# ACRI-BOND 206
## Methyl Methacrylate Adhesive
Technical Data Sheet

### 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

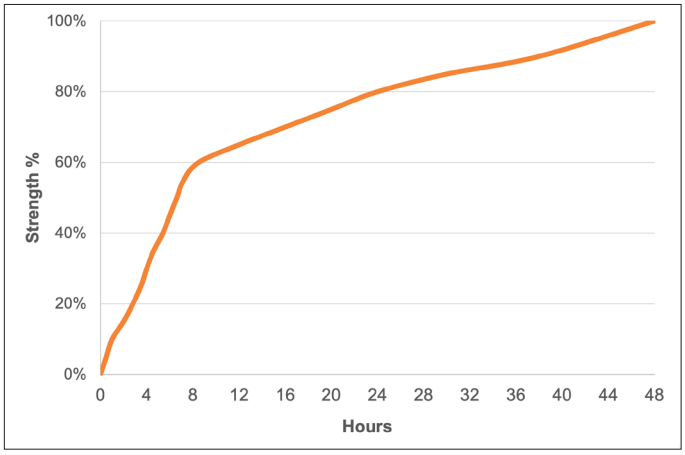
| | |
|---|---|
| Cartridge Ratio | 10 : 1 |
| Maximum Gap Fill | 3 mm |
| Working Time @ 25°C | 5 – 6 minutes |
| Fixture Time @ 25°C | 90 – 240 minutes |
| Full Strength @ 25°C | 24 - 48 hours |
| Supplied In | 50mL Cartridge |

### Typical Performance of Cured Adhesive

| | |
|---|---|
| Shear Strength | Polypropylene (PP)....**1075 psi** (CF)<br>Polyethylene (PE).....**1100 psi** (AF)<br>Acrylic.....**950 psi** (SF)<br>PC.....**850 psi** (SF)<br>Aluminium.....**2275 psi** (CF)<br>Copper.....**2275 psi** (CF)<br>Mild Steel.....**2050 psi** (AF)<br>Stainless Steel.....**2300 psi** (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.

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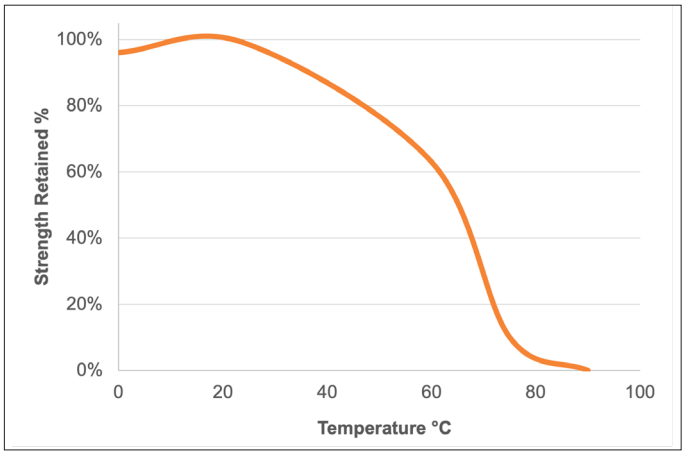
### Temperature Resistance




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

### 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.

### Storage and Shelf Life

| | |
|---|---|
| Storage Temperature | 4 - 12 °C |
| Shelf Life | 9 Months |

### Materials Tested

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

### 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.

### Not Recommended Surfaces

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