



*The Glue People*

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# Tradeweld Acrylic VT

**Fast setting methacrylate structural adhesive**

## General Description

Tradeweld Acrylic VT is a toughened 1:1 ratio structural adhesive formulated for bonding thermoplastics, metals and composites. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations.

### Typical uses of Tradeweld Acrylic VT

Tradeweld Acrylic VT is used for outdoor weathering or solvent exposure applications, thermoformed plastic assemblies, PVC, Fibreglass, Vinyl, ABS, Steel, FRP, Coated metals, Aluminium, Acrylics, Wood, Concrete, Ceramics.

Tradeweld Acrylic VT has been tested and approved for use with ovens for powder coating and paint bake cycles up to 220°C.

## Application

For best results use on clean, dry substrates between +10°C to +30°C. Insert the cartridge into the slot on the applicator gun. Once the cartridge is secure, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixing nozzle. Attach the mixing nozzle and dispense adhesive until a uniform colour is evident. Apply the mixed adhesive to one joint surface, immediately bring the two surfaces into contact and apply a steady pressure. 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.

## Physical Data

### Typical uncured properties.

	<b>Adhesive component</b>	<b>Activator component</b>
<b>Adhesive</b>	Methyl methacrylate	Methyl methacrylate
<b>Appearance</b>	Off white gel	Off white gel
<b>Specific Gravity @ 25°C</b>	0.97	0.95
<b>Viscosity @ 25°C</b> Brookfield DVII, Spindle 7, 2.5rpm	50,000 to 100,000 cps	50,000 to 100,000 cps
<b>Operating Temperature</b>	-40°C to +150°C Constant temperature -40°C to +220°C Intermittent temperature	

**Mixed properties.**

<b>Working Time</b>	4-6 minutes
<b>Fixture Time</b>	10-12 minutes
<b>Mix Ratio</b>	1:1

**Typical cured properties.**

<b>Tensile Strength (psi)</b>	3,500 - 4,500 ps
<b>Modulus (psi)</b>	125,000
<b>Elongation at break</b>	50-75%
<b>Bond strength</b>	3,500 max

**General Information**

Packaging – Available in 50ml cartridge and 400ml cartridge.

**Terminology**

Working time/Open time: The time interval between application of adhesive to substrate, and the possible assembly / repositioning of the two mating parts at 20°C.

Fixture time: The length of time after the substrate assembly that will allow a joint to support a 1kg dead weight (tested on a 12mm x 25mm overlapped joint at 20°C)

**Storage** - Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) 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 Acrylic VT.