

LOCTITE AA 3008

May 2024

PRODUCT DESCRIPTION

LOCTITE AA 3008 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Diacrylate
Appearance (uncured)	Red, transparent
Fluorescence	Positive under UV light
Components	One component – requires no mixing
Viscosity	Low
Cure	Ultraviolet (UV)/ visible light
Secondary Cure	Activator
Application	Bonding and Sealing

LOCTITE AA 3008 is a low viscosity and high capillarity adhesive. When it is used with metallic substrate and absence of air, it presents a slow anaerobic cure. Rapid cure can be obtained when it is exposed to UV or Visible light. It is designed for sealing ammunition.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 23 °C	1.08
Viscosity, Brookfield - LVF, 25°C, mPa·s (cP): Spindle 1, Speed 30 rpm	12

TYPICAL CURING PERFORMANCE

LOCTITE AA 3008 can be cured by exposure to UV and/or visible light of sufficient intensity. To obtain a full cure on surfaces exposed to air, radiation at 365 nm is also required. The speed of cure will depend on the UV intensity and spectral distribution of the light source, the exposure time and the light transmittance. Typical cure condition is 1 to 10 seconds at 30 mW/cm² using a LED lamp of 365 nm.

Tack Free Time

Tack Free Time is the time required to achieve a tack free surface.

Tack Free Time, seconds: 30 mW/cm ² , measured @ 365 nm	4
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Fixture time

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

UV Fixture Time, Glass microscope slides, seconds: 25 mW/cm ² , measured @ 365 nm	1
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TYPICAL PROPERTIES OF CURED MATERIAL

Adhesive Properties

Cured @ 30 mW/cm², measured @ 365 nm, for 8 seconds using Loctite® LED Flood System, (samples with 0 mm gap).

Lap Shear Strength, ISO 4587: Acrylic	N/mm (lb/in)	0.5* (73)
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Cured for 23 hours @23 °C, Activator SF 7649 on 2 sides, (samples with 0 mm gap).

Lap Shear Strength, ISO 4587: Steel (grit blasted)	N/mm ² (psi)	970 (970)
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Compressive Shear Strength, ISO 10123: Steel pins and collars	N/mm ² (psi)	9.0 (1,300)
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*substrate failure

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. This product is light sensitive; exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling.
2. The product should be dispensed from applicators with black feedlines.
3. For best performance bond surfaces should be clean and free from grease.
4. Cure rate is dependent on lamp intensity, distance from light source, depth of cure needed or bondline gap and light transmission of the substrate through which the radiation must pass.
5. Cooling should be provided for temperature sensitive substrates such as thermoplastics.
6. Plastic grades should be checked for risk of stress cracking when exposed to liquid adhesive.
7. Excess adhesive can be wiped away with organic solvent.
8. Bonds should be allowed to cool before subjecting to any service loads.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.

Material removed from containers may be contaminated during 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.

Product specification

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and certificate

Please contact Henkel representative for related approval or certificate of this product

Data ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

Disclaimer

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Reference N/A