

DanBond A22

Methacrylate Structural Adhesive

Danbond A22 is a two component toughened acrylic adhesive system supplied in ready to use cartridges. It is designed for structural bonding of thermoplastic, metal, and composite assemblies and combines high strength and stiffness along with the ability to bond a wide range of different materials. It is ideal for bonding dissimilar materials where differential thermal expansion and contraction could be an issue.

FEATURES:

- Excellent ratio working time / cure time
- Toughened
- Multi-purpose
- Gap filling to 4mm

APPLICATIONS:

- Ideal for bonding all types of PVC, Polycarbonate, Acrylic, Fiberglass, PBT, PPO, ABS, FRT, Polyurethane, Epoxy, Wood, RIM, Nylon, FRP, Polyesters, Styrene, Stainless Steel, Galvanized Steel, etc.
- Ideal for Automotive Components, Sporting goods, Electronics Enclosure Parts, Fiberglass Tanks & Fittings, Appliances, Construction, Furniture, Marine assemblies, Plastic Fabrications, Sign & Display, etc.

PROPERTIES OF UN CURED ADHESIVE

Properties	Comp. A	Comp. B	Mixed adhesive
Colour (visual)	Off white	Yellow	Pale yellow
Specific gravity	1.02	0.96	ca. 1
Viscosity at 25°C (A191) (Pa.s)*	15 - 50	10 - 50	thixotropic
Pot Life (100 gr at 25°C)	-	-	ca. 10 minutes
Time to peak exotherm (20gr) (A159)*	-	-	15 – 30 minutes

Pretreatment

The strength and durability of a bonded joint are dependent on proper pretreatment of the surfaces to be bonded, however the methacrylate adhesives can be used effectively with little surface preparation. Ideally joint surfaces should be cleaned with a good degreasing agent such as acetone, iso-propanol (for plastics) or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Low grade alcohol, gasoline (petrol) or paint thinners should never be used. The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces.

Mix ratio	Parts by weight	Parts by volume
A22 Comp. A	100	100
A22 Comp. B	100	100

Typical times to minimum shear strength

Temperature	°C	10	15	23	40
Cure time to reach	hours	-	-	-	-
LSS > 1MPa	minutes	30	17	12	6
Cure time to reach	hours	-	-	-	-
LSS > 10MPa	Minutes	40	25	17	10

DanBond A22 is available in 50 ml Cartridges

HANDLING PRECAUTIONS

Please refer to the relevant SDS (Safety Data Sheet) regarding the safe handling of this material.

Note: *All materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.*

Further technical support or information may be obtained from

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