

ACRY-TRON 1E1

LOW ODOR TOUGHENED ACRYLIC STRUCTURAL ADHESIVE

• PRODUCT DESCRIPTION

Acry'tron 1E1 is a 100% solid, high performance acrylic based structural adhesive with low odor and bake proof high temperature resistance. Acry'tron 1E1 has an excellent flexibility which tolerates different coefficient of thermal expansion of dissimilar substrates. Very good at heat resistance. MMA free, low hazard formula. 1E1 can be used with mixing tips or bead on bead.

• RECOMMENDED SUBSTRATES

Steel	Polyester	Wood	Ferrite
Aluminium	Hard PVC	Glass	Acrylic
Copper	ABS	Stainless Steel	Coated Metals
STYROL	Stone	Brass	Epoxy
FRP	Concrete	Nickel	Zinc
GRP	Zinc Chromate	Chrome	

• UNCURED PROPERTIES

Base	Acrylic
Color	Brownish Green
Mixing Ratio	1:1
Viscosity	10000 cps
Density (g/cm ³)	1,1
Flash Point (°C)	>101
Working Time	5 min.
Fixture Time	8 – 12 min.
Functional Strength	2 hours
Full Cure	18 hours

• CURED PROPERTIES

Hardness (Shore D)	55
Temperature Resistance (°C)	-40 to +220
Shrinkage (%)	7 - 8
Lap Shear Strength (Steel/Steel) (MPa)	28,9
Lap Shear Strength (Al/Al) (MPa)	20
Lap Shear Strength (SS/SS) (MPa)	23,5
Lap Shear Strength (Secc-P/Secc -P) (MPa)	28,5
T-Peel Strength (Secc-P/Secc -P) (kN/m)	9,5

• STORAGE AND SHELF-LIFE

Shelf life of Acry'tron 1E1 base and activator (Parts A&B) are max. 12 months. Store between 8°C and 18°C.

