

Technical Data sheet

Company: Multi Supplies 4U Ltd Tel: 01282 930195 37 Casserley road, Colne Lancashire BB8 0QT

Product code MS4WELD 846

Technical Data – Page 1

General Description

MS4WELD 846 is a toughened 1:1 ratio structural adhesive formulated for bonding thermoplastics, metals and composites. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations.

Typical uses of MS4WELD 846

MS4WELD 846 is used for outdoor weathering or solvent exposure applications, thermoformed plastic assemblies, PVC, Fiberglass, Vinyl, ABS, Steel, FRP, Coated metals, Aluminum, Acrylics, Wood, Concrete, Ceramics.

MS4WELD 846 has been tested and approved for use with ovens for powder coating and paint bake cycles up to 220°C Intermittent temperature and up to +150°C Constant temperature.

Application

For best results use on clean, dry substrates between +10°C to +30°C. Insert the cartridge into the slot on the applicator gun. Once the cartridge is secure, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixing nozzle. Attach the mixing nozzle and dispense adhesive until a uniform colour is evident. Apply the mixed adhesive to one joint surface, immediately bring the two surfaces into contact and apply a steady pressure. The cartridge can be re-sealed if only partly used by removing the mixing nozzle, cleaning the two cartridge openings and replacing the cartridge cap.

Physical Data

Typical uncured properties.

	Adhesive component	Activator component
Adhesive	Methyl methacrylate	Methyl methacrylate
Appearance	Off white gel	Off white gel
Specific Gravity @ 25°C	0.97	0.95
Viscosity @ 25°C Brookfield DVII, Spindle 7, 2.5rpm	50,000 to 100,000 cps	50,000 to 100,000 cps
Operating Temperature	-40°C to +150°C Constant temperature -40°C to +220°C Intermittent	

Disclaimer This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.

Technical Data sheet

Company: Multi Supplies 4U Ltd Tel: 01282 930195 37 Casserley road, Colne Lancashire BB8 0QT

MS4WELD Technical Data – Page 2

Mixed properties.

Working Time	4-6 minutes
Fixture Time	10-12 minutes
Mix Ratio	1:1

Typical cured properties.

Tensile Strength (psi)	3,500 - 4,500 ps
Modulus (psi)	125,000
Elongation at break	50-75%
Bond strength	3,500 max

General Information

Packaging – Available in 50ml cartridge and 400ml cartridge.

Terminology

Working time/Open time: The time interval between application of adhesive to substrate, and the possible assembly / repositioning of the two mating parts at 20°C.

Fixture time: The length of time after the substrate assembly that will allow a joint to support a 1kg dead weight (tested on a 12mm x 25mm overlapped joint at 20°C)

Storage - Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 18°C unless otherwise labeled. Optimal storage is at the lower half of this temperature range. For specific shelf-life information, contact Multi Supplies 4U Ltd at the above address.

Important Notice - Data contained in this document is for information only and is believed to be reliable. Multi Supplies 4U LTD cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and MS4U is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

The hazard label (complying with latest CDG/CPL regulations) applied to the container.
Material Safety Data Sheet, MS4WELD

Disclaimer This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.