

# LOCTITE<sup>®</sup> AA 392<sup>™</sup>

Known as LOCTITE<sup>®</sup> 392<sup>™</sup>  
November 2014

## PRODUCT DESCRIPTION

LOCTITE<sup>®</sup> AA 392<sup>™</sup> provides the following product characteristics:

<b>Technology</b>	Acrylic
<b>Chemical Type</b>	Modified acrylic
<b>Appearance (uncured)</b>	Translucent beige to dark amber <sup>LMS</sup>
<b>Components</b>	One component - requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Activator
<b>Secondary Cure</b>	Heat
<b>Application</b>	Bonding

LOCTITE<sup>®</sup> AA 392<sup>™</sup> may be used for applications which require very fast assembly. This adhesive is particularly suited to DC motor assembly, magnet bonding and bonding of pre-coated sheet metal. Automated assembly lines with short cycle times will benefit from the rapid cure characteristics of LOCTITE<sup>®</sup> AA 392<sup>™</sup>. The product has the capability to produce tough, durable bonds with outstanding impact and peel resistance.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 1.16

Flash Point - See SDS

Viscosity, Brookfield - HBT, 25 °C, mPa·s (cP):

Spindle TA, speed 2.5 rpm, Helipath 20,000 to 80,000<sup>LMS</sup>  
Spindle TA, speed 20 rpm, Helipath 6,500 to 17,500<sup>LMS</sup>

## TYPICAL CURING PERFORMANCE

LOCTITE<sup>®</sup> AA 392<sup>™</sup> is designed to be used with Activator 7380<sup>™</sup> or 7387<sup>™</sup> and cured at room temperature. Cure characteristics are measured by determining fixture time (handling time) and speed of cure.

### Fixture Time

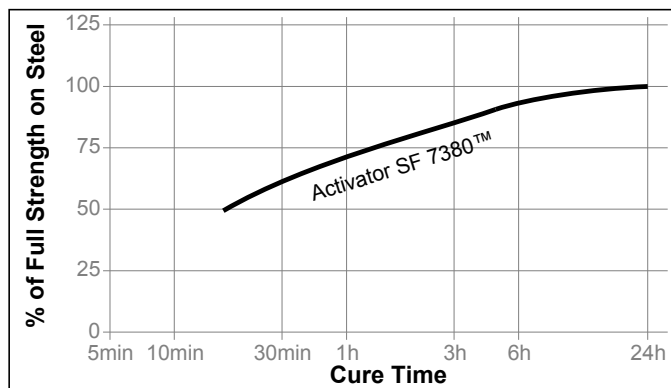
Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Fixture Time, seconds:

Steel, with Activator 7380<sup>™</sup> on 1 side:  
0.05 mm gap ≤25  
0.25 mm gap ≤330

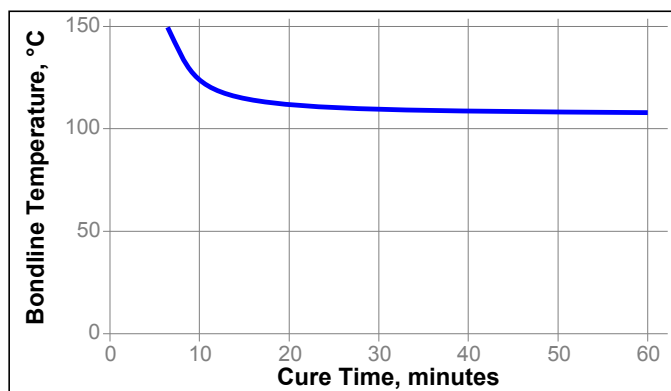
### Cure Speed vs. Activator

The graph below shows the shear strength developed with time on steel lap shears using and tested according to ISO 4587.



### Cure Speed vs. Temperature

Heat can be used to effect or accelerate cure when surface priming operations are undesirable. Typical heat cure conditions consist of heating and maintaining bondline at a temperature shown in the graph below for the corresponding time specified. Optimum conditions for heat cure should be determined on the actual assemblies.



## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties:

Shore Hardness, ISO 868, Durometer D	65
Elongation, ISO 527-3, %	130
Tensile Strength, ISO 527-3	N/mm <sup>2</sup> 18.6
	(psi) (2,700)
Tensile Modulus, ISO 527-3	N/mm <sup>2</sup> 144.8
	(psi) (21,000)

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

After 24 hours @ 22 °C, Activator 7380<sup>™</sup> on 1 side

Lap Shear Strength :

Steel	N/mm <sup>2</sup> ≥11.7 <sup>LMS</sup>
	(psi) (≥1,696)



After 48 hours @ 22 °C, Activator 7380™ on 1 side

Lap Shear Strength :

Steel :		
0 gap	N/mm <sup>2</sup>	17.2 (psi) (2,500)
0.25 mm gap	N/mm <sup>2</sup>	15.8 (psi) (2,300)
0.5 mm gap	N/mm <sup>2</sup>	14.5 (psi) (2,100)
Aluminum :		
0 gap	N/mm <sup>2</sup>	11 (psi) (1,600)
Zinc dichromate :		
0 gap	N/mm <sup>2</sup>	11 (psi) (1,600)

## TYPICAL ENVIRONMENTAL RESISTANCE

After 48 hours @ 22 °C, Activator 7380™ on 1 side

### Heat Aging

Heat aged for 2000 hours

Lap Shear Strength :

Steel:		
@ 93 °C	N/mm <sup>2</sup>	13.1 (psi) (1,900)
@ 121 °C	N/mm <sup>2</sup>	9 (psi) (1,300)
@ 150 °C	N/mm <sup>2</sup>	3.4 (psi) (500)

### Humidity Resistance

Conditioned in 50°C condensing humidity

Lap Shear Strength :

Steel:		
1 week	N/mm <sup>2</sup>	13 (psi) (1,900)
2 weeks	N/mm <sup>2</sup>	9.3 (psi) (1,350)
4 weeks	N/mm <sup>2</sup>	3.4 (psi) (500)

### Chemical/Solvent Resistance

Aged under conditions indicated and tested @ °C

Environment	°C	% of initial strength	
		720 h	
Air reference	87	100	
Water/glycol 50/50	87	30	
Gasoline	87	10	
Motor oil (MIL-L-46152)	87	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

- For best performance bond surfaces should be clean and free from grease.
- To ensure a fast and reliable cure, Activator 7380™ or 7387™ should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes.
- The recommended bondline gap is 0.1 mm. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, Activator 7380™ or 7387™ should be applied to both surfaces. Parts should be assembled immediately (within 1 minute).
- Excess adhesive can be wiped away with organic solvent.
- Bond should be held clamped until adhesive has fixtured.
- Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

## Loctite Material Specification<sup>LMS</sup>

LMS dated January 3, 2003. 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 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 **N/A**

