

# D371

## FAST WHITE METHACRYLATE ADHESIVE

### PRODUCT DESCRIPTION

D371 is a two part, very fast setting, room temperature curing, methacrylate adhesive system which is ideal for structural repairs and bonding plastic parts. It cures by chemical reaction of the two components, which are contained in a two part cartridge and applied through a specially designed mixing nozzle. This ensures that the 1:1 mix ratio is achieved along with the necessary amount of mixing. The product forms a durable polymer which includes a novel adhesion system, this gives a cured product with an excellent balance of mechanical strength and impact resistance. D371 is specifically designed for small, quick and durable repair jobs also referred to as 'smart repair'.

### PROPERTIES

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as Aluminum, Stainless steel, ABS, PVC, Polyurethane, Composites, Thermoplastics, Thermosetting Plastics, Wood, Glass, Concrete without any use of primer.
- General bonding and sealing.
- Sandable and overpaintable.
- Easy and cost effective repair.
- High viscosity for vertical applications.

### AREAS OF USE

- Repairs to acrylic baths and fittings.
- Cosmetic plastic part repairs
- Cladding and panel bonding applications.
- Any high specification bonding use.

TECHNICAL DATA	TYPICAL UNCURED PROPERTIES	
	Colour	White UV Stable
Appearance	ThixotropicGel	
Viscosity, Brookfield, T Bar	400,000 to 600,000cps	
Mix Ratio by volume	1:1	
Mix Ratio by weight	1:1	
Working Time	7 Minutes	
Fixture Time	12 - 15 Minutes	
Functional Cure	2 hours	
Full Cure	24 hours	

**STRUCTURAL**

TECHNICAL DATA	TYPICAL CURED PROPERTIES	
	ASTM D1002 Lapshear	Up to 30 Nmm <sup>2</sup>
	ASTM D638 Tensile Strength	Up to 30 Nmm <sup>2</sup>
	Gap Fill	4mm
Service Temperature	-55°C to 120°C	

**SURFACE PREPARATION**

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the surface area and increase the bond strength. For lacquered and coated surfaces we recommend to remove the layers by sanding and degreasing with a suitable solvent. For more detailed information, please contact Delta Technical Department.

**MIXING PROCEDURE**

**Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.**

1. Attach cartridge to 50ml manual or pneumatic dispensing systems.
2. Open or remove tip.
3. Extrude cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to surface and attach other substrate quickly, as you have less than 2 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.2mm.

**STORAGE**

Store in cool, dry place.

**HEALTH AND SAFETY**

Refer to the relevant Material Safety Data Sheet (MSDS).

**PACKAGING**

Available in 50ml twin syringe.

**LEGAL NOTICE**

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Delta Adhesives Limited accepts no liability arising out of the use of this information or the product described herein.

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