

PRODUCT

Purok® VX67-15 is a two component hybrid toughened structural methacrylate adhesive for bonding a wide range of solid surface materials, quartz, granite, natural stone, plastics and composites.



Characteristics

- Excellent adhesion.
- High durability.
- Excellent impact, peel and shear resistance.
- Non-sagging and thixotropic.
- Gap fill up to 2mm.
- Range of colours.
- Other cure profiles available.
- UV stable.

Applications

- Effective for bonding dissimilar materials e.g. bare metal, painted metal, plastics, glass and ceramics.
- Jointing of solid surface materials such as MMA cast resin, Quartz, Granite, natural stone and ceramic.

Technical characteristics

Base Material	Hybrid Methacrylate
Appearance	Various colours (adhesive) clear (activator)
Mix Ratio - By Weight	10:1
Working Time (min)	9 - 11
Fixture Time - Solid Surface MMA (min)	30 - 60
Fixture Time - Chipboard Core Solid Surface (hrs)	2
Full Cure (hrs)	24
Sandable After (mins)	30
Gap Fill (mm)	1 - 2
Density (g/ml)	1.03
Shear Strength (N/mm ²) ASTM D1002 - rate - 6mm/min	5 - 15
Shore D Hardness ±5	90
Viscosity C&P @ 1 s-1 (Pa.s)	15 - 20
Service Temperature (°C)	-40 to +120

(*) These values may vary depending on environmental factors, such as: temperature, moisture and type of substrates.

Packaging

Colour	Available in over 200 colours, but we can also make any bespoke colour matched to your substrate or colour reference.
Contents	50ml, 250ml, 490ml Cartridges, 18kg or 180kg drum.
Shelf life	18 months in unopened packaging, in a cool and dry storage place at temperatures between +10°C and +25°C. Prolonged exposure above +25°C will reduce the shelf life of this product. Shelf life can be extended by refrigeration (+7°C to +12°C). Do not freeze.

Substrates

Nature	Clean, dry, free of dust and grease.
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Application

Method	Using Manual or pneumatic applicator remove the resealable cap and pull trigger until both components are extruded at an equal rate, screw on a static mixer nozzle, Dispose of the first 2cm of mixed adhesive before applying. After application remove nozzle and replace cap. To restart repeat these instructions.
Application temperature	+5°C to +35°C.

Resistance to chemical agents

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis. Poor resistance to aromatic solvents, concentrated acids, chlorinated hydrocarbons.



Remarks, Disclaimer & Health and safety

Disclaimer - The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end user.

Health and safety - Refer to Safety Data Sheet (SDS) for further information. Apply the usual industrial hygiene. Always use in well ventilated areas. The mixing of the adhesive and hardener starts a chemical reaction which is exothermic (15mm thickness and greater can generate temperatures of over 120°C).

Reviewed November 2018

