

## 2C Methacrylate Adhesives

### Multi Power Spezial 17

Multi Power Spezial 17 is a 2-component, strain hardening adhesive for metal and thermoplastic synthetics. The product is an acryl-based structural adhesive for numerous treated and untreated metals and technical plastics. It was especially developed to ensure a high impact and peel strength as well as a good resistance to cold. It replaces numerous mechanical connection and fixing methods like riveting, welding or soldering, especially at low temperatures.

#### Trading units

150 ml cartridge  
380 ml cartridge  
490 ml cartridge

#### Item no.:

MPSP17.K150  
MPSP17.K380  
MPSP17.K490



#### Performance characteristics

- Bonding of untreated metals possible
- Bonds numerous thermoplastic synthetics, e.g. polycarbonate and XENOY
- Bonding of vertical surfaces possible
- Little surface-treatment necessary
- Resistant to diluted acids, alkaline substances, solvents, greases, oils, humidity, solar radiation and weathering
- Temperature resistant between  $-40^{\circ}\text{C}$  and  $+149^{\circ}\text{C}$
- UV-stable

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### General product properties

	<b>Component A (Adhesive)</b>	<b>Component B (Activator)</b>
Colour:	Cream-white	Cream
Viscosity(mPas) (Brookfield; 25°C) :	100.000 – 300.000	1.000 – 3.500
Mixing ratio:	10	1
Flash point (°C):	15	> 93
Specific gravity (g/ml):	1,09 – 1,16	1,15 – 1,25
Colour after mixing:	beige	
Colour after curing:	greenish	

### Application properties at 23°C

Working time (min):	3 – 6
Fixture time (min):	20 – 35
Final strength (h):	24
Optimum adhesive layer thickness (mm):	0,25

### Cured properties

Tensile strength (N/mm <sup>2</sup> ):	32 (ASTM D638)
Elongation (%):	30 (ASTM D638)
Tensile modulus (N/mm <sup>2</sup> ):	1132 (ASTM D638)
Glass transition temperature (°C):	72 (ASTM E1640-99)

### Storage and shelf life

If stored at recommended temperature between +10°C and +15°C, the unopened components A and B have a shelf life of 6 months, which is defined from the date of shipment from GLUETEC.

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#### Application conditions

Follow the recommended instructions or do not hesitate to contact GLUETEC for help before bonding.

Make sure that the product gains room temperature and the materials to be bonded are free of dust, oxide layer and other contaminants before usage. Please use an appropriate WIKO cleaner for this [depending on the material either WIKO METAL CLEANER (AMTR.D500; AMTR.D1000) or WIKO PLASTIC CLEANER (AKSR.D500; AKSR.D1000)] in order to ensure an ideal process.

Usually, a simple cleaning before bonding is enough. In special cases, however, the surface must be grinded in order to ensure an ideal bonding result.

Place the product cartridge into a suited dispensing device, remove sealing cap and squeeze a small amount of the adhesive onto a piece of cloth/pulp until both components are flowing freely.

Then, clean the cartridge outlet and apply the mixing nozzle on the outlet, now squeeze a small amount of the adhesive onto a piece of cloth/pulp until the material has a homogenous colour.

Dose enough of the adhesive onto the joint partners to make sure that there is minimum gap of 1 mm (max. 15 mm) when bonding. A lower layer thickness is possible, yet require a material-oriented and application-oriented testing beforehand. Make sure that enough adhesive is applied in order to ensure a complete filling of the gap. Clamp properly to prevent joint movement during curing process. If too much pressure is applied, the adhesive layer thickness might be influenced negatively and therefore impair the bonding quality. In case of doubt, use spacers or do not hesitate to contact GLUETEC.

Please pay attention to the information of the safety data sheet before usage. Use the product in well-ventilated areas only. Large curing masses of the adhesive should be stored carefully in well-ventilated areas only. Keep the cartridge closed when it is not in use.

Avoid contact with skin or eyes. If swallowed, seek medical advice immediately. The product is easily flammable and thus, must be kept out of reach of heat sources.

The user must verify the application-suitability of the adhesive at all times before conducting the application. GLUETEC advises strict testing in order to determine the current batch and the final results.

This product is intended for the use by qualified personnel only and at own risk. Recommendations contained herein are based on our knowledge and experience. The mentioned properties and values were obtained under controlled conditions in our laboratory and thus, respectively, only serve as clues. An actual suitability for any individual application needs to be tested and determined by the user under realistic conditions. GLUETEC reserves the right to restrict the replacement warranty for damaged goods after leaving the factory, since the correct management cannot be controlled comprehensibly.

The information contained in this data sheet, especially the suggestions for processing and application of products, is based on our experience and newest expertise. Due to the facts that materials can be very diverse and that we have no influence on the working conditions, we recommend to perform sufficient tests to validate the compatibility of the products. Our company shall neither be held liable for this information nor for a verbal or written consultation. Additionally, please consider the information of our safety data sheets.