

Technical Data Sheet

2510 PlastiFix High Performance Adhesive is a two-component, 100% reactive structural methacrylate adhesive specifically formulated for bonding thermoplastics, thermosets, metals and composite assemblies.

FEATURES:

- Convenient 1:1 mix ratio, sag resistant and thixotropic formulation
- Excellent adhesion to metal surfaces such as aluminum, stainless steel, plated steel, galvanized metals, etc. without primer or chemical wipes.
- Excellent impact, peel and shear resistance
- Room temperature cure with extended working time.

APPLICATIONS:

- Ideal for bonding all types of metals, Metton®, PVC, fiberglass, PBT, PPO, ABS, polyurethane, epoxy, wood, RIM, nylon, polyester, acrylic, gelcoats, styrene, etc.
- Ideal for automotive components, heavy equipment, watercraft, electrical components, tools, appliances, computer assemblies, furniture, exterior signs and displays, etc.

ADHESIVE PROPERTIES

	Adhesive	Activator
State of Matter	Viscous Liquid	Viscous liquid
Appearance	Off-White	Amber
Viscosity at 25°C	80,000 – 85,000	80,000 – 85,000
Flash Point (TCC)	51 °F	51 °F
Density (lbs/gal)	8.07	8.05
Mix Ratio (weight & Volume)	1	1

CURE CHARACTERISTICS

Mixed Viscosity, cps	280,000 - 320,000
Mixed Density	8.06
Working Time	10 – 12 minutes
Fixture Time	18 – 22 minutes
Functional Cure	2 – 4 hours
Full Cure	24 hours
Coverage/lb	147 sq.in @ .010"
Service Temperature	-40°F to 250°F
Assembly Time	22 minutes @ 77°F

CURED ADHESIVE PROPERTIES

		Standard
Gap Filling	0.125+ inches	
Shore Hardness	66 D	ASTM D 2240
Elongation Before Break	18%	
Tensile Shear Strength	3,000 psi	DIN 53283
Peeling Strength	18-20 pli	
Adhesive Tensile Shear (Steel/Steel)	4200 psi	ASTM D 1002
Adhesive Tensile Shear (Al/Al)	>3,600 psi	
Adhesive Tensile Shear (Fiberglass/Fiberglass)	Stock Failure	
Adhesive Tensile Shear (ABS/PVC)	Stock Failure	
Adhesive Tensile Shear (SMC/SMC)	Stock Failure	
Impact Resistance	18 ft.lb./in.	

APPLICATION INSTRUCTIONS:

- All surfaces must be clean, dry, dust, and grease free. The best results will be achieved when the surfaces have been abraded immediately prior to bonding.
- Thorough mixing is required for proper curing and strength development of the adhesive.
- Excess adhesive can be wiped away with organic solvent. Adhesive bond should be allowed to develop to full strength (24 hours) before subjecting to any service loads.

PACKAGING:

2510 PlastiFix is available in 200 mL cartridges only.

PRECAUTIONS:

This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheets (SDS) for this and all other products being used are understood by all people who will work with the product.

WARRANTY:

Polyvance warrants only that its product will meet those specifications designated as such herein. All information supplied by Polyvance is considered accurate, but the warranty is dependant upon the express condition that the customer shall make its own assessment to determine the product's suitability for a particular purpose. Polyvance makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will nor infringe any patent.



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