

AllWeld 530 - 7 Minute

DESCRIPTION

Sylmasta methacrylate adhesives are designed to adhere to hard-to-bond engineered plastics, advanced composites, exotic metals and other difficult substrates. They produce tough, flexible adhesive bonds with little or no surface preparation and cure rapidly at room temperature to provide exceptional shear and peel strengths and environmental resistance.

AllWeld 530 - 7 Minute is a rapid-setting, tough, structural gel for high strength load bearing bonds to engineered plastics, metal, ceramics and many other materials.

Applications

- High strength bonds to load bearing metals, plastic, wood, composites etc.
- Glueing hard-to-bond plastics
- Bonding metal fasteners to moulded composite parts
- Bonding automotive carbon fibre body panels
- Bonding GRP in the marine industry
- Bonding dissimilar metals for trailer fabrication

Advantages

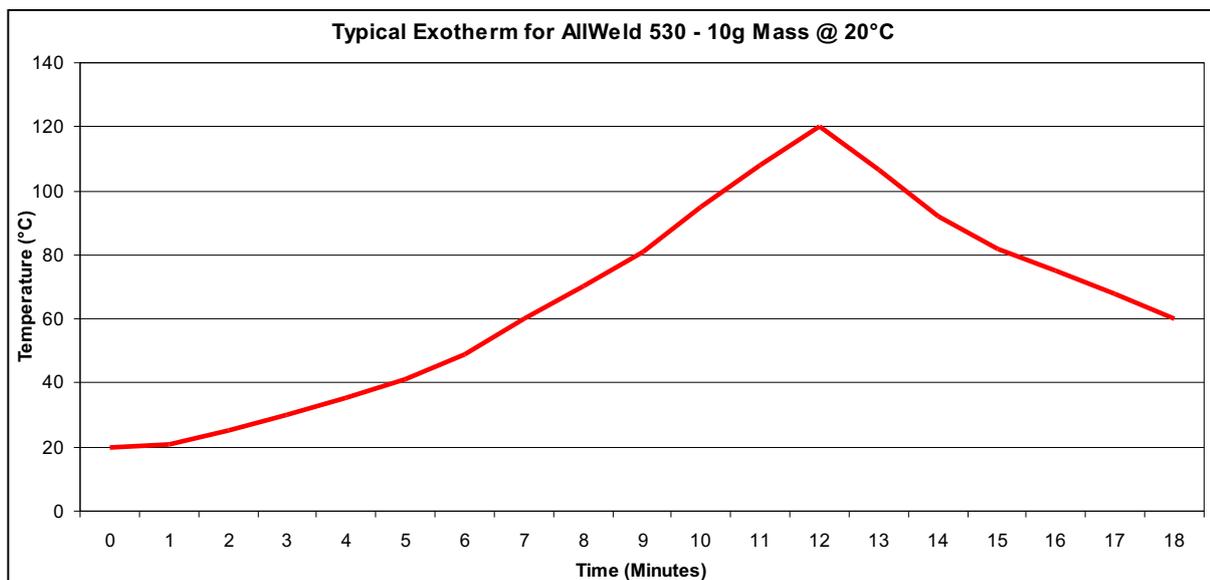
- Handling strength in 12 minutes
- High adhesive and impact strength
- Excellent chemical resistance
- Minimal surface preparation
- Weather and moisture resistant

INSTRUCTIONS

- Always consult safety data sheet before using AllWeld for the first time.
- Carry out surface preparation where required.
- Remove cap, and attach mixer nozzle.
- Dispense sufficient adhesive to ensure equal mix.
- Apply adhesive to one surface and assemble components carefully, clamping if required.
- It is always easier to remove any excess adhesive prior to cure using a suitable cleaner
- Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

Curing Cycle

Once mixed at the 1:1 ratio the working time of AllWeld is the period whereby the adhesive remains fluid and is easily transferrable between two or more mating surfaces. Temperature, volume and substrate have a direct effect on the length of this period as AllWeld cures by an exothermic reaction. Higher temperatures and larger volumes speed the reaction causing a reduction in open and cure time. Lower temperatures and smaller volumes slow the reaction time extending both the open time and ultimate full cure time.



TECHNICAL DATA SHEET

TECHNICAL DATA

Colour	Off-White
Appearance	Thixotropic Gel
Working Time (@20°C 10g Mass)	7 Minutes
Handling Strength (@20°C 10g Mass)	12 Minutes
ASTM D1002 Lapshear	(Average over 16 tests)
Aluminum	20.4 Nmm ²
Stainless Steel	38.4 Nmm ²
Mild Steel	32.8 Nmm ²
GRP	Substrate Failure
ABS	Substrate Failure
Acrylic	Substrate Failure
ASTM D638 Tensile Strength	Up to 30 Nmm ²
Gap Fill	4mm
Standard Temperature Range	-55°C to 120°C
Paint Bake Cycle Approval*	20 Minutes @ 220°C
Aluminum lapshear following moist cataplastm	
7 days @ 70°C	26.7 MPa
Peel Strength Aluminium	6 KN/m
Shore Hardness	75 Shore D

*Temperature resistance relates directly to bond size, thickness of adhesive and subjected load.

COMPATIBLE SUBSTRATES

Aluminum	Vinyl Esters
Wood	ABS
Stainless Steel	Galv/Zinc Coated
Granite	Acrylic
Mild Steel	Thermoset Plastics
Marble	FRP
UPVC	Gelcoats
Urethanes	GRP
Polyesters	Epoxy laminate

TYPICAL CHEMICAL RESISTANCE

Acetic (Dilute) 10%	Excellent
Ammonia	Very Good
Cutting Oil	Excellent
Glycols/Antifreeze	Excellent
Hydrochloric 10%	Fair
Mineral Spirits	Excellent
Motor Oil	Excellent
Sodium Hydroxide 10%	Very Good

STORAGE

AllWeld should be stored unopened in suitable hazardous storage conditions for flammable adhesives that are in a cool, dry location and out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from its manufacture in the UK (6 months for 25ml syringe)..

PACKAGING

Code	Description
MMA530/25ml	25ml Syringe
MMA530/50ml	50ml Cartridge
MMA530/250ml	250ml Cartridge
MMA530/400ml	400ml Cartridge

HEALTH & SAFETY

AllWeld is a methyl methacrylate and should not be used without consulting the SDS 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.