Technical Data Sheet

LOCTITE® AA 350

January 2026

Product description
LOCTITE® AA 350 provides the following product characteristics:

Technology	Acrylic
Chemical type	Modified Acrylic
Appearance (uncured)	Transparent dark amber liquid[LMS]
Components	One component - requires no mixing
Viscosity	Medium
Cure	Ultraviolet (UV) light
Application	Bonding, Encapsulating or Sealing
Operating temperature	-54 to +150°C

LOCTITE® AA 350 is a medium viscosity adhesive that forms tough, flexible bonds with excellent adhesion to glass, metal and certain thermoplastic substrates. Strength retention is excellent when exposed to water or humidity. The product has a long open working time, making it applicable for screen printing operations.

Typical properties of uncured material

Specific gravity @ 25°C	1.01
Flash point (TCC), °C	>93
Viscosity @25°C, mPa·s:	
Brookfield RVT:	
Spindle 5 @20 rpm	3,500 to 6,000[LMS]

Typical curing performance
Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of the light source, exposure time and light transmittance of the substrate through which the light must pass.

Fixture time
UV Fixture time vs source intensity
UV Fixture time, seconds:
UV Light source intensities:

6 mW/cm² @365 nm	15
12 mW/cm² @365 nm	10
100 mW/cm² @365 nm	5

UV Fixture time on glass microscope slides, 0 gap
UV Fixture time, seconds:
UV Light source intensities:

6 mW/cm² @365 nm	≤20[LMS]

Full cure time (approximate)
UV Fixture time vs source intensity
UV Light source intensities:

6 mW/cm² @365 nm	90
12 mW/cm² @365 nm	60
100 mW/cm² @365 nm	30

Note:
Surface can be cured tack free with 60 mW/cm² or greater intensity.

Typical performance of cured material
Adhesive properties:

Shear strength, ASTM D 1151, N/mm²	
ABS to glass:	
RT control	4.97
Aged for 30 days in 95% RH at 35°C	4.48
PVC to glass:	
RT control	5.34
Aged for 30 days in 95% RH at 35°C	4.97
Polycarbonate to glass:	
RT control	5.38
Aged for 30 days in 95% RH at 35°C	5.10
Polystyrene to glass:	
RT control	1.38
Aged for 30 days in 95% RH at 35°C	1.52
Acrylic to glass:	
RT control	5.07
Aged for 30 days in 95% RH at 35°C	2.48
Polyester glass to glass:	
RT control	5.28
Aged for 30 days in 95% RH at 35°C	4.28
Epoxyglass to glass:	
RT control	4.83
Aged for 30 days in 95% RH at 35°C	4.32

Cured @ 6 mW/cm² @365 nm for 3 minutes
Adhesive properties:

Torsional shear strength, N.m:	
Aluminum hex button to glass:	≥61.00[LMS]

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).

Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.

This product is not normally recommended for use on plastics (particularly thermoplastic materials where stress cracking of the plastic could result). Users are recommended to confirm compatibility of the product with such substrates.

Directions for use:

For best strength and aging properties, bonding surfaces should be clean and dry. When cured under low intensity light, excess adhesive will remain uncured and can be removed with a chlorinated solvent wipe.

@ 0.127mm bondline - 78.7cm² /ml
@ 0.254mm bondline - 39.4cm² /ml

Loctite material specification[LMS]
LMS dated June 1, 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 28°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 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
(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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