



# SAF 150-15

## TWO COMPONENT METHACRYLATE



### KEY FEATURES

- Excellent environmental resistance
- Permanent toughness even after ageing
- Minimal surface preparation
- Fast curing time
- High elongation and impact resistance
- Non-sag, application on vertical surfaces

### ADHESIVE PROPERTIES

### 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 150-15 is recommended for the followed substrates:

Steel	Aluminium	ABS
Stainless Steel	Elium	PC
Galvanized Steel	PMMA	PS
Powder coated steel	PVC	Glass

### PRODUCT CHARACTERISTICS

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Characteristics	SAF 150-15
System	Two component 10:1 Volume Ratio
Polymerization	Room Temperature
Operating temperature	-40°C to 150°C
Elongation	150 %

PHYSICAL PROPERTIES		
PROPERTIES	RESIN	HARDENER
Appearance	Off White	
Density	1.03	
Viscosity Brookfield at 23°C [mPa.s]	A: 90000-160000 <sup>1</sup> B: 40000-80000 <sup>2</sup>	
Type	Non-sag	

CURING PROPERTIES	
PROPERTIES	SAF 150-15
Open time [min]	7
Fixture time @24°C [min]	15
Full Cure [hours]	24

MECHANICAL PROPERTIES	
PROPERTIES	SAF 150-15
Lap Shear strength [MPa] <sup>4</sup>	16,0 CF
Tensile Strength at break [Mpa] <sup>3</sup>	8.0 – 10
Tensile Modulus [Mpa]	100-200
Hardness [Shore D]	60-65
% elongation at break <sup>3</sup>	150

**WEATHERING AND AGEING RESISTANCE**

LAP SHEAR STRENGTH (Mpa) <sup>4</sup>		
Substrates	Before ageing cycles	After ageing cycles
Aluminium 6060	16.0 CF <sup>5</sup>	17.0 CF
Aluminium 6061	15.0 CF	16.0 CF
Stainless steel	16.7 CF	17.5 CF
Steel	17 CF	18.0 CF
PMMA	Substrate failure	Substrate failure
ABS	Substrate failure	Substrate failure
FRP	10.0 delamination failure	10.0 delamination failure

**NOTES**

1. Brookfield viscosity (mPa.s) mobile T-D at 10trm
2. Brookfield viscosity (mPa.s) mobile RV7 @10trm
3. With ISO 527-IA
4. ISO 4587
5. CF: Cohesive Failure

**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 150-15 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 150-15 adhesive is available in 50mL and 490mL side by side cartridges, 20L pails or 200L drums.

SAF 150-15 50mL cartridges require the use of M5.4/16 mixers. SAF 150-15 490mL cartridges require the use of M10-18 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**

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