



*The Glue People*

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# Tradeweld Acrylic TX

**Modified methacrylate structural adhesive**

## General Description

Tradeweld Acrylic TX is a pre-mix, high performance two-part structural acrylic adhesive which provides high strength bonds to a wide range of substrates.

The two component adhesive is extruded as a single pre-mixed bead using a twin cartridge system. The system's ease of use and accuracy of application means increased productivity.

## Additional Features

- Fast bonding, handling strength in approximately 10 to 15 minutes.
- Easy to use cartridge system for accurate application.
- Excellent temperature resistance (-40°C to +120°C).
- Up to 4mm gap fill.
- Non-sagging.
- Controlled mixing for consistent bond strength.
- Simple 1:1 ratio mix.
- Tough, durable bonds with excellent bond strength across a wide range of substrates.
- Good chemical resistance.
- Low odour acrylic adhesive and activator.

## Application

### 50ml twin pack

For best results use on clean, dry substrates between +10°C to +30°C. Insert the cartridge into the slot on the applicator gun. Once the cartridge is secure, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixing nozzle. Attach the mixing nozzle and dispense adhesive until a uniform colour is evident. Apply the mixed adhesive to one joint surface, immediately bring the two surfaces into contact and apply a steady pressure. The cartridge can be re-sealed if only partly used by removing the mixing nozzle, cleaning the two cartridge openings and replacing the cartridge cap.

### 28ml twin pack

For best results use on clean, dry substrates between +10°C to +30°C. Remove the cap and cut the ends off of each part. Extrude equal amounts from the cartridge and mix together by hand until a uniform colour is achieved. Immediately bring the two surfaces into contact and apply a steady pressure.

It is important that once the substrates are pressed together that no movement occurs and any clamping pressure remains constant, as this will affect the strength of the final cured bond.

Tradeweld Acrylic TX adhesive provides high strength bonds across a wide range of plastics, composites and metals.

Typical uses are:

Structural bonding, Product assembly and repair, Bonding plastics including polycarbonate, rigid polystyrene and acrylic e.g. Perspex and Bonding most metals including aluminium, mild and stainless steel.

## Physical Data (Liquid)

**Cured 7 days @ 23°C**

<b>T-Peel</b>	35 – 40 psi
<b>Impact resistance</b>	22 ft.lb/in
<b>Tensile elongation</b>	15 – 25%
<b>Shore hardness</b>	78 Shore D
<b>Gap fill</b>	3mm
<b>% Solids by volume</b>	100
<b>Tensile shear, ABS</b>	1300 psi
<b>Tensile shear, polycarbonate</b>	1400 psi
<b>Operating temperature</b>	-40°C to 120°C
<b>Maximum temperature</b>	150°C
<b>Shelf life</b>	1 year

**Uncured**

<b>Colour</b>	Off white			
<b>Viscosity</b>	Adhesive	55000 cps	Activator	50000 cps
<b>Specific gravity</b>	0.82			
<b>Mix ratio by volume</b>	1:1			
<b>Flash point</b>	10.5°C			
<b>Working time</b>	4-6 minutes @ 22°C			
<b>Fixture time</b>	10-15 minutes @ 22°C			
<b>Functional cure</b>	45 minutes to 1 hour			
<b>Full cure</b>	24 hours			

## General

**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.

**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 TX.