

# LOCTITE® AA 330

Known as LOCTITE® 330™  
January 2021

## PRODUCT DESCRIPTION

LOCTITE® AA 330 provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Urethane methacrylate ester
<b>Appearance (uncured)</b>	Slightly cloudy, colorless to pale yellow liquid <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	High
<b>Cure</b>	With activator
<b>Application</b>	Bonding

LOCTITE® AA 330 is a general purpose adhesive that is used to bond metal, wood, ferrite, ceramic and plastic materials. Applications include tool handles, appliances, sporting goods and decorative trim.

## NSF International

**Registered to NSF Category P1** for use as a sealant where there is no possibility of food contact in and around food processing areas. **Note:** This is a regional approval. Please contact your local Technical Service Center for more information and clarification.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.05

Viscosity, Brookfield - RVT, 25°C, mPa·s (cP):  
Spindle 7., speed 20 rpm 45,000 to 90,000<sup>LMS</sup>

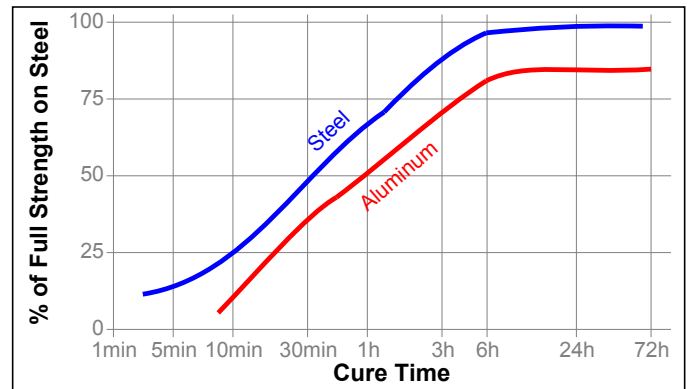
Viscosity, EN 12092 - SV, 25 °C, after 180 s, mPa·s (cP):  
Shear rate 20 s<sup>-1</sup> 30,000 to 70,000

Flash Point - See SDS

## TYPICAL CURING PERFORMANCE

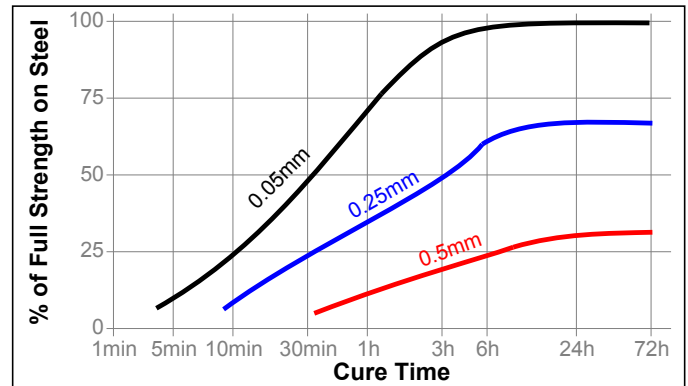
### Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The graph below shows the shear strength developed with time on grit blasted steel lap shears and tested according to ISO 4587. (Activator 7387™ applied to one surface).



### Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. The following graph shows the shear strength developed with time on grit blasted steel lap shears at different controlled gaps and tested according to ISO 4587. (Activator 7387™ applied to one surface).



## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K <sup>-1</sup>	151×10 <sup>-6</sup>
Temperature Range: -25°C to 25°C	
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Specific Heat, kJ/(kg·K)	0.3

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties





use. Do not return product to the original container. Henkel Corporation 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 Henkel Representative.

### Conversions

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

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Reference 1.5

