



# SAF B 1023

## TWO COMPONENT METHACRYLATE

### KEY FEATURES

- Very fast curing time
- Liquid
- Transparent (Crystal clear)
- Permanent toughness even after ageing
- Minimal surface preparation

### DESCRIPTION

The SAF range is made of patented methacrylate adhesives and shows unmatched performance in term of resistance and flexibility. These adhesives have been designed for bonding a wide range of dissimilar substrates including metals and plastics as well as composite materials for industrial applications. The outstanding properties of the SAF range allow structural bonding while keeping flexibility and fatigue resistance.

The SAF range products have been developed to resist the most aggressive environments and extreme temperatures. It shows unprecedented results facing weathering and ageing.

### RANGE OF APPLICATION

The SAF B 1023 is recommended for the followed substrates:

Steel	PMMA	ABS
Stainless Steel	PVC	Glass
Aluminium	PC	-
Powder coated steel	PS	-

### PRODUCT CHARACTERISTICS

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Characteristics	SAF B 1023
System	Two component 1:1 Volume Ratio
Polymerization	Room Temperature
Operating temperature	-40°C to 150°C
Elongation	5 %

### ADHESIVE PROPERTIES

PHYSICAL PROPERTIES	
PROPERTIES	
Appearance	Transparent
Density	1,0
Viscosity Brookfield at 23°C [mPa.s]	A: 16000-22000 <sup>1</sup> B: 15000-21000 <sup>1</sup>
Type	Liquid

CURING PROPERTIES	
PROPERTIES	SAF B 1023
Open time [min]	45-70 s
Fixture time @ 24°C [min]	3
Full Cure [hours]	24

MECHANICAL PROPERTIES	
PROPERTIES	SAF B 1023
Lap Shear strength [MPa] <sup>3</sup>	13
Tensile Strength at break [Mpa] <sup>2</sup>	12
Tensile Modulus [Mpa]	200-250
Hardness [Shore D]	60
% elongation at break <sup>2</sup>	5

## WEATHERING AND AGEING RESISTANCE

LAP SHEAR STRENGTH (Mpa) <sup>3</sup>		
Substrates	Before ageing cycles	After ageing cycles
PVS	9 SF	-
Stainless steel	16 CF <sup>4</sup>	-
Aluminium	13 CF	-
ABS	7.5 SF <sup>5</sup>	-
FRP/FRP	5.6 DF <sup>6</sup>	-
Polycarbonate	4 SF	-
PMMA	7 SF	-
Galvanized Steel	13 CF	-

### NOTES

1. Brookfield viscosity (mPa.s) mobile T-D at 10trm
2. With ISO 527-IA
3. With ISO 4587
4. CF: Cohesive Failure
5. SF: Substrate failure
6. DF: Delimitation failure

### SURFACE PREPARATION

Use AEC T700 to remove grease, contamination or poorly adhering oxides from metal surfaces. Most plastics require a simple cleaning before bonding. Some may require sanding for better performances.

### PRECAUTIONS

Adhesive contains methacrylate monomers and is flammable. Materials must be stored in cool place away from sources of heat. During the polymerization, the chemical reaction causes a typical smell, please use the product in a well-ventilated area.

When the adhesive two components are mixed, an exothermic reaction can occur and generates heat. The amount of heat is dependent on the mass and thickness of the mixed product. It can reach a maximal temperature of 100°C.

Adhesives contain chemical materials, prevent contact with skin and eyes. In case with skin contact, wash with soap and water. In case of eye contact, flush with water and seek immediate medical attention. Do not swallow and keep away from children.

Read material Safety Data Sheet before handling or using this product.

## APPLICATION

The optimum qualities are obtained at room temperature, between 12°C and 35°C without post-curing.

Follow the instructions on the product operating guide or contact your Bostik representative for any information concerning product use, dispensing equipment or substrates application.

### STORAGE

The SAF B 1023 shelf life is 9 months in unopened original packaging. The product may be stored in a closed container in a dry place at temperature between 15°C and 30°C.

Exposure to higher or lower temperature will result in a reduction of the stated shelf life.

### PACKAGING

The SAF B 1023 adhesive is available in 50mL side by side cartridges or 2.5 Kg buckets.

SAF B 1023 50mL cartridges require the use of M0Q16-M5,4/7 mixers.

For packaging information please call your Bostik sales or technical representative.

### LIMITED WARRANTY

To the maximum extent allowed by law, Bostik disclaims all other express or implied warranties, including without limitation warranties of merchantability and fitness for a particular purpose. Unless otherwise stated in the limited warranty, the sole remedy for breach of warranty is replacement of the product or refund of the buyer's purchase price. Bostik disclaims any liability for direct, incidental, consequential, or special damages to the maximum extent allowed by law. Disclaimers of implied warranties may not be applicable to certain classes of buyers and some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days of discovery of a problem, and must be submitted with written proof of purchase.

### BOSTIK HOTLINE

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