



Product Data

Adekit A-310 NA

Methacrylate Adhesive

Universal Grade

High Reactivity

APPLICATIONS

Adekit A-310 NA is a two-component high reactive methacrylate. Its particular properties allow it to bond many different materials together. This product is particularly good for bonding metals and works well for bonding plastics too. Adekit A-310 NA is also suitable for bonding galvanized iron, laminated parts, as well as thermoset or RIM prototype parts.

PROPERTIES

- Easy to use cartridge kit
- No sag on vertical surfaces
- Medium cure time
- Excellent for bonding metals or thermoplastics

CHOOSING AN ADEKIT PRODUCT

- It is important to take the environment and surface condition into consideration when selecting the correct Adekit product for your application. Environment combined with the product's mechanical characteristics may affect the product's bonding resistance over time.
- After full curing, Adekit A-310 NA has good resistance to prolonged exposure to water, sea water, highly diluted bases, hydrocarbons, or mineral oils.
- Chemical resistance to oxidizing acids (nitric, sulfuric) or chlorinated solvents is average. It is not meant to be permanently immersed in any of these. Exposure to detergents, acids, and concentrated bases must be for a limited amount of time.

Items to consider when selecting an Adekit Product for Use:

- Nature of materials to be processed
- Mechanical performance of bonding
- Environment (temperature, moisture, UV light, etc.)
- Durability required

SURFACE PREPARATION

- Apply on a clean, dry surface that is free of polluting agents (grease, dust, etc.)
- Please consult our technical department for preparation of large industrial applications
- This product comes in a two part cartridge and requires a manual or pneumatic gun for application.
- Application temperature range is 59° - 95°F (15° - 35°C)

Possible Surface Preparations:

- Degreasing with solvents
- Mechanical treatment
- Chemical treatment
- Application of a primer

PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves and safety glasses

For further information, please consult the Material Safety Data Sheet

STANDARD PACKAGING

Part A Resin	Part B Hardener
25 cc cartridge	25 cc cartridge
200 cc cartridge	200 cc cartridge

Adekit A 310-NA is sold in packages of 12 cartridge kits per case

Adekit A-310 NA

PHYSICAL PROPERTIES				
Composition		Resin	Hardener	Mixed
Mix Ratio - by weight		100	100	-
Mix Ratio by volume		100	100	-
Color		Off-White	Yellow	Natural
Viscosity 72°F/22°C	cP	200,000	200,000	200,000
Pot Life at (10g) 72°F/22°C	Minutes	-	-	15-18
Initial Hardening (10g) 72°F/22°C	Minutes	-	-	30-35
Density	lbs/gal (g/cc)	8.60 (1.03)	8.10 (0.97)	8.35 (1.00)
Working Temperature Range	°F / °C	-	-	-67°-250° / -67°- 121°

MECHANICAL AND HEAT RESISTANCE PROPERTIES*			
Tensile Strength	ASTM D638	psi/MPa	4,000-4,500
Tensile Modulus	ASTM D638	psi/MPa	150,000-175,000
Strain to Failure	ASTM D638	%	5-15
Lap Shear - Cohesive Strength	ASTM D1002	psi/MPa	3,000-3,500

APPLICATION INSTRUCTIONS

- Apply using a coaxial pneumatic or manual gun.
- Do not apply in thicknesses greater than 9mm.

STORAGE

The shelf life of both parts is six (6) months in a dry place and in the original unopened containers at a room temperature of up to 72°F/ 22°C. All materials should be stored in a cool place when not used for an extended period of time. Shelf life may be extended with refrigeration, DO NOT FREEZE.

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON® products, under their own conditions before commencing with the proposed application. AXSON® guarantees the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON® disclaims all responsibility for damage from any incident, which results from the use of these products. The responsibility of AXSON® is strictly limited to reimbursement or replacement of products, which do not comply with the published specifications.

November 7, 2002

Page 2 of 2



AXSON NORTH AMERICA, INC.
 1611 HULTS DRIVE
 EATON RAPIDS, MI 48827 U.S.A.
 TOLL FREE: 800.365.8191
 LOCAL: 517.663.8191
 FAX: 517.663.0523

AXSON MEXICO
 SAN LUIS POTOSI N°211 PISO
 7 DESP 701 COL. ROMA
 06700 MEXICO DF
 LOCAL: (52) 5.264.49.22
 FAX: (52) 5.264.49.16

AXSON FRANCE
 BP 444
 95005 CERGY, FRANCE
 LOCAL: 013.440.3460
 FAX: 013.421.9787

VISIT AXSON ON THE WEB AT:
WWW.AXSON.COM

WEB: WWW.AXSON-NA.COM
 E-MAIL: INFO@AXSON-NA.COM

WEB: WWW.AXSON.COM
 E-MAIL: AXSON@PRODIGY.NET.MX

WEB: WWW.AXSON.COM
 E-MAIL: AXSON@AXSON.FR