

Technical Datasheet D374

Product Description

Delta D374 is a two component hybrid structural adhesive, designed for the bonding of low surface energy materials such as polypropylene (PP) and polyethylene (PE) without the need for primers or pre-treatments. Used frequently in manufacturing and composite assembly applications. Once bonded this offers a high strength bond with excellent chemical and environmental resistance.

Typical Applications

Delta D374 is very versatile, and can bond a wide variety of substrates and plastics without the need for surface primers or conditioners. Typical examples shown below:

- Lightweight automotive components.
- Polypropylene battery cases.
- Hand held electronic devices.
- Model Aircraft.
- Assembling electric meter housings & covers.

Instructions For Use

1. Always consult MSDS before using D374 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.

Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Cream/Clear
Appearance	Thixotropic gel
Viscosity Spindle 6 @ 20rpm	150,000cps
Cure System	Exothermic
Open Time	4 - 5 Minutes @20°C
Handling Strength	20 Minutes@ 20°C

Performance of Cured Material

ASTM D1002 Lapshear	Up to 30 Nmm ²
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Gap Fill	Up to 5mm
Temperature Range	-50°C to 120°C

Packaging

Delta D374 is available in 50ml Nylon cartridges for use with a dispensing gun.

Storage & Shelflife

Delta D374 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 6 month shelf life from manufacture.

Health and Safety in Use

Delta D374 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.