



## TECHNICAL DATA

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# ZYROBOND® MMA 7295 *Methacrylate Adhesive*

MMA 7295 is a strengthened, structural two-component adhesive specifically formulated for bonding a wide variety of metals, thermoplastics, thermosets and composite assemblies.

MMA 7295 is used for making lasting connections and for virtually all bonding and repairs that need to be machined. Combines the various components and elements with each other or in combination.

### FEATURES:

- Excellent for clear and discrete adhesive applications.
- High temperature resistance.
- Excellent shear, peel and impact strength.
- Possesses high gap-filling properties; fills fissures and scratches.
- Possesses a high resistance to heat, vibrations, water, gases, oils, hydrocarbons and many chemicals.
- Suitable for paint bake cycling to +180°C for 20 min.

### APPLICATION AREAS:

- Caravans and boats, electronic and electrical components, automotive components, machinery housings, magnets, metal and mould building, lamp housings, furniture, switch casings, sport and play equipment, signs and displays etc....

### APPLICATION EXAMPLES:

- High-strength metal-glass bonding.
- Bonding flat iron, metal panels and corner angles
- Repairing fibreglass e.g. bumpers, doorways, wings, side panels, bonnets and wind deflectors, cab parts, plastic containers on commercial vehicles and trains.
- Bonding steel and stainless steel casings with large gaps
- Strengthening and installation of auto body floor panels
- Repairing breaks, faulty-drillings, holes and cracks
- Filling and strengthening cavities.



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# ZYROBOND® MMA 7295 Methacrylate Adhesive

### Adhesive Properties:

Chemical Basis:	Methyl Methacrylat
Appearance:	Green / Pink (Mixed: Transluscent thin layer)
Viscosity: (mixed)	3500 - 5000 mPa S (cps)
Flash Point:	21°C
Mixing Ratio: (Weight & Volume)	1.1
Specific Gravity, mixed:	1,02 @ 24°C

### Curing Properties:

Working Time:	< 2 min. @ 24°C
Machining Time:	60 min. @ 24°C
Gap Fill:	< 3 mm
Functional Cure:	1 - 3 hours.
Final Cure:	6 hours.
Recommended Gap Thickness:	0.2 – 2.0 mm
Temperature Resistance:	-40°C to +190°C
Max. Operational Temperature:	up to 200°C (intermittent)

### Mechanical Function Properties:

Tensile Strength:	16 - 22 N/mm <sup>2</sup>	ASTM D 1001
Lap Shear Strength (metal/metal):	20 - 35 N/mm <sup>2</sup>	ASTM D 1002
Lap Shear Strength (glass/metal):	16 - 22 N/mm <sup>2</sup>	ASTM D 1002

**Preparation:** The strength and durability of bonding depends on the proper preparation of the surfaces which are to be glued together. The surfaces must be cleaned with a suitable degreaser in order to remove all possible traces of dust, dirt, oil and grease. For the preparation of thermoplastic materials such as PVC, polycarbonate, polypropylene, polymethyl methacrylate (PMMA - Plexiglas), etc., a mixture of light ether or isopropyl alcohol (IPA) can be used. Do not use solvents, as they could damage the surface. Acetone can be used for the pre-treatment of all other surfaces. Under no circumstances use petrol or other solvents. If possible, grind the surfaces, remove any paint residue from the surface to be glued. In order to increase the strength and durability of the bond. The surfaces must dry thoroughly before applying the adhesive.

**Instructions for use:** The components A and B must be mixed in equal proportions. The 2 components should be mixed thoroughly to ensure optimal bonding. MMA 7295 can immediately be applied by using a static mixer onto the surface to be bonded. To ensure that the mixing ratio is 100% accurate, it is beneficial to discard a small portion of the adhesive before bonding. Excess fresh adhesive can be removed with organic solvents. Cured adhesive can only be removed mechanically. The bonded joint should be loaded only after the end of reaction in order to ensure the full strength.

**Storage:** MMA 7295 should be stored in unopened original packaging in a cool and dry place. Recommended storage temperature +10°C to +25°C. The shelf life is at least 12 months (in compliance with the above mentioned storage conditions).

**Packaging:** MMA 7295 is available in 25ml cartridges.

General information: The information contained herein serves merely as an indication and is given to the best of knowledge. The users must test the suitability of the product for her/his/their respective application independently however. All products purchased from or supplied by Nohtec are subject to terms and conditions set out in the contract. Nohtec warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Nohtec is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Nohtec makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will infringe any patent.