



Sales Technology Inc

Condition Monitoring Custom Products
"Proactive Technologies for Reliability Improvement"

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Condition Monitoring Custom Products

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CMCP210 Acrylic Adhesive Bypacs

Description

CMCP210 acrylic adhesive bonds a wide variety of prepared or unprepared metals and engineered plastics. CMCP210 adhesive is specifically formulated to provide the highest impact and peel strengths available in a room temperature curing adhesive. CMCP210 adhesive replaces welding, brazing, riveting and other mechanical fastening methods especially in low temperature environments subject to high impact or high peel loads.

Features and Benefits

- **Non-Sag** - remains non-sag when applied on vertical surfaces.
- **Exceptional Cold Temperature Strength** - performs at temperatures from -40°C to 149°C (-40°F to 300°F).
- **Bonds Unprepared Metal** - requires little or no substrate preparation.
- **Bonds Plastic** - bonds difficult plastics such as polycarbonate and XENOY®.
- **Excellent Environmental Resistance** - resists dilute acids, alkalis, solvents, greases, oils, moisture, and weathering. This adhesive also provides excellent UV exposure resistance.

Specifications

	Acrylic Adhesive	Accelerator
Appearance	Off-White to Tan	Off-White
Viscosity, cps Brookfield at 25°C	100,000 - 300,000	10,000 - 100,000
Density		
Kgs/m3	1097 - 1162	1150 - 1246
lbs/gal	9.1 - 9.7	9.6 - 10.4
Flash Point	15°C (59°F)	>93°C (>200°F)
Mix Ratio		
By weight	10	1
By volume	10	1
Working Time @ 24°C (75°F)	6 - 10 minutes	N/A
Handleable Bonds @ 24°C (75°F)	12 - 17 minutes	N/A
Shelf Life from date of shipment, @ 24°C (75°F), unopened container	6 Months	6 Months

Instructions

Surface Preparation

Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for best performance.

Mixing

Hand mix or apply with automatic meter/mix/dispense equipment. Mix resin with the proper amount of accelerator. Once mixed, the acrylic adhesive cures rapidly.

Application

Apply to substrates and join.

Curing

The cure is completed in 24 hours at room temperature. The cure rate can be accelerated by applying modest heat. The surfaces need to be held in contact during the entire cure period. If heat cured, do not exceed temperatures of 66°C, 150°F.

Clean Up

Uncured Adhesive - Clean excess adhesive on the bonded assembly, as well as mixing and application equipment, before the adhesive cures. Use hot water and detergent, or an organic solvent.

Cured Adhesive - Heat the cured adhesive to 204°C (400°F) or above to soften the adhesive.

Ordering Information

CMCP210	Acrylic Adhesive Bypac
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Your STI Representative: