



AT-804030

Technical Data Sheet

AT-804030 is a 1:1, meter-mix, methacrylate-based structural adhesive formulated to bond engineered thermoplastics, thermosets, composites, and metal structural elements in any combination. It has excellent adhesion to as-received metal surfaces, including aluminum, galvanized, stainless and plated steels. It exceeds the strength of PVC, ABS, acrylic, polycarbonate, fiberglass and many other composites and engineering plastics. It forms tough, high-strength bonds without surface preparation, primers, or chemical wipes. It features a 3-4 minute open time for fast fixturing. This product is formulated as a non-sag, high viscosity product with a special filler for holding anchoring studs and clips to walls and ceilings and is easily dispensed from cartridges with static mixer tubes. AT-804030 also provides low temperature impact and peel strength. This formulation is Reach Compliant and acid free.

UNCURED PROPERTIES







Viscosity, cPs, Brookfield TD @ 2.5/20 rpm	PART A 250,000/ 50,000	PART B 350,000/ 90,000
Color	PART A Off White	PART B Amber
Density (pounds/gallon)	PART A 8.82	PART B 8.45
Mix Ratio (Weight & Volume)	1:1	
Flashpoint	51°F (11°C)	

TYPICAL CURING PROPERTIES

Mixed Viscosity, cPs, Brookfield TD @ 2.5/20 rpm	265,000/65,000
Mixed Density (pounds/gallon)	8.63
Working Time	3-4 Minutes
Fixture Time 3 kg weight, Aluminum/Aluminum	5-6 Minutes
Peak Exotherm Temperature (range)	257° to 275°F (125° to 135°C)
Peak Exotherm Time (range)	12 - 14 Minutes

TYPICAL CURED PROPERTIES

Color	Off-White to Amber
Hardness (Shore D)	68-70
Elongation (%)	10%
Operating Temperature	-40° to 248°F (-40° to 125°C)

-  Room Temperature Cure
-  Fast Fixturing
-  Reach Compliant
-  Convenient 1:1 Mix Ratio
-  Bonds Diverse Substrates
-  High Viscosity, Non-Sag
-  Good Chemical Resistance
-  High Green Strength
-  Acid Free

BOND PERFORMANCE (STRENGTH AFTER 24 HOUR CURE, UNLESS NOTED)

Tensile Shear (ASTM D1002), psi (N/mm²)

Steel: 3,200 (22)

Acrylic: Substrate Failure

PVC: Substrate Failure

ABS: Substrate Failure

SMC: Substrate Failure

Aluminum: 3,250 (22.4)

Galvanized: 2,200 (15.2)

Polycarbonate: Substrate Failure

Fiberglass: Substrate Failure

Ultem to Aluminum: Ultem Failure

1 HOUR CURE - Approx 75% full cure

Steel: 2,400 (16.6)

Aluminum: 2,420 (16.7)

Galvanized: 1,800 (12.4)

Peel Strength

(ASTM D1876), pli (N/mm)

Steel: 65 (11.4) @ 0.017" (0.432 mm) Gap

Impact Strength

(GM9751P), Joules/in² (KJ/m²), 2 kg Hammer

Aluminum: 13 (9.6)

The technical data was generated under controlled laboratory conditions using standard substrates. Performance must be verified on production substrates and tested under end use conditions to confirm performance.

Packaging & Shelf Life

AT-804030 is available in 30 ml. The materials can be used with conventional meter/mix dispense equipment. All materials should be stored in a cool place when not used for an extended period of time. Do not freeze. Shelf life of this product is six (6) months at 73°F (23°C) when stored in original sealed bulk containers and 12 months in cartridges.

Chemical Resistance

AT-804030 exhibits good resistance to commonly encountered service environments and chemicals. Resistance to specific chemicals and environments must be tested by the end-user to ensure the adhesive is compatible to both the substrate and the environment.

NOT RECOMMEND FOR LONG TERM EXPOSURE TO FOLLOWING SOLVENTS: Toluene, MEK, acetone, 100% low molecular weight aromatics, aldehydes, and ketones.

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