

**Product Description**

**MXCRYL<sup>®</sup> 330** is designed as a general-purpose adhesive that can be used for many bonding applications such as wood, ceramic, metal and plastic materials

**MXCRYL<sup>®</sup> 330** offers the following characteristics:

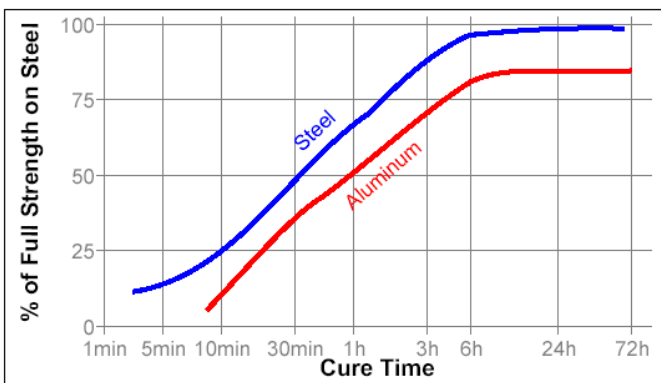
<b>Technology</b>	Acrylic
<b>Appearance (uncured)</b>	Slightly Cloudy, Colourless
<b>Chemical Form</b>	Urethane methacrylate ester
<b>Cure</b>	With activator
<b>Components</b>	Single – requires no mixing
<b>Viscosity</b>	High
<b>Application</b>	Bonding

**Properties of Uncured Material**

	Typical Value
Specific Gravity @ 25°C	1.05
Viscosity @ 25°C	40000 – 90000 mPas
Flash Point	See MSDS

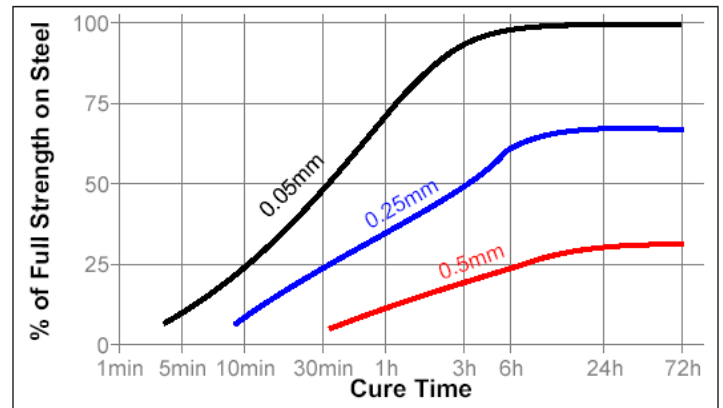
**Cure speed vs. substrate**

The rate of cure is dependant on substrate used. The graph below shows the shear strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587. (Activator applied to one surface)



**Cure speed vs. bond gap**

The rate of cure is dependant on the bond gap. The graph below shows the shear strength developed with time on grit blasted steel lap shears at different gap sizes and tested according to ISO 4587. (Activator applied to one surface)



**Typical performance of cured material**

Physical Properties	Typical Value
Coefficient of Thermal Expansion	80x10 <sup>-6</sup>
Coefficient of Thermal Conductivity	0.1

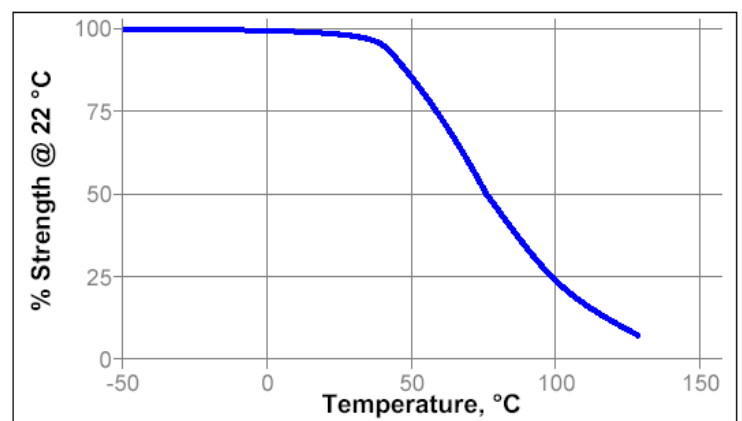
(After 24 hr at 20-25°C)

Adhesive Properties	Typical Value
Lap Shear Strength Activator on 1 side Mild Steel (grit blasted)	15 - 30 N/mm <sup>2</sup>
Tensile Strength Mild Steel (grit blasted)	12 - 22 N/mm <sup>2</sup>
Tensile Strength Activator on 2 sides Mild Steel (grit blasted)	≥16.5 N/mm <sup>2</sup>

**Typical heat resistance**

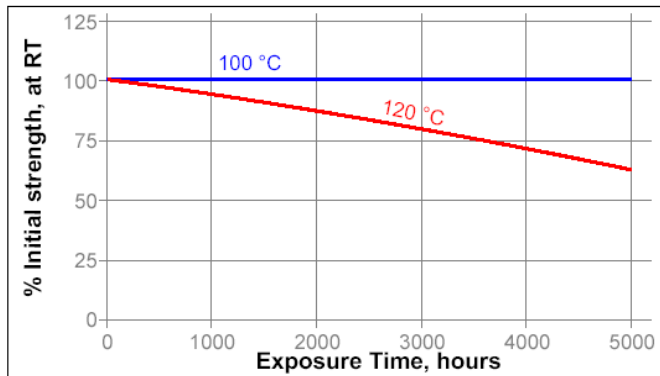
**Hot Strength**

Tested at temperature



## Heat aging

Aged at temperature indicated and tested at 22°C



## General information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidising materials.

**For information on the safe handling of this product, consult the Material Safety Data Sheet, (MSDS).**

Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics.

## Directions for use

1. For optimum performance surfaces should be clean and free of grease.
2. The recommended bond gap is 0.1mm. Where the bond gap is larger to a maximum of 0.5mm or a faster cure speed is required, activator should be applied to both sides of the material.
3. To ensure a reliable and fast cure, activator should be applied to one side of the material.
4. Bond should be held clamped until adhesive has fixture.
5. The product should be allowed to develop full strength before subjecting to loads (typically 24 – 72 hours depending on bond gap and ambient conditions)

## Precaution

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder.
3. Do not try to remove forcibly.

4. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
5. Keep well out of reach of children.

## Storage

Keep adhesive in a cool, dry place optimal storage 8°C-21°C. is recommended unless otherwise labelled. To prevent contamination of unused material, do not return any product to its original container. For specific shelf life information, contact Cartell UK Ltd.

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