

Product Description

Bondchem M105 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications in the automotive industry. M105 has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the M105 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use.

Typical Applications

Bondchem M105 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners. Typical examples shown below:

- Bonding metal fasteners to moulded composite parts
- Bonding hinge assemblies to GRP bonnets.
- Bonding automotive carbon fibre body panels
- Bonding and repairing plastic bumpers and trims.
- Repairing aluminium sumps.
- Bonding and repairing headlight brackets.

Instructions For Use

1. Always consult MSDS before using M105 for the first time.
2. Carry out surface preparation where required. *
3. Remove cap, and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner *
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components

**Contact your Bondchem representative for full information and usage instructions.*

Properties of Uncured Material

| | |
|------------------------------------|-----------------------|
| Resin | Methyl Methacrylate |
| Colour | Black or Standard |
| Appearance | Thixotropic Gel |
| Viscosity Brookfield Sp7 @ 2.5 rpm | 450,000 to 550,000cps |
| Cure System | Exothermic |
| Open Time | 2-3 Minutes @ 20°C |
| Handling Strength | 5-7 Minutes@ 20°C |

Performance of Cured Material

| | |
|----------------------------|---------------------------|
| ASTM D1002 Lapshear | Up to 30 Nmm ² |
| ASTM D638 Tensile Strength | Up to 30 Nmm ² |
| Gap Fill | 5mm |
| Temperature Range | -55°C to 120°C |

Packaging

Bondchem M105 is available in 50ml and 400ml Nylon cartridges for use with a dispensing gun. M105 is also available in 20 litre pails and 200 litre drums, for use with our BC1 dispensing system.

Storage & Shelflife

Bondchem M105 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.

Health and Safety in Use

Bondchem M105 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.