

TECHNICAL DATA SHEET



INDASOL HT & HTFC (Fast Cure) Page 1 of 3

PRODUCT DESCRIPTION and APPLICATIONS:

INDASOL HT & HTFC (fast cure) is a structural methacrylate, a purpose built adhesive for applications intended for the powder coating process.

Open Time: 2-4 min

Fixture Time: 4-6 min

INDASOL HT & HTFC offers a high functional tensile shear strength after the initial cure, which then further increases following an additional heat cure process. This unique chemistry allows these grades to not only maintain a high functional strength through the powder coating process but actually improve in all aspects of functional strength performance.

INDASOL HT & HTFC can bond a wide variety of substrates without the need for surface primers or conditioners.

- Bonding mild steel straps on structural sheet work.
- Sealing weld seams.
- Bonding stainless and aluminum letters and signs.
- Bonding mild steel.

PROPERTIES OF UNCURED MATERIAL:

Resin	Methacrylate Blend
Colour	Off White/Black
Appearance	Thixotropic Gel
Viscosity Brookfield T Bar	200,000 to 280,000cps
Cure System	Non Peroxide



NEXT DAY DELIVERY AVAILABLE

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

0121 556 9900 **technical@indasol.co.uk**

For our Ireland sales manager please contact us on 07795 151814

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PERFORMANCE OF UNCURED MATERIAL:

ASTM D1002 Lapshear	
Aluminum	16.09 Nmm ²
Aluminium (unabraded)	15.92 Nmm ²
Stainless Steel	15.50 Nmm ²
Mild Steel	15.02 Nmm ²
GRP	5.80 Nmm ² SF
ABS	SF
Polycarbonate	SF
Gap Fill	4mm
Temperature Range	-55°C to 150°C
Hardness	70 Shore D
UV Stability	Excellent

COMPATIBLE SUBSTRATES:**

Aluminum	GRP/FRP
Stainless Steel	Granite
Mild Steel	Marble
UPVC	Urethanes
Polyesters	Vinyl Esters
ABS	Galv/Zinc Coated

****Contact your INDASOL representative for full information and usage instructions.**

INSTRUCTIONS FOR USE:

1. Always consult the SDS before using INDASOL HT & HTFC for the first time.
2. Carry out surface preparation where required.
3. Remove cap and nut, burp cartridge and then attach mixer nozzle and replace nut.
4. Dispense sufficient adhesive to ensure equal mix and uniform color.
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.



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CURING CYCLE:

Once mixed at the 10:1 ratio the working time of the INDASOL HT & HTFC is the period whereby the adhesive remains fluid and is easily transferrable between two or more mating surfaces. Temperature, volume and substrate have a direct effect on the length of this period as the INDASOL HT & HTFC cures by an exothermic reaction. Higher temperatures and larger volumes speed the reaction causing a reduction in open and cure time. Lower temperatures and smaller volumes slow the reaction time extending both the open time and ultimate full cure time.

PACKAGING:

INDASOL HT & HTFC is available in 50ml and 490ml PBT cartridges.

STORAGE & SHELF LIFE:

INDASOL HT & HTFC should be stored unopened in suitable hazardous storage conditions for adhesives that are in a cool, dry location and out of direct sunlight. The optimum temperature required would be between 6-12°C; storage outside these temperatures could significantly reduce the shelf life of this product. Stored correctly, this grade can offer a 9 month shelf life from its manufacture in the UK.

HEALTH & SAFETY IN USE:

INDASOL HT & HTFC is a structural methacrylate and should not be used without consulting the SDS, 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.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. Indasol Group 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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