

LOCTITE[®] AA 358™

Known as LOCTITE[®] 358™
January 2015

PRODUCT DESCRIPTION

LOCTITE[®] AA 358™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	Urethane methacrylate ester
Appearance (uncured)	Amber liquid ^{LMS}
Components	One component - requires no mixing
Viscosity	Medium
Cure	Ultraviolet (UV) light
Cure Benefit	Production - high speed curing
Application	Bonding
Maximum Gap	0.5 mm

LOCTITE[®] AA 358™ bonds and seals glass to glass and glass to metal, as in decorative glassware, jewelry, etc.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.09
Vapor pressure, mbar	<3
Flash Point - See SDS	
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle 3, speed 20 rpm,	2,000 to 3,000 ^{LMS}
Viscosity, EN 12092, 25 °C, after 180 s, mPa·s (cP):	
Shear rate 36 s ⁻¹	1,750 to 3,500

TYPICAL CURING PERFORMANCE

LOCTITE[®] AA 358™ cures when exposed to UV radiation of 365 nm. To obtain a full cure on surfaces exposed to air, radiation at 250nm is also required. Both of these wavelengths are emitted by medium pressure mercury vapor lamps as incorporated, for example, in the LOCTITE[®] UVALOC 1000.

Tack Free Time

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

Tack Free Time, seconds:	
100 mW/cm ² , measured @ 365 nm	17

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:	
6 mW/cm ² , measured @ 365 nm	≤7 ^{LMS}

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹	100×10 ⁻⁶
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
UV Depth of Cure, mm:	
100 mW/cm ² , measured @ 365 nm, for 17 seconds	1.7
100 mW/cm ² , measured @ 365 nm, for 68 seconds	2.8

Electrical Properties

Surface Resistivity, IEC 60093, Ω·cm	2×10 ¹⁵
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	50
Dielectric Constant / Dissipation Factor, IEC 60250:	
100 Hz	3.4 / 0.03
1,000 Hz	3.4 / 0.03
10,000 Hz	3.4 / 0.03

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured @ 10 mW/cm², measured @ 365 nm, for 15 seconds using a black light

Tensile Strength, ISO 6922:	
Steel pin to Glass	N/mm ² ≥10 ^{LMS} (psi) (≥1,450)

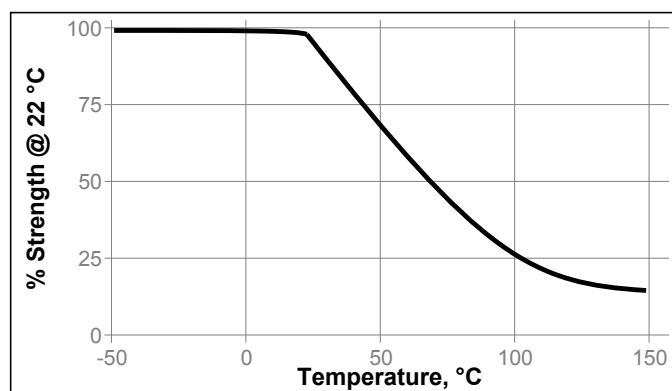
TYPICAL ENVIRONMENTAL RESISTANCE

Cured @ 100 mW/cm², measured @ 365 nm, for 20 seconds plus 1 week @ 22 °C

Tensile Strength, ISO 6922:	
Steel pin (grit blasted)Glass	

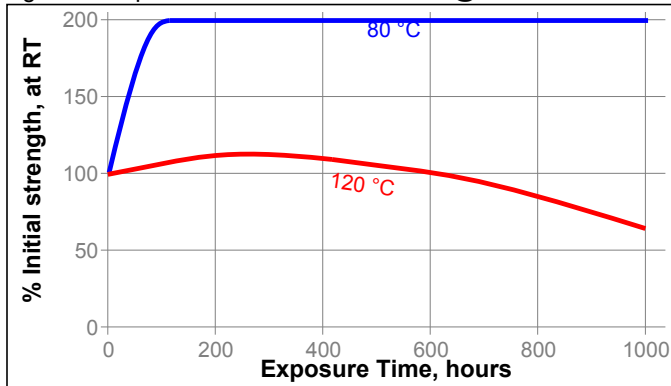
Hot Strength

Tested at temperature



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		
		100 h	500 h	1000 h
Heat/humidity 90% RH	40	50	35	25
Gasoline	22	100	100	85
1,1,1 Trichloroethane	22	100	100	100
Freon TA	22	100	100	100
Industrial methylated spirits	22	100	100	100

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 transmittance of the substrate through which the radiation must pass.
5. Recommended intensity for cure in bondline situation is 5 mW/cm² minimum (measured at the bondline) with an exposure time of 4-5 times the fixture time at the same intensity.
6. For dry curing of exposed surfaces, higher intensity UV is required (100 mW/cm²).
7. Cooling should be provided for temperature sensitive substrates such as thermoplastics.
8. Plastic grades should be checked for risk of stress cracking when exposed to liquid adhesive.
9. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
10. Bonds should be allowed to cool before subjecting to any service loads.

Loctite Material Specification^{LMS}

LMS dated June 17, 1999. 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

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 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 1.1