



HOLDIT[®]

**Technical Datasheet
HOLDIT M5060**

Revised Date: June 2011

Description

HOLDIT M5060 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications. M5060 has been formulated from innovative technology, including our revolutionary adhesive system. This unique system enables the M5060 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use. M5020 also resists most fuels, lubricants, cleaning chemicals and fluids.

Typical Applications

HOLDIT M5060 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners.

Typical examples shown below:

- Bonding blades in wind turbine industry
- Bonding large fibreglass mouldings
- Bonding automotive carbon fibre body panels.
- Bonding GRP in the marine industry.
- Bonding dissimilar metals for trailer fabrication.

Instructions for Use

1. Always consult the MSDS before using M5060 for the first time.
2. Prepare the surface where required removing oxides and scale.
3. Remove cap, and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
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 suitable cleaner.
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

Properties of Uncured Material.

Resin	Methyl Methacrylate
Colour	White UV Stable
Appearance	Thixotropic Gel
Viscosity Brookfield T Bar	300,000 to 450,000 cps
Cure System	Exothermic
Open Time	50 minutes @ 20°C
Handling Strength	60-80 minutes @ 20°C

Performance of Cured Material

ASTM D1002 Lapshear	Up to 30Nmm ²
ASTM D638 Tensile Strength	Up to 30Nmm ²
Gap Fill	6mm
Hardness	75 Shore D
Max Operating Temperature	-55°C to 120°C

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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Storage

HOLDIT M5060 should be stored unopened in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C.

This product has a 12 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT M5060 is available in 400ml cartridge.

Health & Safety in Use

HOLDIT M5060 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicology, Exposure Controls, Accidental Release and First Aid Measures essential to the safe use of this product.

Conversions

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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