

### ADHESIVE DESCRIPTION

ACRALOCK SA10 HV series are advanced, two component, 10:1 mix ratio, high shear strength coupled with excellent toughness, high elongation primerless metal bonding, high gap fill, and low exotherm adhesives. The SA10 HV series is available in different adhesive and activator combinations to achieve a wide range of working times starting from around 30 min on up to 120 min in various colours and are designed to bond as received aluminium and stainless steel without primers and with minimal to no other surface preparation<sup>a,b</sup> as well as being able to fill low to high bonding gaps.

Packaging options include 490 ml side by side cartridges and 20 l & 200 l drum containers for application with meter-mix dispensing equipment.

**HV = alta viscosità**  
**LV = bassa viscosità**  
**UV = bianco uv resistente**

### PERFORMANCE HIGHLIGHTS

- Working time 30 to 120 minutes
- Primerless Metal Bonding
- Low Exotherm adhesives
- Gap fill 0,5 to 50 mm**
- Good Environmental/Chemical Resistance<sup>(b)</sup>
- Permanent toughness and elasticity
- No Sagging
- Non Critical mix ratio
- Non Critical to air inhibition
- Stable formulations

**nome del prodotto  
CARTUCCIA**

### BENEFITS

- Variety of working times available for assembly applications
- No surface treatment or priming required for most metals<sup>(a)</sup>
- Reduced Print Through, less post finish work
- Thin film to high gap fill application possible
- Durable long performance in harsh environments
- Excellent fatigue characteristics and shock load resistance
- Vertical surface and overhead applications possible
- Easy to use with cartridges and meter mixing equipment
- Hand Mix application possible
- Shelf-life 6 months

**Indicazione componenti**

### PRODUCT PROPERTIES @ 22° C

Product	Adhesive/Activator	Working Time (Minutes)	Fixture Time (Minutes)
SA 10-35 HVBLK <sup>(x)</sup>	SA 10-50A / 1 BBLK	30 - 35	>60
SA 10-50 HVBLK <sup>(x)</sup>	SA 10-50A / 2 BBLK	40 - 50	>90
SA 10-60 HVGRY <sup>(x)</sup>	SA 10-50A / 3 BGRY	50 - 65	>120
SA 10-70 HVGRY <sup>(x)</sup>	SA 10-100A / 3 BGRY	65 - 80	>120
SA 10-100 HVGRY <sup>(x)</sup>	SA 10-100A / 4 BGRY	80 - 100	>180
SA 10-120 HVGRY <sup>(xx)</sup>	SA 10-100A / 5 BGRY	110 - 130	>300

(x) other colours and working times available on request

(xx) minimum gap 2 mm, only for tropical environments

### TYPICAL ADHESIVE WET PROPERTIES

Property	Component A	Component B	A + B mixed
Colour	Off White	Black	Black
	Off White	Grey	Grey
Mix Ratio (Volume)	10	1	
Mix Ratio (Weight)	8,8	1	
Viscosity kps (Pa.s)	800 - 1000	100 - 200	
Density (g/cm <sup>3</sup> )	0,95 - 0,97	1,09 - 1,11	0,97 - 0,99
Density (lb/gal)	7,9 - 8,05	9,1 - 9,3	8,1 - 8,2

**vuole dire  
neutro beige**

### TYPICAL ADHESIVE CURED PHYSICAL PROPERTIES

- Tensile strength: 3000 - 3,500 psi (21 - 24 MPa)
- Modulus: 80 - 100 kpsi (620 MPa)
- Elongation: 150 - 200 %
- Lap Shear strength, ASTM D1002: 2000 - 2500 psi (14 - 17 MPa)
- Operating Temperature: - 55 - 120°C
- Max Temperature resistance: 200°C, 1h

Cured Adhesive is generally resistant to salt solutions, hydrocarbons and acid and bases with a PH from 3 to 10.

Cured Adhesive is not recommended for exposures to polar solvents and stronger acids or bases (see note b).

Operating Temperature range for this product is from - 40 to 120° C with intermittent exposure of -55 to 200° C (see note c)

**molto completa la tabella dei substrati e delle resistenze dei vari materiali**

**RECOMMENDED SUBSTRATES (See important notes below)**

Polyesters	Acrylics	PVC/FPVC/CPVC	Vinyl Esters
Polyester Gelcoats	ABS	Styrenics	SMC/BMC
Epoxies	Vinylesters	Stainless Steel <sup>(5)</sup>	Carbon Steel
Aluminim	Topcoats	E - Galvanized Metals <sup>(4)</sup>	Coated Metals
Polyurethanes	PU - Rim	PA - RIM	Polycarbonate
PMMA	PET		

**NOT RECOMMENDED FOR BONDING**

Polyolefins	Polyacetals	PTFE	Glas
Hot Dipped Galvanized Steel	Wood		

**TYPICAL LAP SHEAR STRENGTH VALUES @ 22°C,**

Carbonfibre epoxy laminate:	16 MPa <sup>(e)</sup> (cohesive failure)
Stainless steel:	20 MPa <sup>(h)</sup> (adhesive/cohesive failure)
Carbon Steel:	24 MPa <sup>(g)</sup> (cohesive failure)
Aluminum AW 6060	24 MPa <sup>(e)</sup> (cohesive failure)
PVC pultruded	7,0 MPa <sup>(e)</sup> (substrate failure)
PC	8,5 MPa <sup>(e)</sup> (substrate failure)
Polyester RTM laminate	13,5 MPa <sup>(e)</sup> (substrate failure)
Polyester RTM/Gelcoat	9 MPa <sup>(e)</sup> (substrate failure)
Polyester RTM/Topcoat	9 MPa <sup>(e)</sup> (substrate failure)
PU foam resin laminate	5 MPa <sup>(e)</sup> (substrate failure)
Stainless steel:	17 MPa <sup>(h)</sup> (adhesive/cohesive failure)
Carbon steel:	18 MPa <sup>(g)</sup> (adhesive/cohesive failure)
Aluminium AW 6060:	23 MPa <sup>(f)</sup> (cohesive failure)
ABS:	5 MPa <sup>(f)</sup> (substrate failure)
KTL:	11 MPa <sup>(f)</sup> (substrate failure)

<sup>(e)</sup>: bondline gap 1 mm, IPA wipe

<sup>(f)</sup>: bondline gap 1 mm, IPA wipe, after Kataplasmatestcycle, -30/+120°C, 12h each, 5 cycles

<sup>(g)</sup>: bondline gap 1 mm, Grinding 40 grit sandpaper, IPA wipe, after Kataplasmatestcycle, -30/+120°C, 12h each, 5 cycles

<sup>(h)</sup>: bondline gap 1 mm, Grinding 40 grit sandpaper, AP-1 wipe, after Kataplasmatestcycle, -30/+120°C, 12h each, 5 cycles

**IMPORTANT NOTES**

- a.) Surface Preparation: The need for surface preparation must be determined by the user based on comparative testing of unprepared and prepared substrates to determine if strengths are adequate for application. Clean adhesive failure is not desired for long-term durable performance. In all cases initial shear strength tests must be followed up with simulated or actual durability tests to assure that surface conditions do not lead to degradation of the bond over time under service conditions. Subsequent changes in substrates or bonding conditions will require re-testing.
  1. Most thermoplastics listed above can be bonded with no surface preparation other than a dry wipe or air blow-off. If contamination is visible or suspected, wipe with alcohol prior to bonding. Low surface energy plastics like polyolefins, thermoplastic polyesters and fluorocarbon plastics are generally not bondable.
  2. Metals as received aluminum, stainless steel, cold rolled steel, carbon steel are bondable without preparation, EBS strongly suggest only using faster curing versions with working times less ≤ 40 minutes, if bonding metal to metal in thin bond gaps ≥ .015" Bond Gap must be maintained.
  3. Thermoset composites are generally bonded without preparation, however mold releases and process can produce varied bonding performance and testing should be performed.
  4. Due to the wide range of different surfaces and qualities each single type has to be tested by the customer prior to use
  5. Use of AP-1 metal cleaner is recommended
- b.) It is the user's responsibility to determine the suitability of each adhesive for its intended use on substrates and application. EBS strongly recommends laboratory and end-use testing representative of the environmental conditions and how the bonded assembly will be used. Read and understand TDS and MSDS before using. Bonds are generally resistant to the effects of heat, water and moisture, aqueous chemicals and most petroleum hydrocarbons, including gasoline, motor oil and diesel fuel. Not recommended for immersion or long term exposure to concentrated acids or bases, or aggressive organic solvents such as toluene, ketones, and esters. It is the user's responsibility to determine the suitability of each adhesive for its intended use and application. Please contact EBS for technical assistance.

unclamped. This is generally shortly after exotherm is reached for particular bonding condition. Parts can generally be put in service when 75% percent strength has been reached. Once the bonded assembly has cooled back to ambient temperatures. Higher ambient temperatures will shorten the working time and colder temperatures will lengthen the working time. The reported data presented in the TDS are based on tests conducted under laboratory conditions of 75°F/24°C. For applications in hot or cold ambient conditions please contact your EBS representative.

Prior to bonding, surfaces are cleaning free of surface contaminants. All dispensing equipment should be in good operating condition and QC ratio checks performed periodically to ensure consistent and accurate dispensing. Use only adhesive dispensing equipment approved by your EBS representative. All wetted metal parts should be stainless steel, always purge enough adhesive on a non-porous surface (frp or plastic) to ensure proper mixed color is maintained. Check the cure profile to ensure the working time and fixture time match the reported values for A and B components listed on the front page. If all QC checks are in order continue with the assembly and be sure that parts are bonded to a minimum gap thickness of 0.02" (.5mm) and maximum gap of 0.5" (50 mm). All adhesives with working times below 45 minutes can boil in gaps approaching 12,5 mm or even less if using even faster formulas. This could lead to reduced physical properties. After the adhesive is fully applied, consistent pressure should be applied to allow squeeze out, then also, parts should not be repositioned once substrates are bonded. Any movement of parts will entrap air in the bonded joints, which will reduce performance. The bonded assembly should be clamped in position until the cure time has elapsed.

EBS recommends the use of alcohol or industrial cleaning excess adhesive. This should be done when the adhesive is still wet or soft and care must be taken to prevent the cleaning solvent or alcohol from coming in contact with the adhesive as this could lead to an under-cure of the exposed edges. The use of tape and a sharp edge to remove excess adhesive is best practice. Also, partially cured adhesives should be carefully removed with a sharp blade. Removal of cured adhesive should be scraped or cut with a sharp blade which is preferred to sanding or grinding. High speed sanding or grinding of large areas will produce heat and produce noxious fumes and should be avoided by the user with protective breathing apparatus.

**confezioni e materiali:**  
**HV 10-60 fustini da 20 L NERO**  
**cartuccia 490**

**HV 10-100 fustini da 20 L GRIGIO**  
**cartuccia 490**

**UV 10-15 fustini da 20 L BIANCO**  
**cartuccia 380**

**UV 10-40 fustini da 20 L BIANCO**  
**cartuccia 380**

**LV 10-05 fustini da 20 L NERO**  
**cartuccia 490**  
**cartuccia 380**  
**cartuccia 50 ml**

**LV 10-15 fustini da 20 L NERO**  
**cartuccia 490**  
**cartuccia 380**  
**cartuccia 50 ml**