

TECHNICAL DATA SHEET

INDASOL 800 TRANSPARENT

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INDASOL 800 is a 2-part structural bonding adhesive based on a blend of methacrylates and designed for high strength structural bonding of composites, metals and thermoplastics while remaining crystal clear. **INDASOL 800** is ideally suited to bonding transparent substrates and offers excellent chemical resistance including hydrocarbon solvents and acids and bases from 3-10 pH. It can be used with a very wide range of substrate materials including:

- Vinyls
- PVC
- Aluminium
- Carbon Fibre
- Stainless Steel
- ABS
- Acrylics
- Styrenics
- Gelcoats
- FRP (Fibre Reinforced Plastics)
- Polyesters
- Urethanes

Characteristics:

Working Time	1 - 2 Minutes	
Fixture Time	3 - 4 Minutes	
Operating Temperature	-55°C - 125°C	
Gap Filling Capability	3mm	
Flash Point	12°C	
Mixed Density (g/cm ³)	0.97	

Bonding Performance (@25°C):

Tensile Strength (MPa)	13 - 17	
Tensile Modulus (MPa)	700 - 900	
Tensile Elongation (%)	2 - 5	
Lap Shear Strength (MPa)	15 - 21	

Availability: **INDASOL 800** is available in the following formats:

- 50ml cartridges

Temperature: Ideal conditions for adhesive use are between 23°C and 25°C. Temperatures below 23°C will slow cure speed; above 25°C will increase cure speed. The viscosities of the adhesive are also affected by temperature therefore any automated filling or dispensing systems should maintain constant temperatures throughout the year.

Dispensing Information: **INDASOL 800** may be applied manually or with automated equipment. Static mixer selection is critical to the correct functioning of this adhesive. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient adhesive to ensure that the jointed area is filled when the parts are pressed together. All adhesive application, part positioning and fixturing should be completed within the working time of the adhesive. All automated equipment should be constructed of stainless steel or aluminium.

Avoid contact with copper in all fittings and pumps etc. Seals and gaskets should be PTFE, ethylene/propylene or polyethylene. Avoid Viton, neoprene or nitrile/BUNA-N elastomers for gaskets and seals. To clean up solidified adhesive, carefully scrape away excess and clean with solvent.

Technical Data:

Physical Properties (@25°C)

	Part A	Part B
Viscosity (cP)	100,000	5,000
	135,000	10,000
Density (g/cm ³)	0.97	0.97
Mix Ratio	1	1



For further information, samples and a demonstration, please contact:

 0121 556 9900  0121 556 9034  enquiry@indasol.co.uk

For our Ireland sales manager please contact us on 07795 151814

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Handling and Application:

INDASOL 800 is flammable. Keep containers closed after use. Gloves and safety glasses should be in use when applying the products in order to avoid skin and eye contact. In the case of skin contact, wash with soap and water. In the case of eye contact, flush with water for 15 minutes and seek medical attention. Harmful if swallowed. Keep out of reach of children. Avoid heat, sparks and open flames. See MSDS for detailed safety information.

N.B. Large amounts of heat can be generated when large masses of this product are combined at one time; the resultant heat generation can result in the release of trapped air, steam and volatile gasses. To avoid this, use only enough material as is required for the application and confirm gap thickness to no more than 4mm. Further application advice is available upon request.

Storage and Shelf Life:

The shelf life of the adhesive (part A) is 6 months and the shelf life of the activator (part B) is 6 months. These storage times are based on continuous storage between 6°C and 12°C.

These products should never be frozen. When repackaging from bulk containers to cartridges we recommend that the material is filled in to packaging constructed of Polybutylene terephthalate (PBTP) please contact us for further information and advice.

Industrial Adhesive Solutions Ltd recommend that all substrates be tested with the selected adhesive in the anticipated service conditions in order to determine the adhesives suitability for use.

Tested on Brookfield RV at 25°C, Spindle TC93 at 2.5RPM. Working time is defined as the time between the correct and thorough combination of both adhesive parts and the point at which the adhesives are no longer useable i.e. it has started to gel. The times presented were tested at 24°C.

Fixture time is defined as the time in which the bonded static joint will support a 1kg dead weight on a 12.7mm x 25.4mm lap joint at 23°C.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. Industrial Adhesive Solutions Limited shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Please contact us for further assistance and information.



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