



# SAF30 15 SA

## TWO-COMPONENT METHYL METHACRYLATE

### KEY FEATURES

- Short open and fixture times, cure time of approximately 15 minutes
- Non-sag application on vertical surfaces
- Excellent environmental resistance

### DESCRIPTION

Designed with patented methyl methacrylate technology, Bostik's SAF structural adhesive product line offers unmatched chemical, environmental, mechanical and fatigue resistance for many industrial applications. Able to bond a wide range of dissimilar substrates, including composites, metals and plastics, the SAF product line features high elongation from 30-250%, smart viscosity formulation, minimal surface preparation and a wide range of open and curing times.

### RANGE OF APPLICATION

The SAF30 15 SA is recommended for the following substrates:

METALS	COMPOSITES	PLASTICS
Steel	Polyester	PVC
Stainless Steel	Vinyl ester	PS
Aluminum	Epoxy	ABS
	Acrylic (Elium)	PC
		PMMA

### PRODUCT CHARACTERISTICS

#### CURING PROPERTIES

Properties	Result
System	Two-component 10:1 volume ratio
Polymerization	Room temperature



### TYPICAL PHYSICAL PROPERTIES

Properties	Resin	Hardener Bostik SAF D
Appearance	Off-White	White
Density (+/- 0.02)	1.08	1.16
Viscosity @77°F (23°C)	300,000 - 450,000 <sup>1</sup>	50,000 - 180,000 <sup>2</sup>
Type	Non-Sag	

### CURING PROPERTIES

Properties	Result
Open time [min]	6 - 8
Fixture time @77°F (23°C) [min]	12 - 17
Full cure [hours]	24

### MECHANICAL PROPERTIES

Properties	Result
Lap shear strength [MPa/PSI] <sup>3</sup> thickness 250µm	16 - 18 / 2,320 - 2,611 CF <sup>5</sup>
Tensile strength at break [MPa/PSI] <sup>3</sup>	13 - 15 / 1,885 - 2,176
Tensile modulus [MPa/PSI] <sup>3</sup>	700 - 900 / 101,526 - 130,534
Hardness [Shore D]	70 - 80
Elongation at break <sup>4</sup>	20% - 25%

## WEATHERING AND AGING RESISTANCE

Lap shear strength (MPa/PSI) with ISO 4587 after D3 cycle.  
D3 cycle: NF EN ISO 9142, 7 aging cycles (7 days).  
CH7: Humid Cataplast, 7 days.

LAP SHEAR STRENGTH (MPA) <sup>3</sup> THICKNESS 250µm			
Substrates	Before aging cycles	After aging cycles D3	After aging cycles CH7
Aluminum 6060	17 / 2,466 CF <sup>5</sup>	16 / 2,321 CF	10 / 1,450 CF
Stainless steel	16 / 2,321 CF	14 / 1,885 CF	10 / 1,740 CF
FPR	DF <sup>6</sup>	DF	DF

### NOTE

<sup>1</sup> Brookfield viscosity (mPa.s) mobile T-F @ 10 rpm

<sup>2</sup> Brookfield viscosity (mPa.s) mobile RV7 @ 10 rpm

<sup>3</sup> ISO 4587

<sup>4</sup> ISO 527-1A

<sup>5</sup> CF : Cohesive Failure

<sup>6</sup> DF : Delamination Failure

## SURFACE PREPARATION

Use an appropriate cleaning agent, such as isopropyl alcohol, 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.

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

## APPLICATION

The optimum quality is obtained at room temperature, ideally between 64 – 82°F (18 – 28°C) without post-curing.

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

## STORAGE

The SAF30 15 SA 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 59 – 77°F (15°C and 25°C).

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

## SHELF LIFE

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

## LIMITED WARRANTY

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### BOSTIK HOTLINE

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