Bondchem

Technical Datasheet M110

Product Description

Bondchem M110 is a two component structural methacylate 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

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 suface and assemble components carefully, clamping if required.
- 6. It is always easier to remove any excess adhesive prior

· Bonding deck fittings and molded parts in the marine industry.

to cure using a suitable cleaner *

· Bonding and repairing plastic bumpers and trims.

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 ²
ASTM D638 Tensile Strength	Up to 30 Nmm ²
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.

The data, information and values contained in this Technical Data Sheet has been obtained by conducting various tests in a controlled laboratory environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the users sole responsibility to determine the suitability of the product for the application. Bondchem Ltd cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warrantees or implied usage obligations should not be attributed to, and are not the responsibility of, Bondchem Ltd. Bondchem Ltd are not reliable for any financial loss or other damages incurred by the user as a result of the use of this product.

