Technical Data Sheet

PRODUCT SPECIFICATION

404P-2

Structural Adhesive

Description:

Engineered specifically for low surface energy plastics, this structural adhesive bonds polyolefins—including polypropylene (PP), polyethylene (PE), and thermoplastic olefins (TPO)—without requiring chemical or surface pretreatment. It overcomes the non-polar, non-porous, and inert nature of these materials to deliver robust structural joints, addressing the demands of advanced plastic co-polymer and alloy assemblies. Low surface energy plastics: Polypropylene (PP) Polyethylene (PE) and other Thermoplastic Olefins (TPO), commonly known as Polyolefins..

Typical Properties of Cured/Uncured Material:

Properties			
Base	Methacrylate	**Shore D Hardness**	55
Appearance	Off White		
Temperature Range (°C)	-40 to 140		
Shelf Life (Months)	6		
Handling Time (Mins.)	20		
Working Time (Mins.)	4		
Mix Ratio	1:1		

	Part A	Part B
Viscosity	170000	170000

Bond Strength:

(Cured for 24 hours at 20-25°C)

Strength	
Tensile Strength (N/mm2)	13
Lap Shear Strength (N/mm2)	8

Directions For Use:

1. Always consult SDS before using for the first time.
2. Carry out surface preparation where required.
3. Remove nut, attach mixer nozzle and replace nut.
4. Dispense sufficient adhesive to ensure equal mix and uniform colour.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner.
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

Curing Cycle:

At a 1:1 mix ratio, open time depends on temperature, volume, and substrate due to the adhesive's exothermic cure reaction. Higher ambient temperatures and larger mass volumes accelerate curing to reduce working time, whereas lower temperatures and smaller masses extend both open and full cure times.

Storage:

The product should be stored unopened in suitable hazardous storage conditions for adhesives in a cool, dry location and out of direct sunlight.

Precaution:

Structural methacrylates should not be used without consulting the SDS, 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.

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