

### Product Description

**Bondchem M312** is a single component structural acrylic adhesive designed to bond cast acrylic sheet with a bond strength that should always outperform the substrate. This ultra high strength is achieved by using a bespoke blend of advanced acrylic polymers which when combined with our non Dichloromethane cure system provides a fast bond speed with ultra high clarity.

### Advantages and Benefits

Following the growing concern regarding the possible carcinogenic effects of Dichloromethane, we have developed a system using an alternate derived from renewable resources (very low environmental impact). This alternate is very safe to use and brings a number of marked improvements to the adhesive system including:

- A faster cure speed and handling strength.
- Improved optical clarity with no amber or blue tint to the cured material.
- A safer to use structural adhesive.

### Instructions For Use

1. Always consult MSDS before using **M312** for the first time.
2. Carry out surface preparation where required on the cast acrylic sheet.\*
3. Dispense a line of adhesive and quickly assemble the parts to minimise solvent evaporation.
4. 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	Transparent
Appearance	Clear liquid
Viscosity Brookfield Sp 2 @ 20 rpm	550 cps
Handling strength	3 hours @ 20°C
Joint machine time	24 Hours

### Performance of Cured Material

ASTM D1002 Lapshear Acrylic	Substrate Failure
Gap Fill	0.15 – 0.6mm
Temperature Range	-55°C to 120°C

### Packaging

**Bondchem M312** is available in 500ml Aluminium Flasks.

### Storage & Shelflife

**Bondchem M312** 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 M312 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.