

ADHESIVE



M300

Two Part Methacrylate

DESCRIPTION:

M300 is a high performance two part methacrylate adhesive engineered to bond a wide range of plastics, metals, and composite assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. *M300* greatly increases the reliability of finished assemblies with exceptional flexibility, it's ability to with stand extreme temperature fluctuation and thermal cycling, and resistance to a wide range of chemicals and environmental conditions.

PHYSICAL PROPERTIES (UNCURED):

VISCOSITY @ 25°C (cps): RESIN 100,000

ACTIVATOR 50,000

COLOR: Black or Blue

MIXED DENSITY: 8.00

MIX RATIO: VOLUME 10 TO 1

WEIGHT 10 TO 1

THIX INDEX: 5

FLASH POINT: 51°F

PHYSICAL PROPERTIES (CURED):

STRENGTH (PSI): SHEAR 1900-2400

WORK TIME: 4-6 MINUTES

HANDLING STRENGTH: 15-18 MINUTES

GAP FILL: .375 INCHES

TEMPERATURE RANGE: -67°F - +180°F

Bonding Applications

METALS

*ALUMINUM

*STEEL

*STAINLESS

*COATED METALS

THERMO SETS

*FIBERGLASS

*PHENOLICS

*GEL COATS

*EPOXY

*RIM URETHANE

*POLYURETHANE

*LIQUID MOLDING RESINS

THERMO PLASTICS

*ACRYLICS

- *ABS
- *POLYCARBONATES
- *NYLONS
- *PPO's
- *VINYL'S
- *PVC's
- *STYRENE'S
- *PEEK's
- *PBT BLENDS
- *PET BLENDS

STORAGE AND SHELF LIFE:

The shelf life of the *M300* Series is six month from date of shipment. Shelf life is based on the products being stored properly at temperatures between 55° F and 75° F. Exposure to temperatures above 75° F will reduce the shelf life of these materials. These products should **NEVER BE FROZEN**.

PRECAUTIONS:

M300 is *flammable*. Keep away from heat, spark, and open flames.

KEEP OUT OF REACH OF CHILDREN. THE PRODUCT IS FOR INDUSTRIAL USE ONLY. Keep containers closed when not in use. Avoid contact with skin and eyes. Harmful if swallowed. Refer to Material Safety Data Sheet for complete safety information.

HANDLING AND CLEAN-UP:

For optimum bond strength and to insure maximum performance in the finished assembly mate parts together within the specified work time of the adhesive. Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work times for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the fixture time is reached. Clean up is best before the adhesive has cured. Cleaners containing NMP (N-methyl pyrrolidone) or Citrus terpene provide the best results. On cured adhesive repeat use may be required.

DISCLAIMER

The data contained within this Technical Data Sheet are furnished for information only and are believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the user to determine the products suitability for use. Adhesive R&D and its distributors and agents accept no liability arising out of the use of this information or the products described herein.

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