



## TECHNICAL DATA SHEET



### DESCRIPTION

ULTRA FAST METAL BONDING is a high strength, rapid curing, methyl methacrylate, structural adhesive, which gives a tough durable bond with plastics, metals and other materials. It is isocyanate-, phthalates-, solvent-, PVC- and silicone free.

### APPLICATIONS

- Automotive
- Marine
- Construction and assembly industries
- Bonding of PVC, Acrylic, PC, PBTO, PU, Stainless Steel, Gel Coats, ABS, Styrene, Epoxy.

### FEATURES

- Does not attack surfaces
- Room temperature cured with short open time
- Over paintable
- Very good UV-resistance and excellent ageing properties
- Gap filling up to 5 mm.
- Non sagging thixotropic formulation
- Excellent impact, peel and shear strength

### TECHNICAL DATA

#### Nominal Components Properties:

	ULTRA FAST (ADHESIVE)	ULTRA FAST (ACTIVATOR)
Chemical base	Methyl methacrylate	Methyl methacrylate
Colour	Off White	Off White
Specific Gravity (g/cm <sup>3</sup> )	1,00	1,00
Viscosity (mPas)	60.000	40.000

## Typical Cure Characteristics:

Open time	@ 23° C (min)	6
Curing time	@ 23° C (min)	20
Complete cure	@ 23° C (hours)	24

**\*Note** Temperatures higher or lower than 23°C will have influence on the open time and curing time.

## Typical properties of Cured Adhesive:

Shore D Hardness	EN ISO 868 @ 23°C	63
Tensile Strength	ADTM D638 @ 23°C (MPa)	24
Young's Modulus	ADTM D638 @ 23°C (MPa)	1800
Elongation at Break	ADTM D638 @ 23°C (%)	33

## ADHESION

Ultra fast metal bonding has excellent primer-less adhesion properties to metals, painted surfaces, aluminium PVC, glass fibre reinforced plastic, ABS, polycarbonate and plastic materials. Ultra fast metal bonding can be over-painted with most types of lacquers.

**Note!** In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.

## APPLICATION CONDITIONS

- **Application temperature:** Between 15°C and 25°C
- **Substrate:** The surfaces to be bonded should be clean, dry and free from dust and grease
- **Application method:** Manual and pneumatic guns
- **Mixing ratio:** 1:1
- **Mixing:** Connect the mixertip to the cartridge and press out 2 cm. (do not use) to be sure that you have a 100% mixture of the 2 components
- **Assembling:** After applying the adhesive, assembly the parts (within open time) and immediately clamp or press

**SAFETY INFORMATION**

See Safety Data Sheet.

**SHELF LIFE AND STORAGE**

**STORAGE:** Unopened containers stored at a dry place indoors between 5°C and 25°C

**SHELF LIFE:** 9 Months in the originally sealed cartridge

**AVAILABLE PACKAGING**

Code	Description	Packaging
5006-001082	ULTRA FAST METAL BONDING	50ML

\*For more information about our products or means of application, please visit our website [www.carrepairsystem.eu](http://www.carrepairsystem.eu) or send us an e-mail to [info@carrepairsystem.eu](mailto:info@carrepairsystem.eu)

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