



# Technical Datasheet M155



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### Product Description

M155 is produced in a two component transparent structural methacrylate adhesive, designed for the bonding of high strength plastic and composite applications. This grade is an advanced liquid composite, which combines shock resistance and toughness from a unique blend of hybrid rubbers, with a high tensile shear strength from an innovative liquid plastic resin. Due to demand we produce this system in both a medium viscosity and high viscosity non slump version. Once bonded this fusion of chemistries achieves an ultra high strength bond with excellent chemical and environmental resistance.

### Typical Applications

M155 is very versatile, and can bond a wide variety of substrates to plastic without the need for surface primers or conditioners.

Typical examples shown below:

- Y Bonding acrylic letters in the sign industry.
- Y Bonding perspex in POS manufacture.
- Y Repairing polycarbonate headlights.
- Y Bonding outdoor lighting lenses and fixtures.
- Y Assembling electric meter housings and covers.

### Instructions For Use

- Y Always consult MSDS before using M155 for the first time.
- Y Carry out surface preparation where required. \*
- Y Remove cap, and attach mixer nozzle.
- Y Dispense sufficient adhesive to ensure equal mix.
- Y Apply adhesive to one surface and assemble components carefully, clamping if required.
- Y It is always easier to remove any excess adhesive prior to cure using a suitable cleaner \*
- Y Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

### Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Clear
Appearance	Transparent Liquid
Viscosity Brookfield T Bar	22,000 cps (MV System)
Viscosity Brookfield T Bar	150,000 cps (HV System)
Cure System	Exothermic
Open Time	1-2 Minutes @20°C
Handling Strength	3-5 Minutes@ 20°C

### Performance of Cured Material

ASTM D1002 Lapshear	Acrylic Plastic	8.2 Nmm2 **
ASTM D1002 Lapshear	Polycarbonate	12.5 Nmm2 **
Gap Fill	3mm	
Temperature Range	-55°C to 125°C	

### Packaging

M155 is available in 25ml, 50ml and 400ml Nylon cartridges for use with a dispensing gun.

### Storage & Shelflife

M155 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 6 month shelf life from manufacture.

### Health and Safety in Use

M155 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.

\*\* Total Substrate failure

The data, information and values contained in this Technical Data Sheet has been obtained by conducting various tests in a controlled laboratory environment, and should be used for guidance purposes only. Although we believe them to be reliable and accurate, users should always conduct their own tests in their specific working conditions to ensure that the product is suitable and effective for use. It is the users sole responsibility to determine the suitability of the product for the application. RiChem Products cc cannot be held responsible for the results of procedures undertaken elsewhere, nor for the safeguarding of personnel or property, all of which is the duty of the user. Suitability of products or methods is discretionary. Therefore, warranties or implied usage obligations should not be attributed to, and are not the responsibility of, RiChem Products cc. RiChem Products cc are not liable for any financial loss or other damages incurred by the user as a result of the use of this product.