

### Product Description

Bondchem M110 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications in the automotive industry. M110 has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the M110 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use.

### Typical Applications

Bondchem M110 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 and repairing caravan GRP body panels
- Bonding and repairing plastic bumpers and trims.
- Bonding deck fittings and molded parts in the marine industry.

### Instructions For Use

1. Always consult MSDS before using M110 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.

*\*(See Bonchem guide to bonding for full information and in depth usage instructions)*

### Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Yellow/ White
Appearance	Thixotropic Gel
Viscosity Brookfield T Bar	120,000 to 150,000cps
Cure System	Exothermic
Open Time	12-15 Minutes @ 20°C
Handling Strength	20-25 Minutes @ 20°C

### Performance of Cured Material

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

### Packaging

Bondchem M110 is available in 50ml and 400ml Nylon cartridges for use with a dispensing gun. M110 is also available in 20 litre pails and 200 litre drums, for use with our BC1 dispensing system.

### Storage & Shelflife

Bondchem M110 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 M110 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.