

CarbonBond Structural Acrylic Adhesive

1. DESCRIPTION

CarbonBond Structural Acrylic Adhesive is a two-part methacrylate adhesive designed for the structural bonding of various substrates, including fiberglass, steel, aluminum, and thermoplastics. Combined at a ratio of 1:1, CarbonBond Structural Acrylic Adhesive has a working time of 15 to 18 minutes and achieves nearly 90 percent of its ultimate strength in 40 minutes at room temperature curing. CarbonBond Structural Acrylic Adhesive provides high strength and stiffness also bonds to the above reference surfaces with generally no preparation effort.

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2. CHARACTERISTICS:

Room Temperature Cure

- Working Time
- Fixture Time
- Can be Moved In
- Operating Temp.
- Gap Filling
- Mixed Density
- Flash Point

Properties

15 to 18 minutes (at 75°F/ 24°C)
20 to 28 minutes (at 75°F/ 24°C)
40 minutes
-60°C to 82°C (-60° to 180° F)
0.25-0.32 inches
8.1 lbs/gal (.96 g/cc)
51°F (11°C) – See SDS for more safety information

3. CHEMICAL RESISTANCE:

Excellent Resistance to:

- Hydrocarbons
- Acids and Bases
- Vinegar

Susceptible to:

Polar Solvents
Super Strong Acids and Bases

4. PHYSICAL PROPERTIES:

Uncured:

• Viscosity(cps)	50,000 – 90,000	50,000 – 90,000
• Color	Translucent	Natural, Black, Gray
• Density (lbs/gal)	8.2	8.0
• Mix Ratio (wt or vol)	1.0	1.0
• Mixer Recommendation Cartridge (200/400ml):	MFQX 08-24T – Square 24 element White/Green Mix Tips (1:1)	

Resin

Activator

5. MECHANICAL PROPERTIES:

Tensile Strength, psi (ASTM D638)	3500-4000
Elongation@break, %	20-40
Hardness	80

Lap Shear Strength (ASTM D638)	Substrate	Results	Failure Type
• Strength, psi	Polyester	350+	Substrate
• Strength, psi	ABS/PVC Sheeting	1,000+	Substrate
• Strength, psi	Steel/Stainless Steel	3200+	Cohesive
• Strength, psi	Aluminum	2800+	Cohesive
• Strength, psi	PVC	1200+	Substrate

6. HANDLING AND APPLICATION:

CarbonBond Structural Acrylic Adhesive resin (Part A) and activator (Part B) are flammable. Contents include Methacrylate ester and acids. 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 the reach of children. Keep away from heat, sparks, and open flames. Do not smoke cigarettes or anything else while handling or near the product. Refer to the CarbonBond Structural Acrylic Adhesive Safety Data Sheet for more complete safety instruction. To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed. Components bonded, adhesive, and shop temperature can have a significant effect on the work and fixture time of the adhesive. Application of CarbonBond Structural Acrylic Adhesive at temperatures between 65°F and 85°F (18°C and 30°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure and fixture speed. CarbonBond Structural Acrylic Adhesive will still react, but will take longer. Temperatures above 85°F (18°C and 30°C) will increase cure and fixture speeds, and there's a risk that the adhesive will be hardened or too thick to bond materials. The viscosities of CarbonBond Structural Acrylic Adhesive are affected by temperature.

NOTE: Because of the curing features of CarbonBond Structural Acrylic Adhesives, large amounts of heat are generated when large masses of material are mixed at one time. The exothermic heat is generated from mixing large amounts of adhesive can result in a boiling of the monomer in the adhesive (methyl methacrylate), resulting in the release of trapped 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 the gap or spread out the material to no more than .50 inches.

7. HANDLING AND STORAGE

The shelf life of CarbonBond Structural Acrylic Adhesive is twelve (12) months from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of CarbonBond Structural Acrylic Adhesive in refrigerated compartments will extend the shelf life even more. Do not store CarbonBond Structural Acrylic Adhesive or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring CarbonBond Structural Acrylic Adhesive to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of CarbonBond Structural Acrylic Adhesive considerably. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. CarbonBond Structural Acrylic Adhesive contains no water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

8. ADDITIONAL INFORMATION

NOTE: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use or handling of its chemical products since conditions and use are beyond our control. In every case, we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own operating conditions. Statements concerning possible use of our products are not intended as recommendations to use our products in the infringement of any patent, or for any particular purpose or application. These products are intended for industrial use only.