



The Glue People

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Tradeweld Acrylic

Toughened methacrylate adhesive

General Description

Tradeweld Acrylic is a pre-mixed or two way (one on each surface), toughened methacrylate adhesive. It combines a long open time (4.5 minutes) with a rapid strength development (1380psi after 10 minutes) and full strength adhesion in an hour at 20°C.

Tradeweld Acrylic has outstanding impact resistance making it ideal for use in vehicle manufacture.

Uses

Tradeweld Acrylic is a versatile, rapid curing adhesive suitable for dissimilar surfaces particularly where a high impact resistance is required. It gives excellent bonds to most metals and plastics.

Preparation

Ensure the surfaces to be bonded are clean, dry and free dust, grease or any loose contaminants. Tradeweld Acrylic will bond well to lightly oiled surfaces but will perform better on degreased surfaces.

Application

Either:

1. Using the twin mixer gun and static mixer nozzle, apply a thin bead of the pre-mixed adhesive to one surface or
2. Apply a thin coat of the A pack to one surface and a thin coat of the B pack to the other.

Bring the surfaces together within the mixed life of the adhesive and DO NOT disturb the bond during the early minutes of cure as this will weaken the finished bond considerably. If clamps are used DO NOT vary the pressure during cure.

Physical Data

Adhesive type	Twin pack methacrylate.
Viscosity	45 poise @ 25°C
Flammability	Highly Flammable.
Flash point	11°C
Solvent	Solvent free. Monomers used as solvents enter the reaction to form adhesive.
Specific gravity	A Pack – 1.05 B Pack – 0.97
Storage life	6 months – Refrigerate to extend shelf life.

Strengths

Impact strength On steel bond at ambient temperature. 3.1 J/cm² x 3 impacts of 3.5Kg falling 0.6m

Peel strength On aluminium sheet. 13.8 N/cm

Shear strength aged 1 day @ 25°C

<u>Metals</u>	<u>psi</u>	<u>Plastics</u>	<u>psi</u>
Aluminium	3110	ABS	1350 SF
Ganvanised steel	540	Formica	600 SF
Mild steel	2950	GRP	600 SF
Stainless steel	4700	HIPS	300
Zintec	1200	Nylon	400
		Perspex	600
		Polycarbonate	930 SF
		uPVC	1170 SF

(SF = Substrate Failure)

Strength development on steel

	10 mins	15 mins	30 mins	1 day
Shear strength (psi)	1380	2700	2740	2950

Heat resistance

	80°C	120°C	160°C
Shear strength on steel (psi)	2330	1750	750

General

For safe handling information on this product, consult the material safety data sheets, (MSDS).

Storage

*****PROTECT FROM FROST*****

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° 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 specific shelf-life information, contact Trade Grade Products at the above address.

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.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradeweld Acrylic.