



STRUCTURAL ADHESIVES

Superior speed,
aesthetics and strength.
Without the weight.



PROBLEM

With traditional fastening:
Added weight, time, cost and difficulty.



SOLUTION

With structural adhesives:
Lightweight, strong, durable, less expensive
fastening with better end product aesthetics.

Take off the weight. Take on the load.

Structural adhesives join two materials firmly and permanently. The adhesive is the “bridge” between the substrates and provides advantages such as:

- Uniform stress distribution for better product reliability
- Design freedom for light weight constructions

Adhesives are easy to apply and assemble. The selection of the right adhesive depends on some factors like adhesive-material compatibility and joint requirements.



How to choose a structural adhesive.

GENERAL PURPOSE VS. SPECIALTY ADHESIVES

LOCTITE has a wide range of structural adhesives, from general purpose – strong and versatile enough to cover the majority of applications, to specialty – formulated for cases where special properties are needed.

HIGH PERFORMANCE

Solutions designed for a range of product needs, with respect to impact strength, peel strength, durability, working time etc.

FLEXIBLE SOLUTIONS

Offering excellent shock absorption, elasticity and adhesion to plastics, metals and glass.

SPECIAL SUBSTRATES

From epoxies designed to be safe for food and water contact to acrylics and polyurethanes for bonding e-coated metals, rigid foams, plastics and glass.

BONDING FERRITE COMPONENTS

Epoxies and acrylics designed for the specific requirements of bonding ferrite (magnets).

POTTING

Flowable epoxies designed for filling cavities and protecting components.

Legend for your adhesive choice:



FIXTURE TIME

A range of fixture times from ultra fast to slow to meet your process requirements.



SUBSTRATE

LOCTITE structural adhesives can bond most materials.



BEST SELLER

LOCTITE AA 326

Fast Fixture, Small Gaps, 2-Step

LOCTITE AA 326 is a yellow to amber, 2K no mix, medium viscosity (thixotropic) structural and magnet bonder which is activated with LOCTITE SF 7649. It has good adhesion to different types of ferrites, a fixture time of 3 minutes and a shear strength of 15 N/mm². It can be used in temperature up to 120 °C.

Benefits:

- Fast fixture
- High strength
- All purpose bonder



Fixture time:
3 min.



Substrate:
Aluminium, steel, ferrite



BEST SELLER

LOCTITE EA 3430

Optically Clear, Water-Resistant

LOCTITE EA 3430 is a 2K, clear epoxy adhesive which cures rapidly at room temperature after mixing. It is a general purpose adhesive which develops high strength on a wide range of substrates. The gap filling properties make this adhesive system suitable for rough and poorly fitting surfaces.

Benefits:

- High transparent
- Water resistance
- Fast curing



Fixture time:
15 min.



Substrate:
Metal, glass, ceramic, rigid plastic



Find the right product for your application



GENERAL PURPOSE

LOCTITE AA 330
LOCTITE EA 3421

LOCTITE AA 326
LOCTITE EA 3423

SPECIALTY

Working Life / Heat Cure

WORKING LIFE

Time ranges (before assembly) from fast to slow to meet your process requirements.

< 1 Hour

LOCTITE EA 3450
LOCTITE EA 9450
LOCTITE EA 9461
LOCTITE EA 3430

≥ 1 Hour

LOCTITE EA 9483
LOCTITE EA 9497

Heat Cure

LOCTITE EA 9514

High Performance

LOCTITE AA 3342
LOCTITE EA 9492

LOCTITE AA 3298
LOCTITE EA 9466

Plastic Repair

TEROSON PU 9225 Teroson PU 9225 SF
TEROSON PU 9225 SF ME Teroson PU 9225 UF ME

Multi-Substrate Repair Bonder

TEROSON PU 6700
TEROSON PU 6700 ME

General Purpose



LOCTITE AA 330
Small Gap



LOCTITE AA 326
Magnet Bonding,
High Viscosity



Fixture time: 3 min.



Fixture time: 3 min.



Substrate: Metals, ceramic, plastics



Substrate: Aluminium, steel, ferrite

Gap: 0.5 mm
Temperature resistance: 120 °C
Colour: Pale yellow
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7388

Gap: 0.5 mm
Temperature resistance: 120 °C
Colour: Light amber
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7649



LOCTITE EA 3421
Slow Curing



LOCTITE EA 3423
Non-Sag



Working life: 30 – 150 min.



Working life: 30 – 60 min.



Substrate: Metals, ceramics,
rigid plastics, wood



Substrate: Metals (can be sanded)

Temperature resistance: 120 °C
Colour: Clear amber
Chemistry: 2K Epoxy

Temperature resistance: 120 °C
Colour: Grey
Chemistry: 2K Epoxy

LOCTITE SERVICES

IMPROVE STRENGTH AND AESTHETICS IN REDUCED TIME.

<https://www.henkel-adhesives.com/uk/en/insights/loctite-services-signup.html>

Work Life / Heat Cure

WORKING LIFE* < 1 HOUR



LOCTITE EA 3450

Rapid Cure,
High Strength



Working life: 4 – 6 min.



Substrate: Metals, ceramics,
rigid plastics, wood

Temperature resistance: 100 °C

Colour: Grey

Chemistry: 2K Epoxy



LOCTITE EA 9450

Fast Cure,
Non-Sag



Working life: 2 – 7 min.



Substrate: Metals, ceramic,
glass, most plastics

Temperature resistance: 100 °C

Colour: Translucent

Chemistry: 2K Epoxy



LOCTITE EA 9461

Toughened



Working life: 40 min.



Substrate: Metals, ceramics,
rigid plastics, thermoset
laminates

Temperature resistance: 120 °C

Colour: Grey

Chemistry: 2K Epoxy



LOCTITE EA 3430

Optically Clear,
Water-Resistant



Working life: 5 – 10 min.



Substrate: Glass, metals,
ceramics, rigid plastics, wood

Temperature resistance: 100 °C

Colour: Ultra clear

Chemistry: 2K Epoxy

WORKING LIFE* ≥ 1 HOUR



LOCTITE EA 9483

High Strength,
Optically Clear



Working life: 25 – 60 min.



Substrate: Glass, metals,
ceramics, rigid plastics, wood,
magnets

Temperature resistance: 150 °C

Colour: Ultra clear

Chemistry: 2K Epoxy



LOCTITE EA 9497

Thermally Conductive,
High Compression Strength



Working life: 165 – 255 min.



Substrate: Metals, ceramics

Temperature resistance: 180 °C

Colour: Grey

Chemistry: 2K Epoxy

HEAT CURE



LOCTITE EA 9514

Toughened,
Induction Cure



Working life:
5 min. gel time at 120 °C



Substrate: Metals, ceramics,
magnets

Temperature resistance: 200 °C

Colour: Grey

Chemistry: 1K Epoxy

* Working life = maximum time before assembly

High Performance



**LOCTITE
AA 3342**
High Temperature



Fixture time: 1 – 1.5 min.



Substrate: Metals, magnets

Gap (if applicable): 0.5 mm
Temperature resistance: 180 °C
Colour: Dark yellow
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7386



**LOCTITE
AA 3298**
Glass Bonding



Fixture time: 3 min.



Substrate: Glass

Gap (if applicable): 0.5 mm
Temperature resistance: 120 °C
Colour: Straw yellow
Chemistry: Two-step acrylic
Activator: LOCTITE SF 7386



**LOCTITE
EA 9492**
High Temperature,
Chemical Resistance



Working life: 15 min.



Substrate: Metals, ceramics,
rigid plastics

Temperature resistance: 180 °C
Colour: White
Chemistry: 2K Epoxy



**LOCTITE
EA 9466**
High Peel Resistance,
High Shear Strength



Working life: 60 min.



Substrate: Metals, ceramics,
plastics

Temperature resistance: 120 °C
Colour: Off-white
Chemistry: 2K Epoxy

Plastic Repair



**TEROSON
PU 9225**
Holes >5 cm



Pot life/Working life: 10 min.



Substrate: Paintable plastic
parts

Colour: Dark grey
Chemistry: 2K Polyurethane
Primer: TEROSON 150



**TEROSON
PU 9225 SF**
Fast Cure, Holes <5 cm



Pot life/Working life: 2 min.



Substrate: Paintable plastic
parts

Colour: Dark grey
Chemistry: 2K Polyurethane
Primer: TEROSON 150



**TEROSON
PU 9225 SF ME**
MicroEmission™



Pot life/Working life: 2 min.



Substrate: Paintable plastic
parts

Colour: Dark grey
Chemistry: 2K Polyurethane
Primer: TEROSON 150



**TEROSON
PU 9225 UF ME**
Ultra Fast Cure,
MicroEmission™



Pot life/Working life:
1 min. max.



Substrate: Paintable plastic
parts

Colour: Black
Chemistry: 2K Polyurethane
Primer: TEROSON 150

Multi-Substrate Repair Bonder



**TEROSON
PU 6700**
Solvent-Free



Pot life/Working life: 10 min.



Substrate: Metals, plastics,
painted surfaces, wood

Colour: Dark grey
Chemistry: 2K Polyurethane
Paintable/Sandable: Yes



**TEROSON
PU 6700 ME**
Fast Curing,
MicroEmission™



Pot life/Working life: 5 min.



Substrate: Metals, plastics,
painted surfaces, wood

Colour: Dark grey
Chemistry: 2K Polyurethane
Paintable/Sandable: Yes

Equipment

DISPENSERS

Pneumatic



Manual



50 ml

LOCTITE 96001
50 ml 1:1/2:1
Dual Cartridge
Applicator
Manual

IDH 26745

LOCTITE 97042
50 ml 1:1/2:1
Dual Cartridge
Applicator
Pneumatic

IDH 476898

50 ml 10:1
Dual Cartridge
Applicator
Manual

IDH 1034026

50 ml 10:1
Dual Cartridge
Applicator
Pneumatic

IDH 1493310

200 ml

LOCTITE EQ HD14
200 ml
Dual Cartridge
Manual Dispenser
1:1 - 10:1

IDH 2693822

LOCTITE EQ HD14
200 ml
Dual Cartridge
Pneumatic
Dispenser
1:1 - 10:1

IDH 2693824

400 ml

LOCTITE EQ HD14
400 ml
Dual Cartridge
Manual Dispenser
1:1 - 10:1

IDH2693823

LOCTITE EQ HD14
400 ml
Dual Cartridge
Pneumatic
Dispenser
1:1 - 10:1

IDH2693825

NOZZLES

 IDH 1487440

 IDH 1487439

 IDH 142242

50 ml
Epoxy Nozzle

400 ml
Epoxy Nozzle

50 ml
Polyurethane Nozzle

**HAVE A UNIQUE
APPLICATION?
SEE THE FULL LINE:**

<https://www.henkel-adhesives.com/uk/en/products/industrial-adhesives/structural-adhesives.html>

Please refer to page 130 for additional equipment/information.



2-STEP ACRYLICS

Product	Pack Size	Features	Colour	Viscosity (mPa·s)	Gap Fill (mm)	Fixture Time (min.)	Shear Strength, GBMS (N/mm ²)	Temperature Resistance (°C)
GENERAL PURPOSE								
LOCTITE AA 330	50 ml kit	General purpose adhesive for metals, ceramic, plastics	Pale yellow	67,500	0,5	3	23	120
MAGNET BONDING								
LOCTITE AA 326	50 ml	Ferrites to plated materials in electric motors, loudspeakers hardware, jewellery	Light amber	18,000	0,5	3	15	120
LOCTITE AA 3342	300 ml	High temperature magnet adhesive for metals, magnets	Dark yellow	90,000	0,5	1 – 1.5	23	180
GLASS BONDING								
LOCTITE AA 3298	300 ml	Excellent glass bonder	Straw yellow	29,000	0,5	3	29	120

EPOXIES

Product	Pack Size	Features	Colour	Viscosity (mPa·s)	Mix Ratio	Fixture Time (min.)	Shear Strength, GBMS (N/mm ²)	Temperature Resistance (°C)
HIGH PERFORMANCE								
LOCTITE EA 3421	50 ml	Universal adhesive with long working time	Clear amber-yellow	37,000	1:1	240	22	120
LOCTITE EA 3423	50 ml, 200 ml	Universal adhesive, excellent for metals, good moisture resistance	Grey	300,000	1:1	180	17	120
LOCTITE EA 9461	50 ml	High impact resistant, gap filling	Grey	72,000	1:1	240	25	120
LOCTITE EA 9466	50 ml, 400 ml	High impact and peel resistance, excellent bond strength to a wide variety of plastics and metals	Off-White	35,000	2:1	180	37	120
LOCTITE EA 9483	50 ml, 400 ml	Optical clarity and high strength, ideal for bonding decorative panels and displays	Ultra Clear	7,000	2:1	210	23	150
LOCTITE EA 9492	50 ml, 400 ml	High temperature and chemical resistance	White	30,000	2:1	75	20	180
LOCTITE EA 9497	50 ml	High temperature, thermally conductive, room temperature cure	Grey	12,000	2:1	480	20	180
FAST FIXTURE								
LOCTITE EA 3430	24 ml, 50 ml	Universal, fast curing	Ultra Clear	23,000	1:1	15	22	100
LOCTITE EA 3450	25 ml	Fast curing, ideal for metal repairs	Grey	35,000	1:1	15	25	100
LOCTITE EA 9450	50 ml	Fast curing, gap filling	Translucent	200,000	1:1	13	23	100
ONE PART / HEAT CURE								
LOCTITE EA 9514	300 ml	High temperature resistance and mechanical strength, excellent impact resistance	Grey opaque paste	45	-	-	44	200

POLYURETHANES

Product	Pack Size	Features	Colour	Pot Life/ Working Time (min.)	Cure Time @ RT (h)	Paintable?	Sandable?	MicroEmission™?
TEROSON PU 6700	50 ml, 310 ml, 400 ml	Solvent-free, multi-purpose bonder for metals, plastics, wood, painted surfaces	Grey	10	6	Yes	Yes	No
TEROSON PU 6700 ME	50 ml, 400 ml	Solvent-free, multi-purpose bonder for metals, plastics, wood, painted surfaces	Grey	5	5	Yes	Yes	Yes
TEROSON PU 9225	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Dark Grey	10	5	Yes	Yes	No
TEROSON PU 9225 SF	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Dark Grey	2	1.5	Yes	Yes	No
TEROSON PU 9225 SF ME	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Dark Grey	2	1.5	Yes	Yes	Yes
TEROSON PU 9225 UF ME	50 ml	Fast curing repair adhesive, in combination with plastics the use of an approved Henkel primer is absolutely necessary	Black	1 max.	1.5	Yes	Yes	Yes

