No. | Used to Dispense | Adhesive Product and Item Numbers | | | | | | | | | |
|--|---|------------------|--|-----------------|---------|-------|-------|---------------------|---------------------|---------------------------------|----------|---------|
| | | | 325™ | 331™ | 334™ | 392™ | 3060™ | 6750™ | A-671™ | E-214HP™ | E-220IC™ | |
| Manual Dispensing | | | | | | | | | | | | |
| | 30 ml Manual Syringe Applicator | 98026 | Any fluid in 30 ml syringe including 25 ml syringes | — | 1256398 | 33403 | — | 1087985 | — | — | 29339 | 1078250 |
| | 50 ml Dual Cartridge Manual Applicator | 98472 1034026 | Two-component products – 40 ml dual cartridge | — | — | — | — | — | — | 1256506 | 1256489 | — |
| | 50 ml Tube Squeeze Dispenser | 1083845 | All adhesives in 50 ml tubes | — | — | — | 39250 | — | — | — | — | — |
| Pneumatic Syringe Dispensing | | | | | | | | | | | | |
| | Digital Syringe Dispensing System | 883976 | Any adhesive in 30 ml syringe including 25 ml syringes | — | 1256398 | 33403 | — | — | — | — | 29339 | 1078250 |
| Pneumatic 300 ml Cartridge Dispensing | | | | | | | | | | | | |
| | Pneumatic 300 ml Cartridge Dispenser | 1294304 | Any adhesive in 300 ml cartridge | — | — | 33470 | 39275 | — | — | — | 29340 | — |
| Bottle Dispensing | | | | | | | | | | | | |
| | Integrated Semiautomatic Dispenser | 1390321 | Any adhesive in bottles up to 2 liters | 32530/ 32586 | 1057674 | — | 39280 | 39280 | — | — | — | 1078261 |
| | Two Stationary Applicator Valves | 97113 | All components needed for external mix products | — | — | — | — | 1087986/ 1087987 | 1256503/ 1255702 | 1256488/ 1256502/ 1255708 | — | — |
| | External Mix Valve Fixture Assembly | 1095801 | | | | | | | | | | |
| | Two Integrated Semiautomatic Dispensers | 97007 97017 | | | | | | | | | | |
| | Dual Foot Pedal Switch | 1095798 | | | | | | | | | | |
| Pail Dispensing | | | | | | | | | | | | |
| | 5 gallon Pail Pumps | | Special orders only: contact your local sales representative or application engineer for item number | — | 1062124 | — | — | 1087988/ 1088035 | — | 1258501/ 1255709 | — | 1078499 |

More product information is available at:
henkelna.com/magnetbonding

More information on equipment is available at:
equipment.loctite.com