Unit 1, Coronation Business Park, Hard Ings Road, Keighley, West Yorkshire, BD21 3ND

VKTFCT2 2 Part Adhesive

Clear Toughened Acrylic for Plastics and Composites Fabrication

DESCRIPTION

Viking Thorflex CT2 a clear, low odour, toughened Acrylic adhesive is a fast, medium viscosity gel, ideal for the bonding of clear plastics within the sign/display and shopfitting market. 3004 combines the speed of the faster methacrylates with toughness, to enable bonding of similar and dissimilar materials which include most plastics (but not PP or PE's) composite materials such as PDCPD (Telene®), Vinyl Esters, Epoxy and Epoxy GRP, and the normal metals including Steel and Aluminium.

CT2 has a short dwell time ($2\frac{1}{2}$ - 3 minutes) in the mix nozzle, and cures to give a fixture time in around 5 minutes. Full cure can usually be achieved in 8 – 12 hours, extended in cold conditions and similarly accelerated in warmer environments.

Available in 50ml cartridges (and 20kg and 180kg bulk containers for automated dispensing), Viking Thorflex CT2 is ideal for bonding small to medium sized components, including the bonding of glass and transparent plastics found in POS displays, boxes, shelves, lecterns and trophies etc. It may also be used to form discrete bonds on 'Solid Surface' materials, stone and wood. It has high vibration and impact resistance, and produces a low exotherm on curing, making it highly suitable for the bonding of thin gauge materials or Alucobond® without causing surface distortion. In White Goods manufacture, CT2 is RoHS compliant and meets the requirements of WEEE.



UNCURED PROPERTIES

Resin Methacrylate Blend
Hardener Amine Accelerated Resin
Viscosity A <30,000cps
Viscosity B <25,000cps
Specific Gravity 0.99 Part A 0.98 Part B

Mix Ratio Equal 1/1 mix
Flash Point <12°C
Peak Exotherm <89°C

CURED PROPERTIES

Mix In nozzle dwell <3 minutes
Gel Time >3 minutes
Fixture Time <5 minutes

Colour Thin Films: Transparent
Thick Films: Semi Transparent

Gap Fill 0.5mm maximum 0.25mm-0.5mm typical

TYPICAL BONDED PROPERTIES

Test method ASTM D1002

<12N/mm²

<3 N/mm²

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Polycarb

Steel

Aluminium	Substrate Failure	<14N/mm ²	
Plastics			
Perspex®	Adhesive Failure	<5 N/mm ²	
Hard PVC	Sub/Coh Failure	<5 N/mm ²	
ABS	Sub/Coh Failure	<4 N/mm ²	
Ероху	Adhesive Failure	10 N/mm ²	
Phenolics	Sub/Coh Failure	<7 N/mm ²	
PDCPD	Adhesive Failure	<10N/mm ²	

Cohesive Failure

Adhesive Failure