

ACRALOCK[®]

Engineered Bonding Solutions

ACRALOCK Structural Adhesives by Engineered Bonding Solutions are advanced two component primerless methacrylate structural adhesives designed to bond chemically to most surfaces, providing a permanently locked or integrated assembly of steel, aluminium, engineered plastics, high performance composites and other materials in mix ratio 1:1 and 10:1.

ACRALOCK Structural Adhesives, mix ratio 10:1

10:1 Products are available as: 200 l drum | 20 l pail | 490 ml cartridge | 50 ml cartridge

ACRALOCK SA 10 LV series are advanced, two component, 10:1 mix ratio, high shear strength coupled with excellent toughness, medium elongation primerless metal bonding adhesives.

SA 10 LV series is available in different adhesive and activator combinations to achieve a wide range of working times starting from 5 min on up to 35 min in various colors and is designed to bond as received aluminum and stainless steel without primers and with minimal to no other surface preparation.

Acralock SA 10 LV series is Marine certified and R1, HL3 fire approved according EN 45545 - 2.

ACRALOCK SA 10 UV series are advanced, two component, 10:1 mix ratio, high shear strength coupled with excellent toughness, medium elongation UV color stabilized white adhesives.

SA 10 UV series is available in two different working times of 15 and 40 min, is formulated bright white with UV stabilizers to resist fading in environmental conditions and designed to bond as received aluminum and stainless steel without primers with minimal to no other surface preparation.

Acralock SA 10 UV series is Marine certified.



ACRALOCK SA 10 HV series are advanced, two component, 10:1 mix ratio, high shear strength coupled with excellent toughness, high elongation primerless metal bonding, high gap fill adhesives. SA 10 HV series is available in different adhesive and activator combinations to achieve a wide range of working times starting from around 30 min on up to 120 min in various colors and is designed to bond as received aluminum and stainless steel without primers and with minimal to no other surface preparation as well as being able to fill low to high bonding gaps. Acralock SA 10 HV series is Marine certified.

ACRALOCK SF 10 series are advanced, two component, 10:1 mix ratio, medium shear strength coupled with excellent toughness, high elongation of > 250 %, primerless metal bonding adhesives.

SF 10 series is available in three different working times of 5, 10 and 30 minutes in various colors and is designed to bond as received aluminum and stainless steel without primers and with minimal to no other surface preparation.

Acralock SF 10 series is R1, HL3 approved according EN 45545 - 2.

ACRALOCK FA 10 series are advanced, two component, 10:1 mix ratio, low shear strength coupled with excellent toughness, high elongation of around 350 %, primerless metal bonding adhesives. FA 10 series is available in three different working times of 5, 10 and 30 minutes in various colors and is designed to bond as received aluminum and stainless steel without primers and with minimal to no other surface preparation.

ACRALOCK GB 10 series are advanced, two component, 10:1 mix ratio, very low shear strength coupled with excellent toughness, high elongation of around 400 %, primerless metal bonding and glass bonding adhesives. GB 10 series is available in three different working times of 5, 10 and 30 minutes in various colors and is designed to bond as received aluminum and stainless steel without primers and with minimal to no other surface preparation.

ACRALOCK CC 10-10 is an advanced, two component, 10:1 mix ratio, crystal clear adhesive. CC 10-10 CLR is available in 5 min working time and designed to bond as received clear and other coloured plastics like PMMA, PETG, PC, PVC and others with no surface preparation for all applications where a crystal clear appearance of the bondline is necessary.



| Product | Description | Colour | Mix Ratio | Viscosity (Pas) | Working Time (min) | Fixture Time (min) | Gap Fill (mm) | Tensile Strength (MPa) | Tensile Elongation (%) | Lap Shear Strength (MPa) |
|---|--|--------------------|-----------|--------------------------------|--------------------|--------------------|---------------|------------------------|------------------------|--------------------------|
| SA 10 LV series, 10:1 ratio, primerless metal bonding, low viscosity structural adhesive series | | | | | | | | | | |
| SA 10-05 | Universal Primerless Metal Bonder | black off white | 10:1 | A: 200 - 500 B: 80 - 200 | 4 - 7 | > 15 | 0,5 - 10 | 18 - 21 | 80 - 120 | 18 - 22 |
| SA 10-15 | | black off white | 10:1 | A: 200 - 500 B: 80 - 200 | 12 - 16 | > 30 | 0,5 - 12 | 18 - 21 | 80 - 120 | 18 - 22 |
| SA 10-35 | | black | 10:1 | A: 200 - 500 B: 80 - 200 | 30 - 35 | > 60 | 0,5 - 12 | 18 - 21 | 80 - 120 | 18 - 22 |
| SA 10 HV series, 10:1 ratio, large gap fill, high viscosity structural adhesive series | | | | | | | | | | |
| SA 10-35 HV | High Gap Fill Marine Adhesive Primerless Metal Bonder | black off white | 10:1 | A: 800 - 1.200 B: 100 - 200 | 30 - 40 | > 60 | 0,5 - 20 | 16 - 19 | 150 - 200 | 16 - 19 |
| SA 10-60 HV | | black grey | 10:1 | A: 800 - 1.200 B: 100 - 200 | 50 - 65 | > 120 | 0,5 - 30 | 16 - 19 | 150 - 200 | 16 - 19 |
| SA 10-70 HV | | grey black | 10:1 | A: 800 - 1.200 B: 100 - 200 | 65 - 80 | > 150 | 0,5 - 30 | 16 - 19 | 150 - 200 | 16 - 19 |
| SA 10-100 HV | | grey | 10:1 | A: 800 - 1.200 B: 100 - 200 | 80 - 100 | > 180 | 2 - 50 | 16 - 19 | 150 - 200 | 16 - 19 |
| SA 10-120 HV | | grey | 10:1 | A: 800 - 1.200 B: 100 - 200 | 110 - 130 | > 300 | 2 - 50 | 16 - 19 | 150 - 200 | 16 - 19 |
| SA 10 UV series, 10:1 ratio, UV stable white coloured, medium viscosity structural adhesive series | | | | | | | | | | |
| SA 10-15 UV | Medium Gap Fill | white | 10:1 | A: 200 - 400 B: 100 - 200 | 15 - 20 | > 30 | 0,5 - 10 | 15 - 18 | 125 - 150 | 18 - 21 |
| SA 10-40 UV | UV white | white | 10:1 | A: 200 - 400 B: 100 - 200 | 40 - 50 | > 80 | 0,5 - 15 | 15 - 18 | 125 - 150 | 18 - 21 |
| SF 10 series, 10:1 ratio, flexible, medium strength, medium viscosity structural adhesive series | | | | | | | | | | |
| SF 10-05 | Medium Gap Fill | black off white | 10:1 | A: 300 - 500 B: 100 - 200 | 4 - 7 | > 15 | 0,5 - 15 | 10 - 11 | 250 - 300 | 10 - 11 |
| SF 10-10 | Flexible | grey | 10:1 | A: 300 - 500 B: 100 - 200 | 8 - 10 | > 20 | 0,5 - 15 | 10 - 11 | 250 - 300 | 10 - 11 |
| SF 10-30 | Medium Strength | black off white | 10:1 | A: 300 - 500 B: 100 - 200 | 30 - 35 | > 60 | 0,5 - 20 | 10 - 11 | 250 - 300 | 10 - 11 |
| FA 10 series, 10:1 ratio, very flexible, low strength, medium viscosity structural adhesive series | | | | | | | | | | |
| FA 10-05 | Medium Gap Fill | black | 10:1 | A: 300 - 500 B: 100 - 200 | 4 - 7 | > 15 | 0,5 - 15 | 6 - 8 | 350 - 400 | 6 - 7 |
| FA 10-10 | Very Flexible | grey | 10:1 | A: 300 - 500 B: 100 - 200 | 8 - 10 | > 20 | 0,5 - 15 | 6 - 8 | 350 - 400 | 6 - 7 |
| FA 10-30 | Low Strength | black | 10:1 | A: 300 - 500 B: 100 - 200 | 30 - 35 | > 60 | 0,5 - 20 | 6 - 8 | 350 - 400 | 6 - 7 |
| CC 10 series, 10:1 ratio, crystal clear, very low viscosity structural adhesive series | | | | | | | | | | |
| CC 10-10 | Crystal Clear Plastic Bonder | clear | 10:1 | A: 20 - 25 B: 10 - 15 | 4 - 6 | > 60 | 0,1 - 2 | 9 - 11 | 10 - 15 | 9 - 11 |