

Tecnite MA 52 - 2K-Polyolefin Adhesive**General Description**

Solvent free 2 Part Structural Acrylate-Hybrid Adhesive

Properties

- Impact-resistant, flexible, excellent adhesion to difficult to bond surfaces such as:-PP, PE, Teflon or EPDM
- Good water and general chemical resistance
- Specially developed for bonding / encapsulating / sealing of Polyolefin and other non-polar
- (low surface energy plastic surfaces)

Product description / Application

	Base material	Activator
Viscosity @ 23°C	8000 – 12000 mPas	28000 - 35000 mPas (Haake cone / plate, shear rate 60/s)
Colour	white	off white
Density	1,00 g/cm ³	1,05 g/cm ³
Mix Ratio by Volume	10	1
Fixture time	2 hours @ 25°C	
Full cure	8 hours @ 25°C	
Working time	5 minutes @ 25°C	

Shelf-life in un-opened original packaging @ 5 °C to + 25 °C x 6 Months

Properties after curing

Colour	white
Shore hardness	D 47
Lap shear strength	PE, 2mm layer 5,8 N/mm ² (cohesive failure in bondline)
Lap shear strength	PP, 2mm Dicke 6,4 N/mm ² (cohesive failure in bondline)
Lap shear strength	high molecular PP, 4 mm Dicke 5,0 N/mm ² (cohesive failure in bondline)

Background Information

MA 's are 2 -Part Acrylate oder Acrylate-Hybrid formulations, which cure quickly upon mixing the basis material with an activator.

Typically found in use in the Automotive Industry but also highly rated by for use in electronics, fine mechanics, optical instruments and generally where production processes require rapid assembly of components.

Surface treatment

The contact surfaces to be bonded should be dry, free of dust, grease and other forms of contamination. Wiping with isopropyl alcohol or ethanol should be sufficient. However, the use of atmospheric plasma treatment will offer the best results for extremely low energy surfaces.

Dispensing the adhesive

This adhesive system is delivered in ready-to-use cartridges and can be applied directly per hand. For half- and fully-automated production there is an option to receive the product in containers suitable for meter mixing equipment. The mixing of the two components via a static mixer allows for a homogenous mixing.
For further assistance on how best to dispense this adhesive please contact our application engineers.

The information contained in this technical data sheet is to the best of our knowledge correct. However, by no means can it be considered a guarantee as usage, working area and application of the product in accordance with the instructions given and their success in application, is beyond our control and is dependent on a number of factors. We decline any responsibility for the improper use of the product as the application recommendations contained herein are to be considered only as a general guideline. If at all in doubt, preliminary tests should be carried out.