



ISEGA certificate 40682 U 15

fire tests



Physical Appearance

Adhesive Part A

Chemical Type	Methyl Methacrylate
Color	milky
Density	approx. 0,97 g/cm ³
Viscosity @20°C mPa·s Brookfield	130.000 to 150.000
Flash Point	11°C
Expansion coefficient (μ/m°C)	60-120x10 E ⁻⁶

Activator Part B

Chemical Type	Methyl Methacrylate
Color	milky
Density	approx. 0,95 g/cm ³
Viscosity @20°C mPa·s Brookfield	150.000 to 200.000
Flash Point	11°C

Mixture A&B

Appearance	milky
Specific Gravity	approx. 0,97
Viscosity @20°C mPa·s Brookfield Helipath < 4 Min.	150.000 to 200.000
Mix Ratio by weight	1:1
Mix Ratio by volume	1:1
Pot life	5 to 7 minutes
Fixture time	10 to 12 minutes
Shelf life 20°C	12 months

The values are average values. They serve merely for your information, but assume no warranty.

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The information in this product has been compiled to the best of our knowledge and is intended purely for information purposes. No claims can be inferred therefrom. Before use, thorough experiments should be carried out. Our brochure represents a basis. Responsibility for possible measures to protect property and persons lies with the user. Safety data sheets on the required standard are available for all products on request.



Typical Properties Cured Material	
Temperature resistance	-55°C to +120°C
Elongation at break	2,4 %
Curing time handling	1 hour
Shrinkage (7 days)	5%
Hardness Shore D	75
Gap filling	1-10 mm
Typical ASTM D1002 Results after 72 hours @ 25°C	
Steel/Steel	up to 30 N/mm ²
Aluminium/Aluminium	up to 27 N/mm ²
Polycarbonate	up to 13 N/mm ²
ABS/ABS	up to 8 N/mm ²
Properties	
<ul style="list-style-type: none"> ○ Bonds metal, stone, woods, plastics and ceramics ○ Extremely high strength ○ Weatherproof ○ MD MEGABOND is easy to use 	<ul style="list-style-type: none"> ○ MD MEGABOND achieves higher strength at low/no surface treatment ○ resistant against petrol and kerosene
Processing information	
MD MEGABOND is mixed automatically. Connect the pieces within 4 minutes and allow to harden for 24 hours (approximately 75% of the final strength is present after 2 hours at room temperature).	
Processing information (25 g)	Processing information (50 g)
The bonding surfaces must be clean, oil and grease free (e.g. with Marston Cleaner). Excellent results are obtained by a mechanical roughening of the adhesion surfaces. Twist off cap, attach and tighten the mixing nozzle. Push the material out with the dispensing gun and discard the first 2 g, as they are not yet mixed at 1:1. Setting time can be curtailed at high temperatures. Join work pieces together and fix. Store opened cartridge in a cool, dry place.	As with the 25 g cartridge, in addition: Insert the cartridge into the dispensing gun and then close. Twist off cap, attach and tighten the mixing nozzle. Push the material out with the dispensing gun and discard the first 2 g, as they are not yet mixed at 1:1.

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Handling and storage
Due to the high reactivity of the product and the associated exothermicity there should be no larger quantities mixed. The resulting heat can cause evaporation or odour nuisance. Do not dispose in plastic containers because they may/might melt.
Storage and shelf life
The storage stability of MD MEGABOND is at <20°C for one year from the date of manufacture. The expiration date is printed on the label. Temperatures above 25°C reduce the storage stability. Lower temperatures (5-12°C) increase the shelf life. Exceeding the storage temperature about 40°C and at high humidity the shelf life is reduced to 6 months. The product should be protected from frost (not cool deep). Material removed from containers may be impurified. Do not return product to the original container. It cannot be held liable for material that is impurified or was stored in a way that differs from the above-mentioned conditions.
Cleaning
Cleaning is easiest if the product is still liquid. Cured material is need to be removed mechanically (scrape off) and with a solvent such as Acetone. Remove any residues with an absorbent and dispose it like a flammable.
Processing temperature
The processing should be done at room temperature (+20°C). Higher temperatures eg +40°C reduce the positioning and cure time by 30%, low temperatures (approx. 10°C) increase the respective times up to 50%, up from +5°C almost no reaction longer takes place.
Precautions
For complete information about safety and proper handling please mention the safety data sheet.

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RoHS conform	
Packaging	Item number
14 dual syringes á 25 g	MMB.S25
12 double cartridges á 50 g	MMB.S50
6 double cartridges á 400 g	MMB.S400
8 dual syringes á 25 g blistered	MMB.S25-BK

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