



## TECHNICAL DATA SHEET

## MMA

Gerko MMA is a high strength, rapid curing, methyl methacrylate, structural adhesive, which gives a tough durable bond with plastics, metals and other materials. It is isocyanate-, phthalates-, solvent-, PVC- and silicone free.

### PROPERTIES

- Does not attack surfaces
- Room temperature cured with short open time
- Over paintable
- Very good UV-resistance and excellent ageing properties
- Gap filling up to 5 mm
- Non sagging thixotropic formulation, perfect for horizontal and vertical applications
- Excellent impact, peel and shear strength

### APPLICATIONS

- Automotive
- Marine
- Construction and assembly industries
- Bonding of PVC, Acrylic, PC, PBTO, PU, Stainless Steel, Gel Coats, ABS, Styrene, Epoxy etc.

### PHYSICAL PROPERTIES

CODE	DESCRIPTION	COLOUR	PIECES PER BOX	PIECES PER PALLET
MB50	MMA 50ML	Black	1	900

### NOMINAL VALUES

	ADHESIVE	ACTIVATOR
Chemical base	Methyl Methacrylate	Methyl Methacrylate
Colour	Black	Black
Specific gravity (g/cm <sup>3</sup> )	1,00	1,00
Viscosity (mPas)	60.000	40.000

### TYPICAL CURE CHARACTERISTICS

	TEMPERATURE	TIME
Open time	@ 23°C	6 min
Curing time	@ 23°C	20 min
Complete cure	@ 23°C	24 hour

Temperatures higher or lower than 23°C will have influence on the open time and curing time.



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### TYPICAL PROPERTIES OF CURED ADHESIVE

<b>Shore D hardness</b>	EN ISO 868 @ 23°C	73
<b>Tensile strength</b>	ASTM D638 @ 23°C (MPa)	24
<b>Young's modulus</b>	ASTM D638 @ 23°C (MPa)	1800
<b>Elongation at break</b>	ASTM D638 @ 23°C (%)	33

### ADHESION

Gerko MMA has excellent primer-less adhesion properties to metals, painted surfaces, aluminium PVC, glass fibre reinforced plastic, ABS, polycarbonate and plastic materials. Gerko MMA can be over-painted with most types of lacquers.

**Note!** In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.

### APPLICATION CONDITIONS

<b>Application temperature</b>	Between 15°C and 25°C
<b>Substrate</b>	The surfaces to be bonded should be clean, dry and free from dust and grease
<b>Application method</b>	Manual and pneumatic guns
<b>Mixing ratio</b>	1:1
<b>Mixing</b>	Connect the mixertip to the cartridge and press out 2 cm. (Do not use) to be sure that you have a 100% mixture of the 2 components
<b>Assembling</b>	After applying the adhesive, assembly the parts (within open time) and immediately clamp or press

### SHELF LIFE AND STORAGE

The product has a shelf life of 12 months in the originally sealed cartridge, when stored in an unopened container at a dry place between 5 - 25°C.