

Lockfast® LF121 Pink & Green

LF121 Pink & Green is a two-part toughened acrylic structural adhesive that cures fast. Almost any material can be bonded, including metals, plastics, glass, wood, concrete, GRP, modern composites, stone, jewels, and many others. You can apply it directly from the cartridge as two overlapping beads, or you can fit a mixer nozzle to the cartridge for more critical applications. It takes approximately 3 to 5 minutes for LF121 to reach handling strength, and one hour for it to cure completely. Prior to bonding, both surfaces should be lightly abraded to remove any dirt and debris, and cleaned with isopropyl alcohol to ensure best results. Temperatures between -55°C and +125°C can be tolerated, but prolonged exposure to water is not recommended.

Application

Use on clean, dry substrates between +10°C and +30°C for best results. Using the applicator gun, insert the cartridge into the slot. Before attaching the mixing nozzle, remove the cartridge cap and level the pistons by dispensing a small amount of material. The mixing nozzle should be attached and adhesive should be dispensed until the colour is uniform. After applying the mixed adhesive to one joint surface, bring the two surfaces into contact and apply steady pressure. Re-sealing the cartridge is possible if it has only been partially used by removing the mixing nozzle, cleaning the two cartridge openings, and replacing the cartridge cap.

Strength

The Table below shows the test results obtained after the following surface preparation.

Steel: polished with emery paper, washed with acetone and dried in a desiccator for 24 hours. Other metals tested were washed with trichloroethylene or acetone and dried in a desiccator for 24 hours. Plastics were washed with methanol and dried in a desiccator for 24 hours.

Material	Tensile Shear Kg/cm ²
Steel / Steel	276
Zinc Chromate / Zinc Chromate	180
Nickel / Nickel	193
Chrome / Chrome	162
Brass / Brass	228
Stainless Steel / Stainless Steel	204
Copper / Copper	244
Aluminium / Aluminium	224
Zinc / Zinc	214
Polyester / Polyester	31
Styrol / Styrol	24
ABS / ABS	47
PA-6 (Nylon 6)	20
Glass	50

Characteristic	Adhesive Part	Activator Part
Adhesive	Methyl methacrylate	
Appearance	Translucent Grey (when mixed)	
Specific Gravity 25°C	1.01	
Viscosity 25°C	3000 mPas	
Handling strength	3-5 minutes depending on ambient conditions	
Full strength	1 Hour	
Operating Temperature	-55°C to +125°C	

Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range.

Important Note

Whilst all reasonable care is taken in compiling technical data on the company's products, all recommendations or suggestions regarding the use of such products are made without guarantee, since the conditions of use are beyond the control of the Company. It is the customer's responsibility to satisfy himself that each product is fit for the purpose for which he intends to use it, that the actual conditions of use are suitable and that in the light of continued research and development the information relating to each product has not been superseded.

SCAN FOR SAFETY DATA SHEET

