



Product 3035

July 2012

PRODUCT DESCRIPTION

LOCTITE® 3035 is a high strength, faster fixturing two-component acrylic adhesive system designed for bonding low energy plastics without surface pre-treatment. This easy to use, 1:1 mix ratio product cures very rapidly forming tough, durable bonds. LOCTITE® 3035 is low odor, non-flammable, halogen and solvent free and will also bond metals and a host of other plastics. This product requires no refrigeration.

UNCURED PROPERTIES

Mix Ratio	1:1
Viscosity	7,500 cP (Part A), 60,000 cP (Part B)
Sustainability	halogen-free, non-flammable, low outgassing
Odor	mild

CURING PROPERTIES

Color	pale yellow
Working Time, min	4
Fixture Time, min.	>10<15 (HDPE), >10<15 (HDPE/Steel)
Surface Cure	pass (24 hr. closed container)
Shrinkage (read-thru)	not tested

MECHANICAL PROPERTIES, PSI

- Block Shear Strength, ISO 13445, cured 72 hr. at 22°C

Polyolefins	
HDPE	1658 psi (14.3 MPa)
HDPE/Steel	657 psi (13.5 MPa)
LDPE	632 psi (9.9 MPa)
Metals	
Steel	879 psi (14.5 MPa)
Aluminum	423 psi (6.7 MPa)
Other Plastics	
ABS	642 psi (10.1 MPa)
Acrylic	886 psi (12.3 MPa)
Delrin	120 psi (2.6 MPa)
G-10 Epoxy	1045 psi (19.4 MPa)
Nylon	226 psi (1.9 MPa)
PC	726 psi (10.3 MPa)
Phenolic	416 psi (9.2 MPa)
PVC	1237 psi (8.8 MPa)
Valox 420	1081 (8.8 MPa)

- Impact Strength cured 72 hr. at 22°C

Metals	
Steel	3 Joules

- T-Peel Strength, ISO 11339

Metals	
Steel	2 lbf/in

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Storage

Store product in cool, dry location, in unopened containers at a temperature between 8°C and 28°C (26°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact Application Engineering at (860) 571-5100.

Data Ranges

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

Note

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