



The Glue People

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Tradeweld Acrylic Super Fast

General Description

Tradeweld Acrylic Super Fast is a two component system, designed for bonding metals, thermoplastics and composite materials. Its very fast cure rate, gap filling ability up to 12mm, and superb methacrylate strength make it ideal for repairing many types of plastics found in the automotive, caravan and motor home industries (not suitable for polyolefins e.g. polypropylene - see acrylic PP).

Tradeweld Acrylic Super Fast has excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded and repaired parts. It is a primer-less compound, requiring only minimal surface cleaning of the substrates to be bonded and demonstrates high toughness in all assembled parts.

Application

Grind out the crack into a bowl shape as in fig 2, then key the surface of the joint with a 60 or 40 grit sand paper.

Fig1



Fig 2



Using a soft, lint free cloth wipe the surface to be bonded with TGP Adhesion Promoter, or Adhesion Promoter wipe. Allow to flash off, then apply Tradeweld Super Fast immediately to prepared surface. For best results use on clean, dry substrates between +15°C and +20°C.

To use, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixing nozzle. Attach the mixing nozzle, dispense and discard adhesive until a uniform colour is evident. Apply the mixed adhesive to the prepared substrate and fill joint until slightly proud of the surface - Fig 3.

Fig. 3



It is best to fill the entire joint to give best flexural strength. If any of the crack is visible from the other side, turn plastic over and inject to fill as much as possible.

When cured, Tradeweld Super Fast can be sanded and finished in the same way as plastics. i.e use primers* and paints usually used with plastics.

The cartridge can be re-sealed if only partly used by removing the mixing nozzle, cleaning the two cartridge openings and replacing the cartridge cap.

*We recommend thorough testing to ascertain the compatibility of any subsequent paint coatings with the Tradeweld Super Fast.

Physical Data

Typical uncured properties.

	Adhesive component	Activator component
Adhesive	Methylmethacrylate	Methylmethacrylate
Appearance	Off white gel	Black gel
Specific Gravity @ 25°C	0.96 - 1.02	1.05 - 1.15
Viscosity @ 25°C Brookfield DVII, Spindle 7, 2.5rpm	100,000 - 140,000 cP	80,000 - 120,000 cP
Flash Point (TCC)	12°C	12°C
Gap fill	1 - 12 mm	

Mixed properties.

Appearance	Grey paste
Working Time	1 - 2 Minutes
Fixture Time	2 – 3 minutes
Mix Ratio	10:1

General Information

Storage - Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 25°C unless otherwise labeled. Optimal storage is at the lower half of this temperature range. For specific shelf-life information, contact Trade Grade Products at the above address.

Important Notice - Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradeweld Super Fast.