

TECHNICAL DATA SHEET
My-T-Bond® 624
 Structural Acrylic Adhesive
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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® 624 is a high impact strength structural single component adhesive. My-T-Bond® 624 cures when confined between close fitting parts with the aid of an activator. My-T-Bond® 624 has high toughness and impact strength.

Applications

My-T-Bond® 624 is used to bond flat parts together. Suitable for joining dissimilar materials e.g. ferrite to plated materials in electric motors, loudspeakers, etc.

Properties

Technology	:	Acrylic
Chemical type	:	Urethane Methacrylate ester
Component	:	Single
Appearance	:	Transparent amber Liquid
Sp. Gravity @ 25±2 °C	:	1.05
Viscosity @25 ±2°C,	:	13000-24000 cP
Brookfield DV II + Pro, Spindle no 6, Speed 20 rpm		
Cure	:	Anaerobic with activator
Service Temperature	:	Upto 150 °C
Application	:	Bonding

Curing Performance

My-T-Bond® 624 will only cure when it is exposed to Activator® 1006 applied surfaces. The rate of cure will depend on substrate used. Cure rate and ultimate depth of cure depend on exposure time, bond-line gap, geometry and the substrate used.

Adhesive Properties of Cured Material

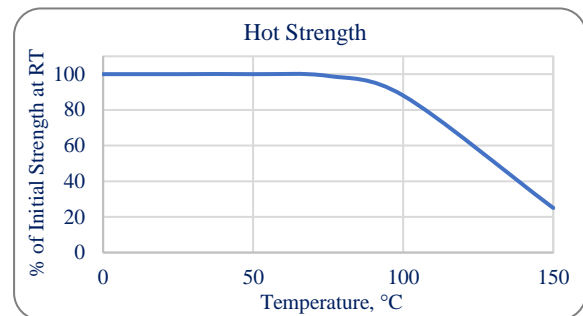
Cured for 24 hours @ 25±2 °C, Activator® 1006 on 1 side

Lap Shear Strength, ASTM D 1002	
Steel	: 20-35 N/mm ²
Tensile Strength, ASTM D 897	
Steel	: 17-30 N/mm ²

Hot Strength

Test	:	Lap Shear Strength, ASTM D1002
Substrate	:	Steel
Cure	:	24 hrs @ 25±2 °C

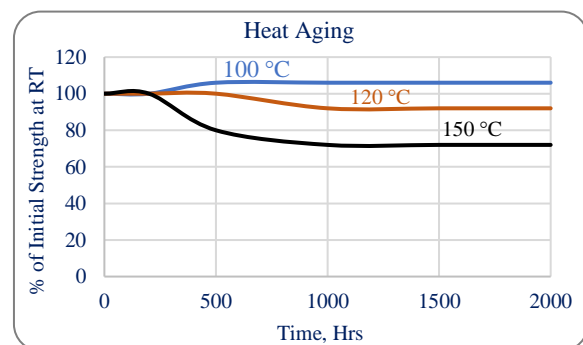
Tested at temperature indicated



Heat Aging

Test	:	Lap Shear Strength, ASTM D 1002
Substrate	:	Steel
Cure	:	24 hrs @ 25±2 °C

Aged at temperature indicated and tested @ 25±2 °C.



Chemical/Solvent Resistance

Cured for 24hours @ 25±2 C, Activator® 1006 on 1 side

Test	:	Lap Shear Strength, ASTM D 1002
Substrate	:	Steel
Cure	:	24 hrs @ 25±2 °C

Aged under conditions indicated and tested @ 25°C.

Environment	Temp (°C)	% of Initial Strength	
		100 hrs.	500 hrs.
Engine oil	100	100	100
Isopropanol	25	100	100
Ethanol	25	100	100
Humidity 90% RH	50	100	100
Water Glycol (50/50)	87	100	75

Directions for Use

- ❖ For best performance bond surfaces should be clean and free from grease.
- ❖ Use applicator to apply the activator to the surface to be bonded.
- ❖ After the solvent evaporates, the active ingredients will appear wet, and will remain active for up to 15 minutes after application. Contamination of the surface before bonding should be prevented.
- ❖ Apply adhesive to the un-activated surface.
- ❖ Secure the assembly, and wait for the adhesive to fixture (approximately 5 minutes) before any further handling.
- ❖ Full cure occurs in 16 - 24 hours.
- ❖ Handling Bond strength should be allowed to develop before subjecting to any service loads.

Handling

- ❖ For safe handling My-T-Bond® 624 must be handled in a manner as indicated in Material Safety Data Sheet (MSDS) and in compliance with relevant local regulations.
- ❖ My-T-Bond® 624 is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials
- ❖ My-T-Bond® 624 can affect certain plastics particularly thermoplastic materials or coatings. It is recommended to check all surfaces for compatibility before use.
- ❖ Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.
- ❖ My-T-Bond® 624 is non-volatile and non-flammable at room temperature.

Storage

- ❖ Store My-T-Bond® 624 in unopened containers in a cool and dry location at 25±2°C.
- ❖ Store away from sunlight and heat sources.
- ❖ My-T-Bond® 624 will exhibit a shelf life of one year from the date of manufacture when stored in above mentioned conditions.

- ❖ To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact our Technical Service center or R&D Center.

Pack Size

My-T-Bond® 624 is ideally available in 50 ml and 250 ml pack.

Note

All statements, technical information and recommendations set forth herein are based on tests which Metlok Private Limited, believes to be reliable. However, Metlok Private Limited does not guarantee their accuracy or completeness. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In no case will Metlok Private Limited be liable for direct, consequential economic or other damages. Continuous Product Improvement is an important policy of the company and is an ongoing activity. As such we reserve the right to improve the performance of the product continuously by modifying the formulation in a manner that it enhances the performance functions.

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