



# VIKING

## Industrial & Safety Supplies

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# VKTFT3 2 Part Adhesive

## Mix in Nozzle or Bead on Bead Applied Acrylic

### DESCRIPTION

VKTFT3 a second generation Acrylic adhesive designed to combine the High Shear and Temperature resistance of a conventional acrylic with the qualities of a rubber toughened adhesive where High Peel and Impact Strength are a feature.

### APPLICATIONS

Bonds to a wide variety of materials such as Metals, Glass, Epoxy, Unsaturated Polyesters, GRP, Bakelite etc, and is supplied in our Equal Mix Ratio system syringe or cartridge and is produced in various other forms of packaging.

### USEFUL HINTS/NOTES

Can be applied from bottles 1:1 ratio and the cure time can be adjusted by variation of the ratio (3.2 max) without affecting the bond strengths after full cure.

### PROPERTIES

Is suitable for paint bake cycling to +180°C for typical coatings etc. Normal Acrylic operating limits recommended for continuous temperature exposure is -50°C to +130°C.

### INSTRUCTIONS FOR USE

Never mix a large volume of A and B together as an exothermic reaction generating great heat and fumes will result. Ensure parts are clean and dry, however it is tolerant of light oil films. It is sufficient to apply part A to one side and Part B to the other.

### PROCEDURE FOR APPLICATION

Using twin Syringe or Cartridge, affix Truflo nozzle and fit the cartridge to the gun in the usual manner. Where the adhesive is being applied by hand, simply apply bead on bead.

### TECHNICAL FEATURES

Resin: .....Methyl Methacrylate  
Colour A: .....Green  
Colour B: .....Pink  
Colour when mixed: .....Violet  
Cure Speed 1.1 mix.....< 2 minutes  
Cure Speed Ratios: .....2-7 minutes  
Viscosity: ..... 3500 cps + -500cps  
Gap Fill: .....<3 mm  
Flash Point: .....12°C  
Shelf Life (Bulk): ..... 9 months @ 20°C  
Specific Gravity: ..... 1.02 @ 20°C  
Operating Temperature: ..... -40°C to + 180°C .  
Max. Operating Temperature: ... + 200°C (Intermittent)  
Normal Operating Limits: ..... + 130°C (Continuous)  
Tensile Strength:.....16-22N/mm<sup>2</sup>

### CURED PERFORMANCE

Cure Time (50% Final Strength): . 1 hour  
Full Cure Time: ..... .6 hours  
Metal to Metal Strength: ..... Max20- 35 N/mm(2)  
Glass to Metal:.....16-22N/mm(2)

### STORAGE

Store in a cool, dark area out of direct sunlight.  
Shelf Life: 12 months @ 20°C.

### PRESENTATION

Syringe/Cartridge: ..... 24ml, 50ml, 400ml  
Bulk: ..... 2 x 2.5 Kg

### HEALTH & SAFETY IN USE

Limited exposure with Cartridge System.  
FLAMMABLE. Contains Methyl Methacrylate. Use adequate ventilation. Keep away from naked flames and welding stations where vapours may accumulate.  
IRRITANT: In case of contact with the skin, wash immediately with plenty of soap and water. Read full Health and Safety Data on VKTFT3