

STRUCTURAL ADHESIVES GUIDE



Best bond in the business...



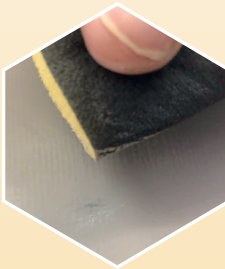
Product	Image	Colours	Sizes	Characteristics	Main materials	Useful information	Thickness of bead/dot
800		Clear	50ml	Open Time 1 - 2 Minutes Handling Strength 3 - 4 Minutes Gap Filling Capability 1mm – 3mm Operating Temperature -50°C - +120°C	● Vinyls ● PVC ● Aluminium ● Carbon Fibre ● Stainless Steel ● ABS ● Acrylics ● Styrenics ● Gelcoats ● FRP (Fibre Reinforced Plastics) ● Polyesters ● Urethanes	Very fast setting so have multiple jobs ready to avoid using lots of nozzles. Main substrates are plastics	We suggest a 3-5mm width bead or a blob of adhesive large enough to allow the final bond to have a minimum adhesive thickness of 0.5mm – 1.0mm after light compression.
2020E		Clear	50ml	Open Time 1-2 Minutes @20°C Handling Strength 4-5 Minutes @ 20°C Gap Fill 3mm Temperature Range -55°C to 125°C	● Polycarbonate ● Acrylic	Main substrates are plastics	
900		Tan, Black or Grey	50ml and 400ml	Open time 7 minutes @ 20°C 10g mass Handling strength 12 minutes @ 20°C 10g mass Standard temperature -55°C to 120°C Paint bake cycle 20 minutes @ 220°C Gap fill 4mm	● Aluminium ● Wood ● Stainless steel ● Granite ● Mild steel ● Marble ● UPVC Urethanes ● Polyesters ● Vinyl esters ● ABS ● Glav / Zinc coated ● Acrylic Thermoset ● FRP Gelcoa ● GRP ● Epoxy ● laminate	Can pass through Powder Coat oven	
930LX		Tan or Black	50ml and 400ml	Open Time 12-15 Minutes @ 20°C Handling Strength 20-25 Minutes @ 20°C Gap Fill 5mm Temperature Range -55 to 120°C	● Aluminium ● Wood ● Stainless steel ● Granite ● Mild steel ● Marble ● UPVC Urethanes ● Polyesters ● Vinyl esters ● ABS ● Glav / Zinc coated ● Acrylic Thermoset ● FRP Gelcoa ● GRP ● Epoxy ● laminate	Best product for delicate surfaces such as mirror acrylic, ACM, BCP, DI-BOND*	
RAPID		Pink/ Green	50ml	Open Time <2 Minutes Handling Strength 5-7 Minutes Operating Temperature: 40°C to + 180°C Max. Operating Temperature: + 200°C (Intermittent) Normal Operating Limits: + 130 C (Continuous) Gap Fill: <3 mm	● Metals ● Glass ● Epoxy, ● Unsaturated Polyesters ● GRP ● Bakelite	Very fast setting so have multiple jobs ready to avoid using lots of nozzles. Best product for most metals including brass - Can pass through Powder Coat oven	

2 PART ADHESIVE

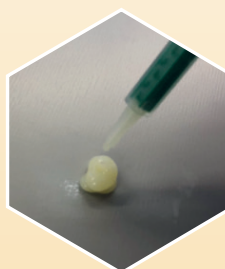
HOW TO GUIDE

Firstly ensure you have the correct adhesive for the substrate. When working with delicate surfaces, such as, Mirror acrylic, ACM, BCP, DI-BOND etc, we advise using INDASOL LX Adhesive. The reason for this is that standard 2 part locator bonding adhesives can generate heat which may distort the face of the substrate.

We have products for all substrates, including Mirror Acrylic, BCP, Di-Bond, Metal, Wood, Plastics, Glass, Brass and Stainless Steel.



Step 1: Lightly scuff both substrates with sandpaper. This is an optional process, however by doing this it does increase the surface area for the bond.*



Step 4: Apply the adhesive to one substrate either in blobs or as a bead. Thickness and diameter of this depends on the work being done and surface area available.



Step 2: Ensure the substrates are clean. Use INDASOL IPA surface cleaner if necessary to remove finger grease and any sanding dust from step 1. For stainless steel and low surface energy substrates, use INDASOL 1960 primer



Step 5: Bring the substrates together ensuring that the bond is good. Adhesive should be compressed to 0.5mm-1.0mm in overall thickness. Each product has a short window for movement. Do not interfere with bond or move product outside of the initial work time (see TDS for details).



Step 3: Place cartridge into gun and remove cap. Gently squeeze trigger until adhesive appears in left and right outlet. Wipe excess adhesive with a clean cloth downwards, trying not to mix part A&B where possible. This is to the burp the cartridge. Fix nozzle in place and dispense a small amount into a waste container to ensure you have a perfect mix.



Step 6: Leave for 24 hours (or as advised on data sheet) to fully cure before fixing.

- Clean and abrade surface before bonding. Prime if necessary
- Apply using correct mixing nozzle
- Refer to TDS and SDS before use
- Always test first to ensure compatibility

Disclaimer: These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. Industrial Adhesive Solutions Limited shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Please contact us for further assistance and information. In some cases a primer may be required, please contact us for technical advice.