

Technical Data Sheet

121 ADHESIVE

Description

121 Adhesive is a two-component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications. 121 Adhesive has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the 121 Adhesive to achieve the ultimate balance of mechanical strength and impact resistance whilst remaining both simple and quick to use.

Typical Applications

121 Adhesive is very versatile and can bond a wide variety of substrates without the need for surface primers or conditioners. Typical examples shown below:

- Bonding metal fasteners to moulded composite parts
- Bonding aluminium and stainless-steel lettering in the sign manufacturing industry.
- Bonding automotive carbon fibre body panels
- Bonding GRP in the marine industry
- Bonding dissimilar metals for trailer fabrication

Instructions For Use

1. Always consult SDS before using 121 Adhesive for the first time.
2. Carry out surface preparation where required. *
3. Remove cap and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner *
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

**Contact your Ellsworth Tooling Solutions representative for full information and usage instructions.*

Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Green/Pink
Appearance	Translucent Liquid
Viscosity Brookfield T Bar	5000cps
Cure System	Exothermic
Open Time	2-3 Minutes @ 20°C
Handling Strength	4-5 Minutes @ 20°C

Performance of Cured Material

ASTM D1002 Lapshear	Up to 25 Nmm ²
ASTM D638 Tensile Strength	Up to 25 Nmm ²
Gap Fill	2mm
Temperature Range	-55°C to 125°C

Packaging

121 Adhesive is available in 25ml, 50ml and 400ml Nylon cartridges for use with a dispensing gun. 121 Adhesive is also available in 20 litre pails for use with a dispensing system.

Storage & Shelflife

121 Adhesive should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 12-month shelf life from manufacture.

Health and Safety in Use

121 Adhesive is a methyl methacrylate and should not be used without consulting the SDS, which contains full information regarding the safe use of this product.

A product Safety Data Sheet should be obtained from Ellsworth Adhesives Ltd prior to use.

ATTENTION: Before handling, read product information, Product Safety Data Sheets and container labels for safe use, and any physical and/or health hazard information.

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Warranty: The information given in this product data sheet are believed to be fully accurate. However, Ellsworth Adhesives Ltd shall not be liable for its content and make no warranty with respect thereto. For additional information we request you to contact Ellsworth Adhesives Ltd - visit our web-site: www.ellsworthadhesives.co.uk