

TECHNICAL DATA SHEET

My-T-Bond® 1151

Acrylic Adhesive

November 2018



METLOK PRIVATE LIMITED
(An ISO 9001 Certified Company)
W-27, M.I.D.C. Industrial Area
Kalmeshwar – 441 501, Nagpur

Product Description

My-T-Bond® 1151 (A & B) is a two component solvent free reactive acrylic structural adhesive for bonding of metals and plastics. Bonds produced with My-T-Bond® 1151 possess high structural strength and high impact resistance. In many cases, a particular surface preparation of the parts to be bonded is not necessary or can be reduced to a minimum.

Benefits

- ❖ Short pot life
- ❖ Fast setting, rapid fixing and handling
- ❖ Excellent bonding
- ❖ Cold-curing
- ❖ High strength
- ❖ Good gap-filling properties
- ❖ Good heat and chemical resistance
- ❖ Minimal surface preparation

Applications

- ❖ Applicable for bonding metals such as steel, aluminium, copper and their alloys, ferrites.
- ❖ Plastics such as ABS, polystyrene, rigid PVC, polycarbonate, polyphenylene oxide, molded polyester parts, hard paper, and others.
- ❖ Materials on a cellulose and wood basis such as loudspeaker membranes and chip boards.

Properties

Technology	:	Acrylic
Chemical type	:	Methacrylate
Appearance (Polymer)		
Polymer	:	Light Green
Component A	:	Light Green
Component B	:	White
Specific Gravity at 25±2 °C		
Part A	:	1.0
Part B	:	1.0
Mixing ratio	:	1:1
Viscosity @ 25±2 °C, Brookfield, Spindle no. 7 , Speed 20 r.p.m.		
Component A	:	90000 - 130000 cP
Component B	:	50000 - 70000 cP
Cure	:	Room Temperature

Service Temperature : -50 to 150 °C

Cure Properties

Properties measured at 25±2 °C

Pot life - 10 gm : 8 - 10 minutes
Total Cure : 24 hours

Adhesive Properties of Cured Material

After 24 hrs @ 25±2 °C

Tensile Strength, ASTM D 897

MS to MS : ≥30 N/mm²

Lap Shear Strength, ASTM D 1002

MS to MS : ≥25 N/mm²

Impact Strength, ASTM D950

MS to MS : ≥30
N-mm/mm²

Peel Strength, ASTM D1876

MS to MS (0.56 mm) : ≥ 6 N/mm

*Cold Rolled Sheet

AL to AL(0.8 mm) : ≥ 3 N/mm

SS to SS (0.4 mm) : ≥ 3 N/mm

Hardness, Durometer Shore : 80 ±3
D, ASTM D2240

Application Information

1. All surfaces should be clean and free of contaminants. If necessary, clean surfaces with solvent.
2. Apply the adhesive to the more difficult-to-bond surface. In general, hard, smooth surfaces are more difficult to bond than rough, porous surfaces.
3. "Set-time" varies depending on application temperature, amount of adhesive applied, type of substrate and ambient temperature conditions.
4. Mate the surfaces to be bonded as quickly as possible after adhesive has been applied for optimum bond strength.
5. Use firmest pressure practical for object being bonded. Do not move or adjust surfaces after contact has been made, as inferior bond strength will result.

6. Typically, a properly formed Acrylic adhesive bond will achieve 50% of its strength after 15 minute, 75% after 6 hour, and 100% after 24 hours.

Storage and Handling

My-T-Bond® 1151 (A & B) shall be ideally stored in a cool, dry location at 25±2°C.

Shelf Life : 6 months @ 25±2°C

Note

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(Bonding and Sealing Solutions)

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