

#### Features

- High strength and durability
- Structurally bonds Polyolefins
- Bonds plastics, metals, composites
- Very good chemical resistance
- Good impact strength
- No primers or surface preparation necessary

#### Description

Acri-Bond 206 is a two-part MMA adhesive designed to structurally bond hard-to-glue plastics like polypropylene and polyethylene without primers or surface prep. It delivers strong, chemical-resistant bonds to polyolefin's, metals, and composites, making it ideal for automotive, industrial, plastic assembly applications and is ideal for bonding dissimilar surfaces.

#### Properties of Uncured Adhesive

	AB206 (A)	AB206 (B)
Chemical Composition	Methyl Methacrylate	Methyl Methacrylate
Colour	Off White	Clear
Mixed Colour	Off White	
Viscosity @ 25°C	9,000 CPS	10,000 CPS

#### Typical Curing Properties

Cartridge Ratio	10 : 1
Maximum Gap Fill	3 mm
Working Time @ 25°C	5 – 6 minutes
Fixture Time @ 25°C	90 – 240 minutes
Full Strength @ 25°C	24 - 48 hours
Supplied In	50mL Cartridge

#### Typical Performance of Cured Adhesive

Shear Strength	Polypropylene (PP)..... <b>1075 psi</b> (CF)
	Polyethylene (PE)..... <b>1100 psi</b> (AF)
	Acrylic..... <b>950 psi</b> (SF)
	PC..... <b>850 psi</b> (SF)
	Aluminium..... <b>2275 psi</b> (CF)
	Copper..... <b>2275 psi</b> (CF)
	Mild Steel..... <b>2050 psi</b> (AF)
	Stainless Steel..... <b>2300 psi</b> (CF)
Resistant to	Ethylene Glycol, Brake Fluid, Power Steering Fluid, Iso-Pentane
Susceptible to	Strong Acids and Bases
Working Temperatures	-40 to 80°C

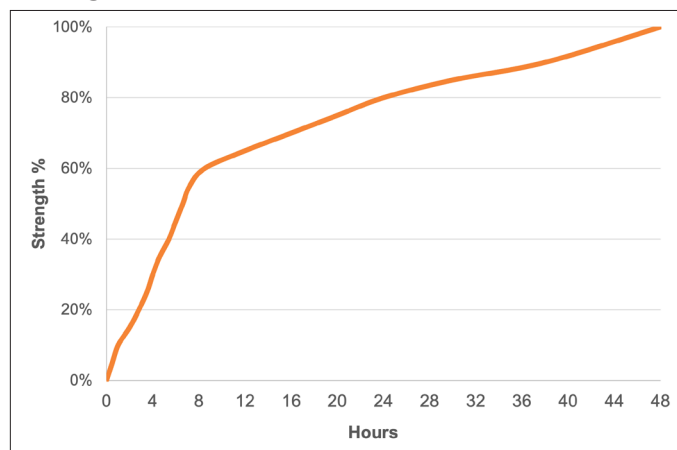
PC – Polycarbonate

SF – Substrate Failure

AF - Adhesion Failure

CF – Cohesion Failure

#### Strength Development



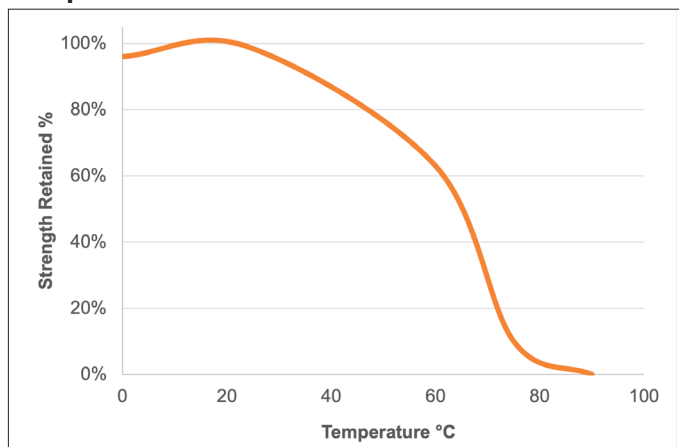
The graph above shows typical strength development of bonded components at 25°C. An increase in temperature will relate to a faster cure time. A lower temperature will result in a slower cure time.

The information and recommendations provided in this document are based on our research and are believed to be accurate; however, no guarantee is made regarding their accuracy or completeness. We strongly advise that purchasers conduct their own testing before using any product in full-scale production, to ensure the product meets their quality expectations and is suitable for their specific application and conditions.

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#### Temperature Resistance



ACRI-BOND 206 can be used in temperatures as low as -40°C.

#### Storage and Shelf Life

Storage Temperature	4 - 12 °C
Shelf Life	9 Months

#### Surface Preparation

All surfaces should be clean, dry and free from grease or contaminants before applying Acri-Bond 206. Acri-Bond Cleaner can be used to clean and degrease most materials. For metal surfaces, Acri-Bond Surface Adhesion Promoter (SAP) may be applied to improve adhesion and bond strength.

#### Instructions for Use

1. Surfaces must be clean, dry and grease-free prior to bonding. If using a cleaning solvent, allow 3-4 minutes to fully evaporate before applying adhesive.
2. Apply adhesive directly out of static mixer to ensure correct pre-mixed ratio.
3. Assemble components within working time specifications and clamp.
4. Maintain clamps until fixture time is reached, which is based on 25°C but can vary with temperature changes. See above for clarification.
5. Clamps may be removed, and the job can be lightly handled. It should not be put under any heavy mechanical load until adhesive has fully cured.
6. Allow 24-48 hours for the adhesive to fully cure.

#### Materials Tested

Acrylic, PC, ABS, PVC, Steel, Stainless Steel, Copper Aluminium, Wood, MDF, FRP, CF, Polypropylene, Polyethylene, PTFE (Teflon), PVDF, Glass, Concrete

#### Not Recommended Surfaces

Nylons, Silicone Surfaces, Polyimide  
 Surfaces Containing Mold-Release Agents  
 Substrates that contain oils and anti-stats.

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