



TOLL FREE 1-800-220-1966

C-19

**Methacrylate
Seaming Adhesive**

Surfacing Adhesive — UV Stable — Two Part

HANDLING AND APPLICATION

C-19 adhesive (Part A) and activator (Part B) are flammable. Contents include Methacrylate Ester. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks, and open flames. Reference the Material Safety Data Sheet for more complete safety information.

Note: Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air, steam, and volatile gases. To prevent this, use only enough material as needed for use within the working time for the product and confine gap thickness to no more than 0.125 in. (3.2mm). Questions relative to handling and applications should be directed to

DISPENSING ADHESIVE

Chem-Set C-19 may be applied manually. Static mixer selection is critical to the proper mixing and performance of C-19 adhesives. Pre-measured (250mL and 50mL) cartridges are available, as well as the hand-held guns with which to dispense the adhesive. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and clamped. All adhesive application, part positioning, and fixturing should occur *before* the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. If the adhesive is already cured, careful scraping, or abrasion followed by a solvent wipe may be the most effective method of clean up.

EFFECT OF TEMPERATURE

Application of adhesive at temperatures between 65°F (18°C) and 80°F (26°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure speed; above 80°F (26°C) will increase cure speed. The viscosities of Parts A and B of this adhesive are affected by temperature. To ensure consistent dispensing in meter-mix equipment, adhesive and activator temperatures should be held reasonably constant throughout the year.

STORAGE AND SHELF LIFE

Shelf life of C-19 Surfacing Adhesive (Part A) is 18 months. Shelf life of activator (Part B), including cartridges that contain activators, is 18 months. Shelf life is based on continuous storage between 54°F (12°C) and 74°F (23°C). Long term exposure above 74°F (23°C) will reduce the shelf life of these materials. Prolonged exposure of activators, including cartridges that contain activators, above 98°F (37°C) quickly diminishes the reactivity of the product and should be avoided. These products should never be frozen.

Notes

1. Application Testing: Chemical Concepts recommends that all substrates be tested with the selected adhesive in the anticipated service conditions to determine suitability.

2. Application Temperature: Do not to apply adhesive above 90F or below 60F.

3. Working Time: The time elapsed between the moment Parts A and B of the adhesive system are combined and thoroughly mixed and the time when the adhesive is no longer useable or gel in nature. Times presented were tested at 74°F (23°C).

4. Fixture Time: The interval of time after which surface being joined will support a 1 kg dead weight on a 0.50 in. (12mm) overlap joint 1.00 in. (25mm) wide, without movement. Times presented were tested at 74°F (23°C).

5. Environmental Resistance: to chemical exposure varies greatly based on several parameters including; temperature, concentration, bondline thickness, and duration of exposure. The chemical resistance guidelines listed assume long term exposures at ambient conditions.

6. Mix Nozzle: recommended mix nozzles MFX 08-18 for the 250 ml cartg. and MDX 5.4-16 for the 50 ml.

7. Optimal Bond Gaps: Between 0.01 to 0.125 in. (0.254 to 3.2 mm) is recommended. Outside these values consult with an Chemical Concepts representative.

NOTE: All information on this data sheet is based on laboratory testing and is not intended for design purposes. Chemical Concepts makes no representations or warranties of any kind concerning this data. Due to variance of storage, handling and application of these materials, Chemical Concepts cannot accept liability for results obtained.