

**ADHESIVE DESCRIPTION**

ACRALOCK SA10-05A, SA10-10A, SA10-20A are three similar base methacrylate adhesives (Component A), that only differ by working time ranges. Formulated to use with an activator (Component B) and mixed at 10:1 ratio. The SA10-05A is used for 5 minute, SA10-10A for 10 minute and SA10-20A for 17 minutes working times based on ACT-1B. These products are designed with low boiling tendencies and high strength to adhere to assemblies of thermoset composites, plastics and are formulated to be primerless on most metal surfaces (see all notes on back). ACRALOCK adhesives, manufactured by Engineered Bonding Solutions, LLC., are packaged in 490ml dual cartridges as well as 5 & 50-gallon containers for application with meter-mix dispensing equipment.

**KEY FEATURES**

- Easy 10:1 Mix Ratio
- SA10-05A working time range from 4-6 min
- SA10-10A working time range from 8-12 min
- SA10-20A working time range from 15-20 min
- 3000psi shear strength and up to 120% elongation
- Little to no surface preparation
- Primerless on most metals
- Good Chemical Resistance
- Excellent fatigue characteristics and shock load resistance
- Stable formulations with shelf-life of 6 months

**SUGGESTED SUBSTRATES WE BOND**

Wood, Polyesters, Vinyl Esters, SMC, Epoxies, Acrylics, PVC/FPVC/CPVC, Polycarbonate, ABS, Styrenics, Stainless Steel, Carbon Steel, Aluminum, Coated Metals, Nylon, Galvanized Metals and many other composites, thermoplastics and metals!

**CHEMICAL RESISTANCE**

Cured Adhesive is generally resistant to intermittent exposures of salt solutions, hydrocarbons, acids and bases with a pH range from 3 to 10. See more important notes on chemical resistance on back page!

**TYPICAL ADHESIVE WET PROPERTIES**

| Property         | Comp A    | Comp 1B   | Mixed |
|------------------|-----------|-----------|-------|
| Color            | CREAM     | BLK       | BLACK |
| Viscosity (cP)   | 200K-400K | 100K-200K | -     |
| Mix ratio weight | 9.0       | 1         | -     |
| Mix ratio volume | 10 part   | 1 part    | -     |
| Density g/cc     | 1.008     | 1.116     | -     |
| WPG lb/gal       | 8.4       | 9.3       | -     |

**CARTRIDGE CODE – WORKING TIME (min)**

| ADHESIVE →          | SA10-05A          | SA10-10A          | SA10-20A          |
|---------------------|-------------------|-------------------|-------------------|
| ACTIVATOR ↓         |                   |                   |                   |
| ACT-1BBLK           | <b>SA10-05BLK</b> | <b>SA10-10BLK</b> | <b>SA10-20BLK</b> |
| <u>Working time</u> | 4-7               | 8-12              | 15-20             |
| <u>Fixture time</u> | 8-12              | 16-24             | 30-40             |

ACT-1B OWT, ACT-2B OWT are also available (10.55 LB/GAL).  
 See Representative for additional details.

**CURED PHYSICAL PROPERTIES**

|                                     | Typical Values<br>psi (MPa) |
|-------------------------------------|-----------------------------|
| Tensile strength                    | 2,300- 2,800 (19.3)         |
| Modulus kpsi                        | 60- 90 (620)                |
| Elongation (max. %):                | 80-120                      |
| Lap Shear Aluminum, ASTM D1002      | 2,500- 3,000 (20.7)         |
| Lap Shear Stainless, D1002          | 2,400- 2,900 (19.3)         |
| Lap Shear Cold Rolled Steel, D1002  | 2,400- 2,900 (18.6)         |
| Lap Shear Pultrusion-FRP psi, D5868 | 2,500- 3,000 (20)           |

**NOT RECOMMENDED FOR BONDING** Polyolefins-TPO's, Polyacetals and PTFE

**TEMPERATURE EXPOSURE**

Temperature range for this product is from -40 to 180 °F (-40 to 82 °C), with intermittent exposure between -67 to 250°F (-55 to 121 °C)

**SEE IMPORTANT INFORMATION AND NOTES ON PAGE 2!**

**IMPORTANT INFORMATION**

ACRALOCK is a trade name of Engineered Bonding Solutions, LLC (hereinafter referred to as "EBS"). All ACRALOCK 10:1 adhesives (Component A) are flammable and corresponding activators (Component B) is classed as a non-hazardous. The use of proper PPE (Personal Protective Equipment) is strongly recommended; wear gloves and safety glasses to avoid skin and eye contact, harmful if swallowed and please always refer to both TDS and SDS before using any ACRALOCK adhesive product. Questions relative to handling and applications should be directed to 1-855-411-GLUE or email us at [info@acralock.com](mailto:info@acralock.com)

Adhesives are supplied in dual component cartridges, 5 gallon pails and 50 gallon drums to facilitate mixing through approved stainless steel meter mix dispensing equipment. Always use a static mixer with sufficient elements to ensure a homogeneous mix. We do not recommend mixing by hand. Please contact your EBS representative for questions about dispensing equipment manufacturers and approved seal and gasket materials. Automated equipment should be constructed of stainless steel. An exothermic chemical reaction occurs when components A and B are mixed and will generate heat. The amount of heat generated is relative to amount of mass of mixed product and also the working time of the Components A and B (or more relative to reactivity of product). Generally, faster curing products applied in larger beads or mixed left into large quantities can cause rapid boiling of monomers under excessive heat of reaction. These vapors are flammable or harmful if inhaled. Avoid sanding, grinding on cured adhesives (cut or scrape instead), which can produce noxious smoke that could contain harmful constituents, in this case consider a forced air breathing apparatus (PPE). After proper mixing of components, the VOC content of cured product will be less than 20 g/L (0.17 lbs/gal).

Use sufficient material to ensure the joint is completely filled when parts are mated and clamped. All adhesive application, part positioning, and fixturing should occur before the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. The working time is the approximate time that the adhesive remains fluid and will still wet the surface of the adherend after mixing component A (adhesive) and component B (activator). The fixture time is the approximate time after mixing the two components that will allow the parts to be moved or unclamped. However both working time and fixture times will increase or decrease depending on ambient temperatures and thickness of application. Thin applications in colder conditions can substantially increase fixture time. The reported data presented in the TDS are based on tests conducted under laboratory conditions of 75°F/24°C. For applications in hot or cold ambient conditions, please contact your EBS representative. Clean-up is easiest before the adhesive has cured Citrus terpene or N-methylpyrrolidone (NMP) containing, polar solvents, ketones. Avoid contaminating wet adhesive cosmetic surfaces with these cleaners, use masking tape and remove after applying while wet. If the adhesive is already cured, careful remove by scraping with a sharp tool, followed by a solvent wipe may be the most effective method of clean-up.

**IMPORTANT NOTES:**

**Surface Preparation:** The need for surface preparation must be determined by the user based on comparative testing of unprepared and prepared substrates to determine if strengths are adequate for application. Clean adhesive failure is not desired for long-term durable performance. In all cases initial shear strength tests must be followed up with simulated or actual durability tests to assure that surface conditions do not lead to degradation of the bond over time under service conditions. Subsequent changes in substrates or bonding conditions will require re-testing.

**Most thermoplastics** listed above can be bonded with no surface preparation other than a dry wipe or air blow-off. If contamination is visible or suspected, wipe with alcohol prior to bonding. Low surface energy plastics like polyolefins, thermoplastic polyesters and fluorocarbon plastics are generally not bondable.

**Metals** as received aluminum and stainless steel are bondable without preparation, EBS strongly suggest only using faster curing versions with working times less ≤ 40 minutes, if bonding metal to metal in thin bond gaps ≥ .015" Bond Gap must be maintained with standoff or spacers. Clean with IPA wipe, if not "as received", Cold rolled steel, carbon steel or other metals should be sanded to remove rust, oxidation or scale for better performance. EBS also manufacturers a product, **AP-1** (alcohol based cleaner/primer available in 500ml bottles), which will improve bond performance and durability on metals. Electrodeposited galvanized adhesion can also be improved with AP-1.

**Thermoset** composites are generally bonded without preparation, however mold releases and process can produce varied bonding performance and testing should be performed.

**Elevated temperature** cohesive strength at 180°F retains a minimum of 500 psi as measured on aluminum. Bonds can be exposed to intermittent temperatures up to 250°F, provided at the higher temperature range bonding assembly is in a fixture and not under shear load. User must determine suitability for all applications and operating conditions.

**Chemical Resistance** EBS strongly recommends laboratory and end-use testing representative of the environmental conditions and how the bonded assembly will be used. Bonds are generally resistant to the effects of heat, water and moisture, aqueous chemicals and some intermittent exposure of gasoline, motor oil and diesel fuel. Not recommended for immersion or long term exposure to all hydrocarbons, concentrated acids or bases, or aggressive organic solvents such as toluene, ketones, and esters.

**The shelf life** of Components A and B in unopened containers is approximately six months from the date the product is manufactured from EBS facilities. Shelf life is based on steady state storage between 55°F and 80°F (13°C and 27°C). Exposure, intermittent or prolonged, above 80°F/27°C will result in a reduction of the stated shelf life. Shelf life of both components can be extended by air-conditioned or refrigerated storage between 55°F and 65°F (13°C and 18°C).

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