

## 930-930LX STRUCTURAL ADHESIVE TECHNICAL DATA SHEET

### Description:

**INDASOL 930-930LX** is a new generation of 2 part 1:1 component mixing structural acrylic adhesives. It offers extended open time for larger and more complex assemblies, mixed via a static mix nozzle at room temperatures. The low exothermic properties mean it is perfect for locator bonding onto ACM, BSP, DI-BOND etc

**INDASOL 930-930LX** demonstrates improved impact strength, peel shear and tensile resistance and exterior performance. Because it is a thixotropic, non-sag adhesive, the mixed material is ideal for all types of gap filling requirements on steel, aluminium, polycarbonates and general plastics. It is also very good for vertical surface bonding without running.

**INDASOL 930-930LX** exhibits excellent structural strength even without priming the surfaces. Owing to its macro molecular structure, the bonds formed show excellent durability and high peel strength even when filling large gaps and demonstrate excellent solvent and environmental resistance to moisture, hydro-carbon fuels, lubricants, cleaning chemicals and fluids.

Structural bonding in the sign industry of most signmaking materials especially mild and stainless steels, aluminium, polycarbonate and acrylic sheets, composite panels and even stone and ceramics where high impact strengths are needed.

### Application:

The thixotropic nature of **INDASOL 930-930LX** is ideal for bonding Bighead fasteners and other locators. Other applications include wind turbines, vehicle roofs, fibreglass, sports goods, automotive spoilers, vents, housings. The high temperature adhesive formulation allows for bonding metal parts prior to powder-coating and oven stoving cycles. Works with both SNAP FIX and SIMPLE FIX Locators.

### Solvent and Environmental Resistance:

Formulated to meet ASTM D1002 on steel lapshears with a 5mm gap size cured 1 week @ 23°C

	Temp	1000hrs	2000hrs
RH100%	40C	60%	35%
Salt spray	50C	75%	60%
Water Glycol	20C	75%	65°C
Motor Oil	40C	75%	93%
Gasoline	40C	95%	92%
I P/Alcohol	40C	75%	90%

At room temperature the product resists all the listed test chemicals, retaining 100% of its full strength

Unless stated otherwise all values given are average. All of the tapes in our range should be thoroughly tested on the substrates in the particular application they are intended for. The customer has to decide on the tapes suitability for the intended application.

### Heat ageing properties – (As a % initial

strength) Hours	500	1000	2000	° C
100% RH @20°C	90	95	98	@60°C
100% RH @23°C	65	55	60	@70°C

### Typical Uncured Properties

Parameter	Adhesive Component	Activator Part
Type	Methyl methacrylate	Methyl methacrylate
Appearance	off white gel	Amber like gel
SG@25°C	1.0	0.97
Viscosity @ 25°C	Brookfield DVII@130-150,000cps Spindle No7@ 2.5 Rpm	Brookfield DVII@ 150,000cps Spindle No7 @ 2.5Rpm
Flash Point	>10°C	>10°C
Operating Temperature:	-40°C to + 180°C max. Short-term stoving cycles up to 220°C.	

### Mixed Properties

Parameter	Properties
Appearance	Pale Yellow
Working time	10-12 Mins
Fixture time	18-20 Mins
Mix ratio	1-1 Mixture

### Typical Cured Properties

Parameter	Properties
Tensile Strength	Average 3500 psi
Hardness	approx. 75 shore D
Average shrinkage	<5%
Mix ratio	1-1 Mixture

### ASTM D1002 Lapshears

Parameter	Properties
On steel/steel	4150 (Psi)
On aluminium as received	3500 (Psi)
On polycarbonates	2500 (Psi)
On nylon	200 (Psi)
Impact Strength	>20 KJ/M <sup>2</sup>

The technical information and data, recommendations, and other statements provided in this document are based on our tests or experience.

It will be up to the user matching the product with the working process or surface. Industrial Adhesive Solutions Limited will not be, at any rate, hold responsible for not proper use.

Warranty is limited to replacement of products Industrial Adhesives Solutions Limited prove to be defective and keeps out any other damages.