

**BONDING +  
SEALING +  
ENCAPSULATION**

**Kisling**



# 1670

**Toughened, long pot life methacrylate (MMA) for large-area bonding applications. Fast strength build-up after an open time of approx. 20 minutes.**

1670 is a black, two-component methacrylate adhesive for the structural bonding of composite materials like CFRP, various thermoplastics and thermosets or metals.

Bonding of larger areas is possible thanks to its long open time of approx. 20 minutes - the very fast strength build-up allows short processing times.

Due to the black, glossy appearance also aesthetically demanding applications are possible without any postprocessing like overpainting (e.g. visible CFRP design parts).

# 1670

- + Ideal pot life for large bonding areas
- + Short fixture times thanks to fast strength build-up
- + Good adhesion to a wide range of materials
- + High toughness and elongation at break
- + 200 to 300  $\mu$  spacer for a defined bonding gap

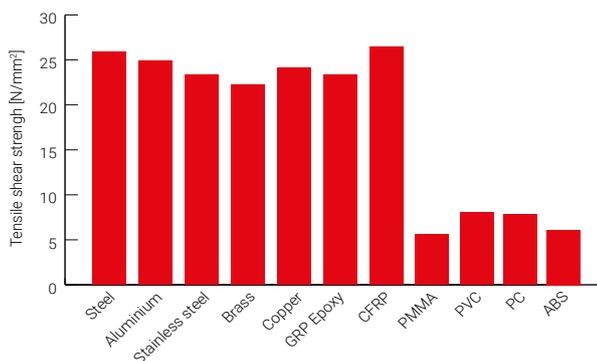


## Specifications

<b>Product category</b>	Methylmethacrylate structural adhesive
<b>Colour</b>	black (after cure)
<b>Mixing ratio</b>	10:1 (V:V)
<b>Viscosity [mPas]</b>	~100 000 thixotropic (Mix)
<b>Pot life [min]</b>	18 – 22
<b>Fixture time [min]</b>	40 – 50
<b>Final strength [h]</b>	~12
<b>Tensile strength [N/mm<sup>2</sup>]</b>	~18
<b>Tensile shear strength [N/mm<sup>2</sup>]</b> <b>Alu-Alu</b>	>20
<b>Tensile shear strength [N/mm<sup>2</sup>]</b> <b>Steel-Steel</b>	>22
<b>Elongation at break [%]</b>	~75
<b>Temperature range [°C]</b>	-55 – +120
<b>Container size (Bulk containers on request)</b>	50 ml   490 ml

## Tensile shear strength

Metals sand blasted, plastics cleaned



## Strength build-up

Steel sand blasted

