



Key Features

- 4-5 minute handling time
- Suitable for metals & plastics
- Optically Clear
- Bonds acrylics & metals
- Thermal curing process

Stykra 4000

Clear Methacrylate Adhesive

Model No: GA4000

The Stykra 4000 is a fast acting 2-part methacrylate adhesive. Suitable for a wide range of material and part assembly. The rapid 4-5 minute handling time provides a fantastic benefit for assembly lines and fabrication work. Suitable for bonding all manner of materials including: Metals including aluminium, stainless steel, mild steel, polycarbonate and acrylic sheets. The optically clear properties lend the 4000 well to acrylic and built up letter fabrication.

Properties of uncured material

Item	Unit	Spec	Test Method
Resin	-	Methacrylate Blend	-
Appearance	-	Transparent Liquid	-
Viscosity	cps	10,000 cps	Spindle 6 @ 20rpm
Cure System	-	Exothermic	-
Open time	minutes	1-2	20°C 10g mass
Handling Strength	minutes	4-5	@ 20°C

Performance of cured material

Item	Unit	Spec	Test Method
Acrylic	N/mm ²	8.2	ASTM D1002 lapshear
Polycarbonate	N/mm ²	12.5	ASTM D1002 lapshear
Gap Fill	mm	3mm	-
Operating Temperature	°C	-55 to +125	-

Unless stated otherwise all values given are average. All of the adhesives in our range should be thoroughly tested on the substrates in the particular application they are intended for. Stykra will not be responsible for the product failure unless full testing has been completed. The customer has to decide on the tapes suitability for the intended purpose.