



# Industrial

## Technical Datasheet 006

### Product Description

StopTite 006 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications. M121 has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the M121 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use.

### Typical Applications

Bondchem M121 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners. Typical examples shown below:

- Bonding metal fasteners to moulded composite parts
- Bonding aluminium and stainless steel lettering in the sign manufacturing industry.
- Bonding automotive carbon fibre body panels
- Bonding GRP in the marine industry
- Bonding dissimilar metals for trailer fabrication

### Instructions For Use

1. Always consult MSDS before using M121 for the first time.
2. Carry out surface preparation where required. \*
3. Remove cap, and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner \*
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

*\*Contact your Bondchem representative for full information and usage instructions.*

### Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Green/Pink
Appearance	Translucent Liquid
Viscosity Brookfield Sp5 @ 20 rpm	3,000 - 4,000 cps
Cure System	Exothermic
Open Time	2-4 Minutes @ 20°C
Handling Strength	4-7 Minutes @ 20°C

### Performance of Cured Material

ASTM D1002 Lapshear	Up to 25 Nmm <sup>2</sup>
ASTM D638 Tensile Strength	Up to 25 Nmm <sup>2</sup>
Gap Fill	2mm
Temperature Range	-55°C to 125°C

### Packaging

Bondchem M121 is available in 25ml, 50ml and 400ml Nylon cartridges for use with a dispensing gun. M121 is also available in 20 litre pails for use with our BC1 dispensing system.

### Storage & Shelflife

Bondchem M121 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.

### Health and Safety in Use

Bondchem M121 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.

The data, information and values contained in this Technical Data Sheet has been obtained by conducting various tests in a controlled laboratory environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the users sole responsibility to determine the suitability of the product for the application. Bondchem Ltd cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warranties or implied usage obligations should not be attributed to, and are not the responsibility of, Bondchem Ltd. Bondchem Ltd are not reliable for any financial loss or other damages incurred by the user as a result of the use of this product.

