

Product Description

Bondchem M145 is a two component fast curing structural acrylic adhesive. This grade is used for bonding high strength applications that require a combination of environmental, peel, fatigue and impact resistance. M145 has been formulated from well established rubber based technology ensuring the optimum balance of structural integrity whilst allowing adhesion to a very wide variety of substrates.

Typical Applications

Bondchem M145 is very versatile, and can bond a wide variety of substrates.

- Bonding stair nosing to metal and fiberglass.
- Bonding GRP in the marine industry
- Bonding magnets to motor housings.

Instructions For Use

1. Always consult MSDS before using M145 for the first time.
2. Carry out surface preparation where required. *
3. Apply the activator to one surface.
4. Apply adhesive to the mating surface and assemble components carefully, clamping if required.
5. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner *
6. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

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

Properties of Uncured Material

Resin	Methacrylate
Colour	Off White
Appearance	Thixotropic Gel
Viscosity Brookfield T Bar	50,000cps
Cure System	Exothermic
Activator 1	
Handling Strength	30 Seconds @230C
Full Strength	24 Hours
Activator 2	
Handling Strength	30 – 60 Seconds @230C
Full Strength	24 Hours
Activator 3	
Handling Strength	4-5 Minutes @230C
Full Strength	24 Hours

Performance of Cured Material

ASTM D1002 Lapshear Steel	Up to 30 Nmm ²
Gap Fill	0.75 mm
Temperature Range	-60°C to 1200C

Packaging

Bondchem M145 is available in 50ml and 310ml Nylon tubes for use with a dispensing gun.

Storage & Shelflife

Bondchem M145 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 M145 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.