



TECHNICAL DATA SHEET

MMA

Gerko MMA is a high strength, rapid curing, methyl methacrylate, structural adhesive, which gives a tough durable bond with plastics, metals and other materials. It is isocyanate-, phthalates-, solvent-, PVC- and silicone free.

PROPERTIES

- Does not attack surfaces
- Room temperature cured with short open time
- Over paintable
- Very good UV-resistance and excellent ageing properties
- Gap filling up to 5 mm
- Non sagging thixotropic formulation, perfect for horizontal and vertical applications
- Excellent impact, peel and shear strength

APPLICATIONS

- Automotive
- Marine
- Construction and assembly industries
- Bonding of PVC, Acrylic, PC, PBTO, PU, Stainless Steel, Gel Coats, ABS, Styrene, Epoxy etc.

PHYSICAL PROPERTIES

Code	Description	Format	Colour	Pieces per box	Pieces per pallet
MB50	MMA 50 ml	50 ml	Black	1	900

NOMINAL VALUES

	Adhesive	Activator
Chemical base	Methyl Methacrylate	Methyl Methacrylate
Colour	Black	Black
Specific gravity (g/cm ³)	1,00	1,00
Viscosity (mPas)	60.000	40.000



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TYPICAL CURE CHARACTERISTICS

	Temperature	Time
Open time	@ 23°C	6 min
Curing time	@ 23°C	20 min
Complete cure	@ 23°C	24 hours

Temperatures higher or lower than 23°C will have influence on the open time and curing time.

TYPICAL PROPERTIES OF CURED ADHESIVE

Shore D hardness	EN ISO 868 @ 23°C	73
Tensile strength	ASTM D638 @ 23°C (MPa)	24
Young's modulus	ASTM D638 @ 23°C (MPa)	1800
Elongation at break	ASTM D638 @ 23°C (%)	33

ADHESION

Gerko MMA has excellent primer-less adhesion properties to metals, painted surfaces, aluminium PVC, glass fibre reinforced plastic, ABS, polycarbonate and plastic materials. Gerko MMA can be over-painted with most types of lacquers.

Note! In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.



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APPLICATION CONDITIONS

Application temperature	Between 15°C and 25°C
Substrate	The surfaces to be bonded should be clean, dry and free from dust and grease
Application method	Manual and pneumatic guns
Mixing ratio	1:1
Mixing	Connect the mixertip to the cartridge and press out 2 cm. (Do not use) to be sure that you have a 100% mixture of the 2 components
Assembling	After applying the adhesive, assembly the parts (within open time) and immediately clamp or press

SHELF LIFE AND STORAGE

The product has a shelf life of 12 months in the originally sealed cartridge, when stored in an unopened container at a dry place between 5 - 25°C.