

LOCTITE[®] AA H8010[™]

 Known as LOCTITE[®] H8010[™]

January 2015

PRODUCT DESCRIPTION

LOCTITE[®] AA H8010[™] provides the following product characteristics:

| | |
|--|--|
| Technology | Acrylic |
| Chemical Type | Methacrylate |
| Appearance, Resin (Component A) | white |
| Appearance, Hardener (Component B) | blue |
| Appearance (Mixture) | gray ^{LMS} |
| Cure | Room temperature cure |
| Components | Two component - requires mixing |
| Mix Ratio, by volume - Part A: Part B | 10 : 1 |
| Product Benefits | Excellent environmental resistance Superior impact and peel strength Non-drip rheology Little or no surface preparation |
| Application | Bonding |

LOCTITE[®] AA H8010[™] is a non-sag, two component, room temperature curing methacrylate adhesive system. LOCTITE[®] AA H8010[™] is designed to have fast fixture time and excellent bond strength on multiple substrates including metals and composites. This product also has high elongation and excellent cold temperature impact strength. LOCTITE[®] AA H8010[™] forms resilient bonds and maintains its strength over a wide range of temperatures. This product was formulated with 0.38 mm spacer beads for consistent gap.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A:

| | |
|---|--------------------|
| Specific Gravity @ 25 °C | 0.96 |
| Viscosity, Cone & Plate, 25 °C, mPa·s (cP): | |
| Cone CP50-1 @ shear rate 50 s ⁻¹ | 1,770 |
| Viscosity, Brookfield - HBD, 25 °C, mPa·s (cP): | |
| Spindle 6, speed 10 rpm | 100,000 to 350,000 |
| Flash Point - See SDS | |

Part B:

| | |
|---|-----------------|
| Specific Gravity @ 25 °C | 1.1 |
| Viscosity, Cone & Plate, 25 °C, mPa·s (cP): | |
| Cone CP50-1 @ shear rate 50 s ⁻¹ | 5,880 |
| Viscosity, Brookfield - HBD, 25 °C, mPa·s (cP): | |
| Spindle 5, speed 20 rpm | 8,500 to 32,000 |
| Flash Point - See SDS | |

Mixed:

| | |
|---|-------|
| Specific Gravity @ 25 °C | 0.99 |
| Viscosity, Cone & Plate, 25 °C, mPa·s (cP): | |
| Cone CP50-1 @ shear rate 50 s ⁻¹ | 8,810 |
| Working Time @ 25 °C, minutes (maximum time before assembly): | |
| Steel | 35 |
| Aluminium | 35 |
| Polyethylene | 35 |
| Flash Point - See SDS | |

TYPICAL CURING PERFORMANCE

Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

| | |
|----------------------------------|----------|
| Fixture Time, ISO 4587, minutes: | |
| Grit Blasted Mild Steel | 35 to 40 |

Peak Exotherm Temperature

| | |
|--|-----|
| Peak Exotherm Temperature, 10 gram mass: | |
| Peak Temperature Time, minutes | 34 |
| Peak Temperature, °C | 119 |

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties:

| | |
|---|--|
| Glass Transition Temperature (Tg), ISO 11359-2, °C | 70 |
| Coefficient of Thermal Expansion, ISO 11359-2 K ⁻¹ : | |
| Pre Tg | 145×10 ⁻⁰⁶ |
| Post Tg | 271×10 ⁻⁰⁶ |
| Shore Hardness, ISO 868, Durometer D | 65 |
| Linear Shrinkage, % | 5 |
| Volume Shrinkage, % | 14 |
| Elongation, at break, ISO 527-2, % | 27 |
| Elongation, at yield, ISO 527-2, % | 20 |
| Tensile Strength, at yield, ISO 527-2 | N/mm ² 16 (psi) (2,270) |
| Tensile Strength, at break, ISO 527-2 | N/mm ² 15 (psi) (2,170) |
| Tensile Modulus, ISO 527-2 | N/mm ² 1,150 (psi) (167,400) |

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

| | |
|-------------------------------|--|
| Cured for 24 hours @ 22 °C | |
| Lap Shear Strength, ISO 4587: | |
| Steel | N/mm ² ≥13.8 ^{LMS} (psi) (≥2,175) |

Cured for 72 hours @ 22 °C.

Impact Strength, ISO 9653, J:

| | |
|---|----|
| Grit Blasted Mild Steel (GBMS) | 29 |
| Aluminum (abraded) | 2 |
| Grit Blasted Mild Steel (GBMS) @ -40 °C | 25 |

"T" Peel Strength, ISO 11339:

| | | |
|----------|---------|------|
| Steel | N/mm | 15 |
| | (lb/in) | (89) |
| Aluminum | N/mm | 6 |
| | (lb/in) | (37) |

Block Shear Strength, ISO 13445:

| | | |
|-------------------------|-------------------|---------|
| Ferrite Magnet to Steel | N/mm ² | 16 |
| | (psi) | (2,370) |
| Glass | N/mm ² | 17 |
| | (psi) | (2,470) |
| Acrylic | N/mm ² | 8 |
| | (psi) | (1,120) |
| Epoxy | N/mm ² | 13 |
| | (psi) | (1,915) |
| ABS | N/mm ² | 4.5 |
| | (psi) | (660) |
| PVC | N/mm ² | 8 |
| | (psi) | (1,110) |
| Polycarbonate | N/mm ² | 6 |
| | (psi) | (930) |

Lap Shear Strength, ISO 4587:

| | | |
|--------------------------------|-------------------|---------|
| Grit Blasted Mild Steel (GBMS) | N/mm ² | 19 |
| | (psi) | (2,820) |
| Aluminum | N/mm ² | 19 |
| | (psi) | (2,800) |
| Stainless Steel | N/mm ² | 18 |
| | (psi) | (2,650) |
| Galvanized Steel | N/mm ² | 6 |
| | (psi) | (880) |
| FRP | N/mm ² | 10 |
| | (psi) | (1,425) |
| Gelcoat | N/mm ² | 8 |
| | (psi) | (1,180) |

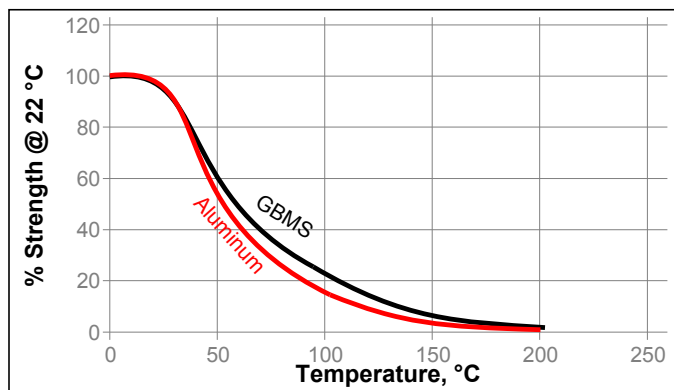
TYPICAL ENVIRONMENTAL RESISTANCE

Cured for 72 hours @ 22 °C

Lap Shear Strength, ISO 4587:

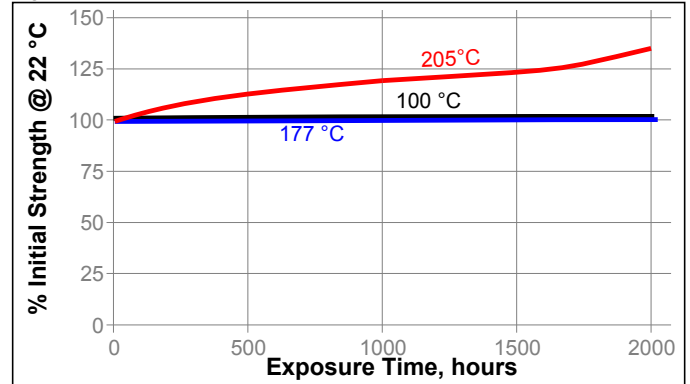
| |
|--------------------------------|
| Grit Blasted Mild Steel (GBMS) |
|--------------------------------|

Hot Strength



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 |
| Air | 87 | 100 | 100 |
| Motor oil (10W30) | 87 | 40 | 50 |
| Unleaded gasoline | 87 | 20 | 10 |
| Water/glycol 50/50 | 87 | 45 | 40 |
| Water | 22 | 90 | 90 |
| Acetone | 22 | 15 | 15 |
| Isopropanol | 22 | 70 | 70 |
| Salt fog | 35 | 80 | 70 |
| Condensing Humidity | 49 | 80 | 75 |
| 95% RH | 40 | 95 | 80 |

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 high strength structural bonds, remove surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants.
2. Use gloves to minimize skin contact. DO NOT use solvents for cleaning hands.
3. **Dual Cartridges:** To begin using a new cartridge, remove cartridge cap and dispense a small amount of adhesive, making sure both parts A&B are extruding. Attach nozzle and dispense approximately 25 to 50mm at ≥480kPa (≥70 psi) air gun pressure, before applying onto part to be bonded. Partially used cartridges can be stored with the mixing nozzle attached. To reuse, remove and discard old nozzle, attach the new nozzle, dispense approximately 25 to 50mm, before applying onto part to be bonded.
Bulk Containers: Normally material is dispensed through volumetric metered mixing equipment, attached to static mix nozzles.
4. For maximum bond strength apply adhesive evenly to both surfaces to be joined.

5. Application to the substrates should be made as soon as possible. Larger quantities and/or higher temperatures will reduce the working time.
6. Join the adhesive coated surfaces and allow to cure. Higher temperatures will speed up curing.
7. Keep assembled parts from moving during cure. The bond should be allowed to develop full strength before subjecting to any service load.
8. Excessive uncured adhesive can be cleaned up with ketone type solvents.

Loctite Material Specification^{LMS}

LMS dated February 26, 2009. 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 Quality.

Storage

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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 0.3