

DanBond A21 is a high strength, rapid curing, methyl methacrylate, structural adhesive, which gives a tough durable bond with plastics, metals and other materials. It is isocyanate-, phthalates-, solvent-, PVC- and silicone free.

APPLICATIONS:

- Automotive
- Marine
- Construction and assembly industries
- Bonding of PVC, Acrylic, PC, PBTO, PU, Stainless Steel, Gel Coats, ABS, Styrene, Epoxy etc.

FEATURES:

- Does not attack surfaces
- Room temperature cured with short open time
- Over paintable
- Very good UV-resistance and excellent ageing properties
- Gap filling up to 5 mm.
- Non sagging thixotropic formulation
- Excellent impact, peel and shear strength

TECHNICAL DATA:**Nominal Components Properties:**

	Komp. A	Komp. B
Chemical base	Methyl methacrylate	Methyl methacrylate
Colour	Off white	Off white
Specific Gravity [g/cm³]	1,00	1,00
Viscosity [mPas]	60.000	40.000

Typical Cure Characteristics:

Open time	@ 23° C [min]	6
Curing time	@ 23° C [min]	20
Complete cure	@ 23° C [hours]	24

Temperatures higher or lower than 23°C will have influence on the open time and curing time.

Typical properties of Cured Adhesive:

Shore D Hardness	EN ISO 868 @ 23° C	63
Tensile Strength	ASTM D638 @ 23° C [MPa]	24
Young's Modulus	ASTM D638 @ 23° C [MPa]	1800
Elongation at Break	ASTM D638 @ 23° C [%]	33

ADHESION:

DanBond A21 has excellent primer-less adhesion properties to metals, painted surfaces, aluminium PVC, glass fibre reinforced plastic, ABS, polycarbonate and plastic materials. DanBond A21 can be over-painted with most types of lacquers.

Note! In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.

APPLICATION CONDITIONS:

Application temperature	Between 15°C and 25°C
Substrate	The surfaces to be bonded should be clean, dry and free from dust and grease
Application method	Manual and pneumatic guns
Mixing ratio	1:1
Mixing	Connect the mixertip to the cartridge and press out 2 cm. (do not use) to be sure that you have a 100% mixture of the 2 components
Assembling	After applying the adhesive, assemble the parts (within open time) and immediately clamp or press

SAFETY NOTE:

Please observe the information provided with the Material Safety Data Sheet.

MSDSs are provided to you under Danlube A/S policy of communicating to our customer health, safety and environmental information for safe handling, use and disposal of our products. This information must be made available to health and safety personnel within your organization and to all employees who come in contact with these products.

STORAGE: Unopened containers stored at a dry place indoors between 5°C and 25°C

SHELF LIFE: 9 Months in the originally sealed cartridge

PACKAGING: DanBond A21 is packed either in 50ml. (25ml by 25ml) or 400ml. (200ml by 200ml) side-by-side cartridges for use with a hand-held dispensing tool