

PRODUCT INFORMATION

AT-2010



Fast Cure 2-comp. Methyl Methacrylate Structural Adhesive - 1:1

AT-2010 is a high performance adhesive engineered to bond a wide range of plastics, metals and composite assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. AT-2010 holds Weld Mount parts in position without sagging and its 5 minute fixture time makes it ideal for production applications.

- Minimal Surface Preparation
- 100% Reactive
- Impact Resistance
- Gap Filling To 9 mm
- Excellent Strength
- Room Temperature Cure
- Easily Applied

TYPICAL UNCURED PROPERTIES

Property	
Viscosity (mixed)	85,000—125,000 MPa*s
Specific Gravity	1.04 g/cm ³
Colour	Off White/ Light Yellow
Mix Ratio	1 : 1
<small>Applies to both the adhesive and activator sides</small>	

TYPICAL CURED PROPERTIES

Property	
Shore D Hardness	65
Thermal Service Range	-55 °C to +105 °C
Gap Fill	9 mm
Tensile Strength	26-28 N/mm ² on steel
Shear Strength	18-24 N/mm ² on steel
Working Time	3 - 4 minutes
Handling Strength	20 min for 75% Overall Strength

SUITABLE SUBSTRATES

Metals	Thermo Sets	Thermo Plastics
Aluminum Steel Stainless Steel Coated Metals	Fiberglass Phenolics Gel Coats Epoxy Rim Urethane Polyurethane	Acrylics ABS Polycarbonates Nylons PPO's PVC's
Others Concrete Brickwork	Liquid Molding Resins SMC	Stryrene's PBT Blends PET Blends

AT-2010

INSTRUCTIONS FOR USE

Preparation

For the highest strength bonds, all surfaces should be clean, dry, and free of contamination. Extensive surface preparation is not required for **AT-2010** and good bonds can be formed on most substrates after a solvent wipe. However we recommend that metal surfaces (particularly aluminum) be given a scotchbrite cleaning to remove surface oxidation to achieve the highest bond strengths.

It is highly recommended that either meter mix equipment or cartridges with static mix nozzles be used to properly ratio and dispense the adhesive. For hand mixing, combine Part A and Part B in the correct ratio and mix thoroughly. Heat buildup during and after mixing is normal. To reduce the likelihood of exothermic reaction or excessive heat buildup, mix less than 100 grams at a time. Mixing smaller amounts will minimize heat buildup.

Bonding

For optimum bond strength and to insure maximum performance in the finished assembly mate parts together within the specified working time of the adhesive (3 - 4 Minutes). Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work time for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the joint is sufficiently cured.

Consumption

parts / 50 ml cartridge AT-2010 (approx):

AT-3	350
AT-5	225
AT113	50
M4, M5, M6 studs	75
M8, M10 studs	35

CLEANING

Koerasolv PU, Koerasolv GL

It is important to remove excess adhesive from the substrate before it is cured. Solvent cleaners such as alcohol or acetone yield good results. Once the adhesive has cured it will be very difficult to remove and may require as much as 180°C to soften to allow removal.

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This product information replaces all previous issues.

SPECIAL NOTES

Storage

The shelf life of **AT-2010** is one year from the date of manufacture which is indicated on the cartridge when refrigerated at 4,4 degrees C. Shelf life is 6 months from the date of manufacture when the product is stored properly at a temperature no greater than 22°C. Exposure to temperatures above 22°C will reduce the shelf life of the product. AT-2010 should never be frozen.

SAFETY

Please notice the indications on our EC-safety-data-sheets and the safety-indications on the labels of each product for the treatment of our products.

Especially the directions of the Dangerous Substance Regulation have to be respected.

Keep the EC-safety-data-sheet of the product you treat ready to hand. It gives you valuable indications for the safe usage, disposal and in case of accidents.

PACKAGING UNITS

50 mL cartridge. Special packaging is available on request.