

#### Features

- High strength and durability
- Bonds plastics, metals, composites
- Fast 4–6 minute working time
- Fast cure at room temperature
- Non-sag for easy application

#### Description

Acri-Bond 200 is an industrial-grade, two-part MMA adhesive offering high strength, fast cure time, and reliable bonding of plastics, metals, and composites with minimal surface preparation. Ideal for structural applications across multiple industries. Balanced thicker viscosity ensures smooth, precise application for diverse industrial bonding needs.

#### Properties of Uncured Adhesive

	AB200 (A)	AB200 (B)
Chemical Composition	Methyl Methacrylate	Methyl Methacrylate
Colour	Off White/ Grey	Light Brown/ Grey
Mixed Colour	Cream	
Viscosity @ 25°C	40,000 – 60,000 CPS	40,000 – 60,000 CPS

#### Typical Curing Properties

Cartridge Ratio	1 : 1
Maximum Gap Fill	4 mm
Working Time @ 25°C	4 – 6 minutes
Fixture Time @ 25°C	14 – 16 minutes
Full Strength @ 25°C	24 hours
Supplied In	50mL or 400mL Cartridge

#### Typical Performance of Cured Adhesive

Shear Strength	Aluminium..... <b>3400 psi</b> (CF) ABS..... <b>2000 psi</b> (CF) PC..... <b>1450 psi</b> (CF)
Resistant to	Hydrocarbons, Salt Solutions, Acids and Bases (3-10pH)
Susceptible to	Polar Solvents, Strong Acids and Bases
Working Temperatures	-40 to 140°C

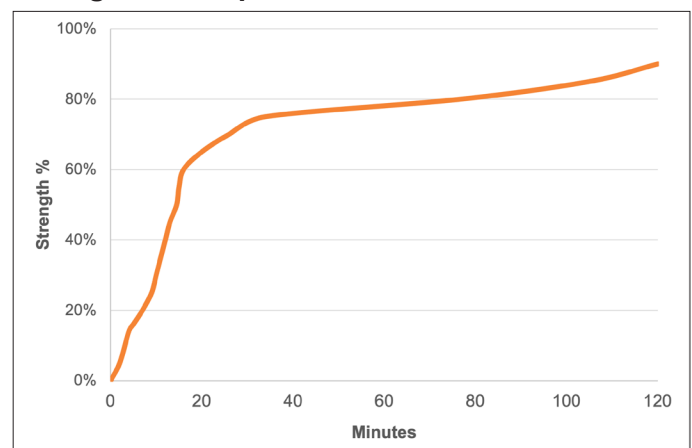
PC – Polycarbonate

ABS – Acrylonitrile Butadiene Styrene

SF – Substrate Failure

CF – Cohesion Failure

#### Strength Development



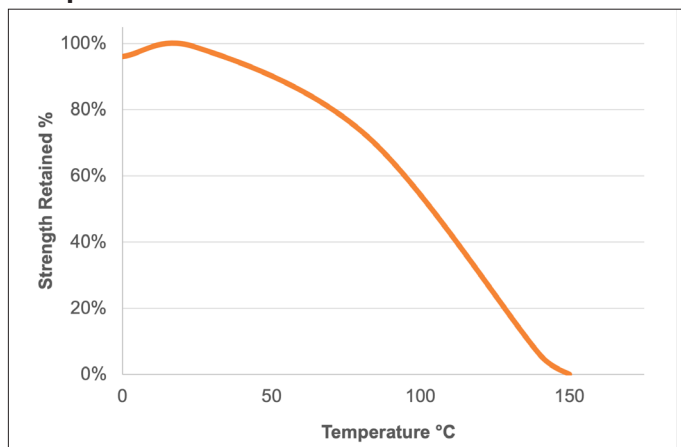
The graph above shows typical strength development of bonded components at 25°C. An increase in temperature will relate to a faster cure time. A lower temperature will result in a slower cure time.

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 200 can be used in temperatures as low as -40°C.

#### Storage and Shelf Life

Storage Temperature	12 – 22 °C
Shelf Life	12 Months

#### Surface Preparation

All surfaces should be clean, dry and free from grease or contaminants before applying Acri-Bond 200. 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 hours for the adhesive to fully cure.

#### Materials Tested

Acrylic, PC, ABS, PVC, Steel, Stainless Steel (with AB SAP), Aluminium, Wood, MDF, FRP, CF

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