

ACRY'TRON MMA 715

TWO-COMPONENT METHYL-METHACRYLATE ADHESIVE

● PRODUCT DESCRIPTION

Acry'tron MMA 715 is a two component methyl-methacrylate structural adhesive. Acry'tron MMA 715 is designed for high strength structural bonding of metals, thermoplastics and composites with excellent chemical resistant properties. Acry'tron MMA 715 has excellent gap filling properties with non-sag rheology.

● RECOMMENDED SUBSTRATES

It can be used with a very wide range of substrate materials including:

Vinyl	Acrylics
PVC	Styrenics
Polycarbonates	Gelcoats
Aluminium	FRP (fibre reinforced plastics)
Carbon Fibre	Polyesters
Stainless Steel	Urethanes
ABS	

● UNCURED PROPERTIES

	PART A	PART B
Viscosity (cPs)	120,000 – 160,000	150,000 – 200,000
Color	Beige	Straw
Density (g/cm ³)	0.97	0.97
Mix Ratio	1	1
Working Time	4 – 6 Minutes	
Fixture Time	12 – 15 Minutes	
Full Cure	24 Hours	
Flash Point	11°C	

● CURED PROPERTIES

Temperature Resistance	-50°C - +120°C
Gap Filling Capability	1mm – 4mm
Optimum Bond Thickness	0,6mm to 0,8mm
Mixed Density (g/cm ³)	0.97
Tensile Strength (MPa)*	20 – 25
Tensile Modulus (MPa)*	1200 – 1400
Tensile Elongation (%)*	10 – 20
Lap Shear Strength (MPa)**	20 - 25

*ASTM D638

**ASTM D1002



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● CHEMICAL RESISTANCE

Excellent resistance to:

- Hydrocarbons
- Acids and Bases (pH 3-10)
- Salt Solutions

● HANDLING AND APPLICATION

MMA products are flammable. Keep containers closed after use. Gloves and safety glasses should be in use when applying the products in order to avoid skin and eye contact. In the case of skin contact, wash with soap and water. In the case of eye contact, flush with water for 15 minutes and seek medical attention. Harmful if swallowed. Keep out of reach of children. Avoid heat, sparks and open flames. See MSDS for detailed safety information.

Large amounts of heat can be generated when large masses of this product are combined at one time; the resultant heat generation can result in the release of trapped air, steam and volatile gasses. To avoid this, use only enough material as is required for the application and confirm gap thickness to no more than 4mm. Further application advice is available upon request.

● STORAGE AND SHELF-LIFE

Shelf life of MMA 715 base and activator (Parts A&B) are 9 months. Store between 12°C and 23°C. Do not freeze and avoid the temperatures above 35°C.

