ADHESIVE® R&D

BLUE OX™ SA 260

STRUCTURAL ACRYLIC

BLUE OX™ SA 260

BLUE OX™ SA 260 is an Anaerobic Structural Acrylic based on modified Urethane Acrylic technology for bonding of rigid parts such as Ferrite to Metals in loudspeakers, magnets, discs, electric motors etc. Typical applications are where tough, shock resistant bonds of high production speeds are necessary. Magnet bonding as described in above applications are typical of its usefulness.

BLUE OX™ SA 260 is used with our special Activator to speed cure. Use AC260 with SA 260 for metal, glass, ceramic and ferrite bonding, including plated metals.The matched activator AC260 gives the fastest bonds on all materials. Accelerated cure is achieved without Activator at 120°C for 30-60 minutes.

PHYSICAL PROPERTIES

Resin	Urethane Acrylate
Color	Clear-Amber
Cure Speed With Activator	<1 minute
Cure Speed Without Activator	<10 minutes (Anaerobic)
Viscosity	6,000 - 10,000 cps
Gap Fill	0.05mm preferred
Flash Point	>100°C
Shelf Life	12 months @ 20°C
Specific Gravity	1.06 (modified)+-
Max Operating Temperature	+120°C

CURE SCHEDULE

Full Cure Time	24 hours
Static Shear Strength	10-25 N/mm(2)

PROPERTIES

Typical Gap Design	0.1mm
Maximum Gap design	0.5mm
Tensile Strength	Up to 25 N/mm(2)
Max. Temp at 60% Retained Strength	85°C
Max. Temp at 100% Retained Strength	60°C

GAP SIZE/CURE RATE RATIO

Minimum 0.05mm	
Fix	<2 minutes
Full Cure	<6 hours
Medium 0.25mm	
Fix	<15 minutes
Full Cure	<16 hours
Maximum 0.5mm	
Fix	<2 hours
Full Cure	<36 hours

GAP SIZE/STRENGTH RATIO

Minimum Gap	100% Strength
Medium Gap	>65% Strength
Maximum Gap	>45% Strength

Rev 01/03