

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

Clip Bonder is a two-part methacrylate, structural rodding and clip bonding adhesive designed for the structural bonding of sink clips, steel and fiberglass rodding materials, and steel and aluminum to solid surface (acrylic and polyester), engineered stone, quartz surfaces, and natural stone products. Combined at a ratio of 1:1, Clip Bonder has a working time of 4 to 8 minutes and achieves nearly 90 percent of its ultimate strength in 10 to 15 minutes at room temperature curing. Clip Bonder provides high strength bonds to acrylic solid surface, polyester solid surface (both filled and unfilled), and alloy solid surface (combinations of both acrylic and polyester solid surface resins) and the steel clips, rods, fiberglass and other materials. Clip Bonder bonds very strongly to steel, stainless steel, and aluminum metals. Clip Bonder is NOT UV STABLE, AND WILL YELLOW OVER TIME and must not be used to create imperceptible seams in countertops. However, this yellowing will not affect bond performance, but will affect bond appearance.

- Vinegar
- Wine and Condiments
- Most Household Foods

PHYSICAL PROPERTIES:

Uncured	Resin	Activator
Viscosity (CPS)	30,000-50,000	70,000-100,000
Color	Translucent	Amber
Density (lbs/gal)	8.2	8.0
Mix Ratio (wt or vol)	1.0	1.0
Mixer Recommendation	Cartridge (50ml)	MBQ05-24L-Square 24 element
	Cartridge (400ml)	7701370 – Square 18 element

COMPANY IDENTIFICATION:

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CHARACTERISTICS:

Room Temp Properties

- Working Time 4 to 8 minutes (at 75°F/ 24°C)
- Fixture Time 10 to 15 minutes (at 75°F/ 24°C)
- Can be Moved 20 to 25 minutes
- Operating Temp 65°F to 85°F (18°C to 30°C)
- Gap Fill 7Star77 ing .250 inches
- Mixed Density 8.1 lbs/gal (.96 g/cc)
- Flash Point 51°F (11°C) – See MSDS for more safety information

CHEMICAL RESISTANCE:

Excellent Resistance to:

- Hydrocarbons
- Acids and Bases

Susceptible to:

- Polar Solvents
- Super Strong Acids & Bases

MECHANICAL PROPERTIES:

Tensile Strength (ASTM D638)	Substrate	Results	Failure Type
Strength, psi	Acrylic Solid Surface	2,500-3,000	Cohesive
Strength, psi	Polyester Solid Surface	2,500-3,000	Substrate
Strength, psi	Steel/Stainless Steel	2,800-3,500	Cohesive
Strength, psi	Aluminum	2,000-2,500	Cohesive

HANDLING AND APPLICATION:

Clip Bonder resin (Part A) and activator (Part B) are flammable. Contents include Methacrylate ester and acids. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of the reach of children. Keep away from heat, sparks, and open flames. Do not smoke cigarettes or anything else while handling or near

the product. Refer to the Clip Bonder Material Safety Data Sheet for more complete safety instruction. To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed. Components bonded, adhesive, and shop temperature can have a significant effect on the work and fixture time of the adhesive. Application of Clip Bonder adhesive at temperatures between 65°F and 85°F (18°C and 30°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure and fixture speed. Clip Bonder adhesives will still react, but will take longer. Temperatures above 85°F (18°C and 30°C) will increase cure and fixture speeds, and there's a risk that the adhesive will be hardened or too thick to bond materials. The viscosities of Clip Bonder adhesives are affected by temperature.

NOTE: Because of the rapid curing features of Clip Bonder adhesives, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from mixing large amounts of adhesive can result in a boiling of the monomer in the adhesive (methyl methacrylate), resulting in the release of trapped air, steam and volatile gasses. To prevent this, use only enough material as needed for use within the working time for the product, and confine the gap or spread out the material to no more than .250 inches.

HANDLING AND STORAGE

The shelf life of Clip Bonder is one (1) year from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of Clip Bonder in refrigerated compartments will extend the shelf life even more. Do not store Clip Bonder or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring Clip Bonder adhesives to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of Clip Bonder adhesives. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. Clip Bonder contains no

water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

ADDITIONAL INFORMATION

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USE ONLY WITH APPROVED EQUIPMENT**

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