

Product Description

Bondchem M146 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. **M146** 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 M146 is very versatile, and can bond a wide variety of substrates.

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

Instructions For Use

1. Always consult MSDS before using **M146** 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.

**(Contact Bondchem technical manager for full information and in depth usage instructions)*

Properties of Uncured Material

Resin	Methacrylate
Colour	Amber
Appearance	Thixotropic Gel
Viscosity Brookfield Sp7 @ 20 rpm	100,000 - 120,000 cps

Performance of Cured Material

ASTM D1002 Lapshear Steel	Up to 30 Nmm ²
Gap Fill	0.75 mm
Temperature Range	-60°C to 120°C

Cure System	Exothermic
Activator 1	
Handling Strength	30 Seconds @ 23°C
Full Strength	24 Hours
Activator 2	
Handling Strength	30-60 Seconds @ 23°C
Full Strength	24 Hours
Activator 3	
Handling Strength	4-5 Minutes @ 23°C
Full Strength	24 Hours

Packaging

Bondchem M146 is available in 50ml and 310ml Nylon tubes for use with a dispensing gun

Storage & Shelflife

Bondchem M146 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 M146 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.