

Technical Data Sheet

Page 1 of 2

Properties:

AKEMI® MMA Adhesive is a high strength, fast curing 2-component methacrylate adhesive for structural bonding of metals, plastics and composites. Most metals, including steel and aluminium, can be bonded without surface pre-treatment.

The product is characterized by the following qualities:

- high impact strength
- high shear strength
- excellent chemical resistance
- excellent environmental resistance

Application Area:

Ideal for use on structural joining of metals (including aluminium, stainless steel), composite bonding, plastics, (including ABS, acrylics, vinyl, PVC, polycarbonates), epoxy laminates, gel coats and ceramics where high impact strength is needed.

Typical uses are for joining:

- side panels
- vehicle roofs
- automotive spoilers
- fiberglass
- ventilation shafts
- construction parts
- housings
- solar panels
- billboards and scoreboards

Instructions for Use:

1. Prepare surface by removing dust, loose scale, rust and other surface residue including oil and grease.
2. For maximum bond strength on joining partners, abrade surface (P80 - P180) prior to bonding, then wipe clean.
3. Insert MMA Adhesive into 50 ml 1:1 applicator gun.
4. Balance A + B part.
5. Attach static mixer nozzle.
6. Extrude first 20 mm of MMA Adhesive and discard to ensure a proper mix has been achieved in the nozzle.
7. Apply MMA Adhesive to one surface only, press parts together with finger pressure only.

Special Notes:

- For professional use only.
- For proper waste disposal, the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Base:	methyl methacrylate
Colour:	black
Density:	approx. 0.97 g/cm ³
Working time:	4 - 6 minutes
Fixture time:	12 - 15 minutes
Working temperature:	18 - 25°C
Optimum bonding layer thickness:	0.6 - 0.8 mm
Lap shear strength:	20 - 25 MPa (ASTM D 1002)
Temperature resistance:	-50°C up to +120°C

TDS 12.25

Technical Data Sheet

Page 2 of 2

Storage:	If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production.
Health & Safety:	Read Safety Data Sheet before handling or using this product.
Important Notice:	The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.