

E360 PLAST WELD

1 - Description

Plast Weld Adhesive represents a two-component structural bonding adhesive formulated with Methyl methacrylate. Tailored for robust structural bonding applications involving composites, metals, and thermoplastics, Methyl Methacrylate Adhesive comes in various color options such as natural, white, black, and grey.

Methyl Methacrylate Adhesive offers impressive chemical resistance, effectively withstanding hydrocarbon solvents as well as acids and bases within the 3-10 pH range.

2 - Fields of Application

It is suitable for use with a diverse range of substrate materials, covering a wide variety of options such as:

- Vinyl
- PVC
- Polycarbonates
- Aluminum
- Carbon fibre
- Stainless steel
- ABS
- Acrylics
- Styrenics
- Gelcoats
- FRP (fibre reinforced plastics)
- Polyesters
- Urethanes

3 - Product Information

Packaging 50 ml cartridges

Shelf Life (Part A) 9 months, (Part B) 9 months

Storage Conditions Store in cool and dry conditions at between 12°C and 23°C.

4 - Technical Data

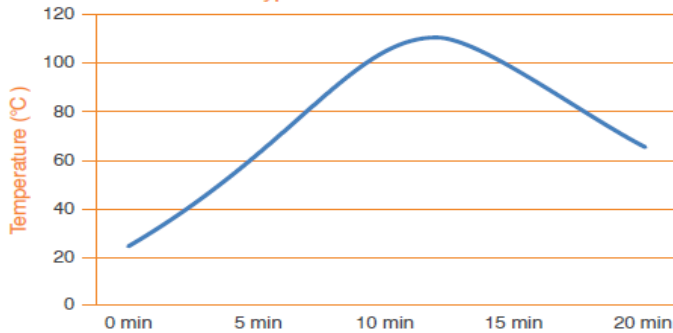
Physical Properties at 25°C;

	Part A	Part B
Mix Ratio	1	1
Density (g/cm³)	0,97	0,97
Viscosity (cP)	120,000 - 160,000	150,000 - 200,000

	Value
Working Time	4 – 6 minutes
Operating Temperature	-50°C to +120°C
Gap Filling Capability	1 mm – 4 mm
Flash Point	11°C
Mixed Density	0,97

Bonding Performance at 25°C;

	Duration
Tensile Strength (MPa)	20 – 25
Tensile Modulus (MPa)	1500 – 1600
Elongation (%)	5 – 10
Lap Shear Strength (MPa)	20 – 25

Typical Cure Performance;**5 - Directions for Use**

- A. **Surface preparation:** To achieve the best results, it is recommended to thoroughly clean surfaces by removing excessive grease, oil, or other contaminants through solvent wiping or industrial cleaning methods like vapor phase degreasers or hot aqueous baths. Enhancing the microscopic bond area through abrasion or roughening of metal surfaces will significantly improve bond strength.
- B. **Application:** Apply the blended adhesive directly onto one of the surfaces intended for bonding. To ensure optimal bond strength, the surfaces must be joined within the designated time frame. All adhesive application, part positioning, and fixturing should be completed before the specified assembly time for the mixture elapses.
- C. **Dispensing:** Methyl Methacrylate Adhesive can be applied either manually or with automated equipment. Premeasured cartridges and handheld guns are accessible for manual dispensing. For automated application, a range of 1:1 mix equipment is available, delivering both components to a static mixer.
- D. **Cleaning:** It is advisable to perform cleanup before the adhesive fully cures. If the adhesive has cured, gently scrape it off and wipe the area with a solvent. Spills should be cleaned up using an absorbent material and disposed of in accordance with flammable material guidelines.

6 - Remarks & Restrictions

- Cure speed will decrease at temperatures below 18°C and accelerate above 26°C.
- The adhesive's viscosities are temperature-sensitive, so automated filling or dispensing systems should ensure consistent temperatures year-round.
- Long term storage above 23°C will reduce the shelf life.
- Avoid temperatures above 35°C at all times.
- This product should never be frozen.
- Keep containers closed after use.
- 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

7 - Safety

Ensure good ventilation of the work station. Wear personal protective equipment. Do not eat, drink or smoke when using this product. Always wash hands after handling the product. Store in a well-ventilated place. Keep cool. Check MSDS guidelines for disposal and further information concerning safety.

8 - Disclaimer

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.