



# SAF 30 LOT

## TWO COMPONENT METHACRYLATE



### KEY FEATURES

- High temperature and impact resistance
- Metal Bonding
- Non-sag, application on vertical surfaces
- Permanent toughness even after ageing
- Minimal surface preparation
- Long open time

### DESCRIPTION

The SAF range is made of patented methacrylate adhesives and shows unmatched performance in term of resistance and flexibility. These adhesives have been designed for bonding a wide range of dissimilar substrates including metals and plastics as well as composite materials for industrial applications. The outstanding properties of the SAF range allow structural bonding while keeping flexibility and fatigue resistance.

The SAF range products have been developed to resist the most aggressive environments and extreme temperatures. It shows unprecedented results facing weathering and ageing.

### RANGE OF APPLICATION

The SAF 30 LOT is recommended for the followed substrates:

Steel	Polyester	PVC
Stainless Steel	Elium	ABS
Powder coated steel	Vinyester	PC
Aluminium	PMMA	PS

### PRODUCT CHARACTERISTICS

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Characteristics	SAF 30 LOT
System	Two component 10:1 Volume Ratio
Polymerization	Room Temperature
Operating temperature	-40°C to 150°C
Elongation	50 %

### ADHESIVE PROPERTIES

#### PHYSICAL PROPERTIES

PROPERTIES	SAF 30 LOT
Appearance	White
Density	1.14 Mixed
Viscosity at 23°C	A: 100000-200000 <sup>1</sup> Hardener B: 40000-80000 <sup>2</sup> Resin
Type	Non-sag

#### CURING PROPERTIES

PROPERTIES	SAF 30 LOT
Open time [min] @ 23°C (min)	90
Fixture time @ 23°C [min]	120
Full Cure [hours]	24

#### MECHANICAL PROPERTIES

PROPERTIES	SAF 30 LOT
Lap Shear strength [MPa] <sup>3</sup>	16
Tensile Strength at break [MPa] <sup>4</sup>	8-10
Tensile Modulus [MPa] <sup>4</sup>	180
Hardness [Shore D]	70-80
% elongation at break <sup>4</sup>	50

## WEATHERING AND AGEING RESISTANCE

### Lap shear strengths and weathering and ageing tests

Lap shear strength (MPa) regarding the accreditation ISO 4587 after cycle D3.

Cycle D3 NF EN ISO 9142 3 ageing cycles (72hours).

LAP SHEAR STRENGTH (MPa) <sup>4</sup>		
Substrates	Before ageing cycles	After ageing cycles
Aluminium 6060	16	16.9
Stainless steel	14.6	16
Steel	15	16.2
PMMA	Substrate failure	Substrate failure
ABS	Substrate failure	Substrate failure
FRP	Delamination failure	Delamination failure

## NOTES

1. Shear viscosity (Pa. s) 1 à 2s<sup>-1</sup>
2. Brookfield viscosity (mPa.s) mobile RV7 @10rpm
3. With ISO 45-87
4. With ISO 527-1A

## SURFACE PREPARATION

Use AEC T700 to remove grease, contamination or poorly adhering oxides from metal surfaces. Most plastics require a simple cleaning before bonding. Some may require sanding for better performances.

## PRECAUTIONS

Adhesive contains methacrylate monomers and is flammable. Materials must be stored in cool place away from sources of heat. During the polymerization, the chemical reaction causes a typical smell, please use the product in a well-ventilated area.

When the adhesive two components are mixed, an exothermic reaction can occur and generates heat. The amount of heat is dependent on the mass and thickness of the mixed product. It can reach a maximal temperature of 100°C.

Adhesives contain chemical materials, prevent contact with skin and eyes. In case with skin contact, wash with soap and water. In case of eye contact, flush with water and seek immediate medical attention. Do not swallow and keep away from children.

Read material Safety Data Sheet before handling or using this product.

## APPLICATION

The optimum qualities are obtained at room temperature, between 12°C and 35°C without post-curing.

Follow the instructions on the product operating guide or contact your Bostik representative for any information concerning product use, dispensing equipment or substrates application.

## STORAGE

The SAF 30 LOT shelf life is 9 months in unopened original packaging. The product may be stored in a closed container in a dry place at temperature between 15°C and 30°C.

Exposure to higher or lower temperature will result in a reduction of the stated shelf life.

## PACKAGING

The SAF 30 LOT adhesive is available in 490mL and 825 mL side by side cartridges, 20L buckets or 200L drums.

SAF 30 LOT 490mL cartridges require the use of MFX10-18 mixers. SAF 30 LOT 825mL cartridges require the use of MGK1420 mixers.

For packaging information please call your Bostik sales or technical representative.

## LIMITED WARRANTY

To the maximum extent allowed by law, Bostik disclaims all other express or implied warranties, including without limitation warranties of merchantability and fitness for a particular purpose. Unless otherwise stated in the limited warranty, the sole remedy for breach of warranty is replacement of the product or refund of the buyer's purchase price. Bostik disclaims any liability for direct, incidental, consequential, or special damages to the maximum extent allowed by law. Disclaimers of implied warranties may not be applicable to certain classes of buyers and some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days of discovery of a problem, and must be submitted with written proof of purchase.

### BOSTIK HOTLINE

Smart help +33 5 57 26 15 15

#### AEC Polymers

6 Rue Guy Pellerin  
33114 Le Barp, France  
[www.bostik.com/aecpolymers](http://www.bostik.com/aecpolymers)

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