



# Technical Datasheet A387

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## Description

Activator A387 must be used with each of the grades mentioned as it is an essential part B of the cure system of each of the specified products. Apply adhesive on one side and Activator to the other for porous surfaces. A light layer can be applied to both surfaces and adhesive can be applied to either and the bond made immediately. Bonds form in under 5 minutes @ 20°C. A faster A386 version is also available.

## Instructions for Use

1. Clean surfaces of any contamination such as excessive oil or loose oxide layers to obtain maximum strength, if the contaminants are not removed cure speed and bond strength will be affected.
2. Brush on Activator to one of the mating surfaces to be bonded. Apply the adhesive to the other.
3. Treat both sides with Activator if there are large gaps or a faster cure speed is required.
4. Bond assembly should be completed within 6 hours of application of the Activator. This is due to the Activator not drying and remaining active for 6 hours.
5. If Adhesive is applied to an activated surface. Assembly should be completed within 15 seconds.
6. Secure the assembly and await fixture before any further handling..

## Storage

Do not store this product near any oxidizing agents or combustible materials as this product is **HIGHLY FLAMMABLE**. Store this product in the unopened contained in a dark dry place. For optimal storage store at 8°C to 21°C. Storing above or below these temperatures and have adverse affects on the product properties.

## Product Features

|                  |                       |
|------------------|-----------------------|
| Solvent Base     | Heptane/Acetone       |
| Form             | Liquid Finger Pump    |
| Colour           | N/A                   |
| Vapour Pressure  | 35mmHg@20C            |
| Viscosity @ 25°C | N/A                   |
| Cure Speed       | V Fast, <90 -120 secs |
| Flash Point      | -10°C                 |
| Drying Time      | <30 secs (both)       |

## Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

## Health & Safety in Use

The Activator must be used in a manner applicable to highly flammable materials and in compliance with relevant local regulations. It is recommended to check all surfaces for compatibility before use as the solvent can affect certain plastics or coatings.

The use of this activator in pure oxygen or oxygen rich environments is not recommended.

Use in a well ventilated area.

For more handling safety information on this product, please consult the Material Safety Data Sheet. MSDS