

Product Description

Bondchem M370 is a two 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 taint to the cured material.
- A safer to use structural adhesive.

Instructions For Use

1. Always consult MSDS before using **M370** for the first time.
2. Carry out surface preparation where required. *
3. Mix by weight Part A and B at the 20:1 ratio taking care to induce as little air as possible to the mixture.
4. Cover container and allow any entrapped air to raise to the surface.
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	Methyl Methacrylate
Colour	Transparent
Appearance	Clear liquid
Viscosity Brookfield Sp2 @ 20 rpm	1,000-3,000 cps
Cure System	Exothermic
Open Time (20:1 Mix)	30 Minutes @ 20°C
Handling Strength (20:1 Mix)	60 Minutes @ 20°C
Open Time (10:1 Mix)	20 Minutes @ 20°C
Handling Strength (10:1 Mix)	45 Minutes @ 20°C
Open Time (5:1 Mix)	15 Minutes @ 20°C
Handling Strength (5:1 Mix)	30 Minutes @ 20°C

Performance of Cured Material

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

Packaging

Bondchem M370 is available in 500ml Aluminium Flasks, with 20g Activator bottles.

Storage & Shelflife

Bondchem M370 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 M370 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