

Product Description

Vitrobond Mightyloc 9025AB is a two component Methyl-Methacrylate (MMA) adhesive specially formulated for a wide variety of metal bonding applications, replacing unsightly mechanical fastening processes like riveting and tack welding etc. It is ideal for bonding most metals, including mild steel, galvanized metal, stainless steel, aluminium and magnets as well. The cured adhesive exhibits exceptional high tensile and shear strength. It also has excellent impact, vibration and temperature resistance.

Features

- Excellent weather durability
- High impact resistance
- Low cost
- Fast setting
- High tensile and shear strength (PSB tested ASTM D1002)
- Easy to use
- ROHS compliant
- Consistent high quality and reliability

Typical Use

- Stiffeners for elevators
- Cladding and facade panels
- Ferrite core for transformers
- Magnets for speaker production
- All metal fixtures requiring long term durability

Physical Properties (Un-mixed)

	Part A	Part B
Color:	Green	Red
Solid Percent:	100%	100%
Viscosity at 25°C	3000-5000 cps	3000-5000 cps
Specific Gravity:	1.16 – 1.18	1.16 – 1.18
Shelf life : (At 15-25°C)	4 months	4 months

Physical Properties (Mixed)

Pot Life at 25°C:	Approx. 5 minutes
Set to Touch:	30 minutes
Full Cure:	24 hours
Operating Temp:	-20°C to 120 °C
Shear Strength: (ASTM D1002)	8.5 n/mm ² or 86kg/cm ²

Tensile Strength | Average Value (Abraded & cleaned with IPA)

Substrates	Tensile Strength
S. Steel to S. Steel	260kg/cm ²
Iron to Iron	255kg/cm ²
Aluminium to Aluminium	110kg/cm ²

Application Method

- All surfaces intended for bonding must be abraded and cleaned thoroughly prior to bonding using Iso Propyl Alcohol (IPA) or Acetone. **DO NOT** use oil based cleaners like turpentine and paint thinners.
- Ensure surfaces are free of dust, dirt & grease before bonding.
- Apply equal amount of both Part A & B directly onto the area to be bonded. Mix them evenly and clamp parts in position immediately.
- For best result, allow bonded parts to set under clamped pressure for 15 minutes and above.

Storage Conditions

Store original container in a cool and dry area (15-25°C), away from direct sunlight. Storing this product otherwise may reduce shelf life and affects physical properties adversely.
DO NOT transfer un-used product back to original container.

Available Packaging Sizes

- 200gm set (Part A 100gm + Part B 100gm)
- 2kg set (Part A 1kg + Part B 1kg)
- 5kg set (Part A 2.5kg + Part B 2.5kg)

Handling Precautions

- Refer to Safety Data Sheet (MSDS) before using this product.
- Always wear personal safety gears when handling this product. (Impervious gloves, eyes protection goggles, respiratory mask.)

For More Product Information, Please Contact:

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