

Bondmaster V1305 Toughened Acrylic Adhesive

Technical Information Sheet



Woodside Road, Eastleigh
Hampshire SO50 4EX
Tel: 023 8061 9822
Fax: 023 8065 2270

Description:

V1305 may be used for bonding components which need to withstand high stresses caused by differential thermal expansion, impact or peeling loads, especially when securing engineering materials such as composites and reinforced plastics. Benefits are that it cures rapidly at ambient temperatures, maximising efficiency and long jigging times are not required. The high strength is complimented by the excellent durability.

Physical Properties:

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Colour	Off white	Off white	Off white
Viscosity (mPa.s)			Thixotropic
Specific Gravity	1	1	1
Mix Ratio -By Volume	1:1		

Performance:

Shear Strength (MPa)	- Steel	21
	- Aluminium	22
	ABS	6*
Gap Fill (mm)	~2	
Peel Strength (N/25mm)	180	

Cure Speed:

<u>Handling Strength</u>	~5 mins.
<u>Working Strength</u>	10-15 mins.
<u>Full Strength</u>	8 hrs.

* denotes substrate failure

Service Temperature:

The recommended service temperature range for this product is -60 to +120°C. However higher temperatures may be endured for short periods providing the adhesive is not unduly stressed.

Storage :

When stored in the original unopened containers at 5-7°C, the shelf life of this product is 6 months from the date of despatch from Bondmaster.

Handling:

Full information can be obtained from the Material Safety Data Sheet (MSDS). Users are reminded that all materials, whether innocuous or not, should be handled according to the principles of good industrial hygiene.

Directions for Use:

1. Though this adhesive will bond through a degree of oil contamination ideally the surfaces should be clean, dry and grease free prior to bonding. Where optimum performance is required then light abrasion (i.e. Emery Cloth or Shot Blasting) is recommended. Surfaces can be degreased using **Permacleen II**.
2. The adhesive should be dispensed through a static mixer directly onto the components
3. Assemble the parts and squeeze together with sufficient pressure to ensure the adhesive spreads to cover the entire bond area. Apply light clamping pressure and do not disturb, or realign the joint, whilst the adhesive cures.

22/04/04.

The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions.