

Product	Protac® 7300 Structural Acrylic
Description	Protac® 7300 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, thermoplastics, thermosets and composite assemblies.
Features	Combined at a 1:1 mix ratio, non-sagging thixotropic formulation. Excellent impact, peel and shear resistance. Excellent low and high temperature properties. Room temperature cure with short open time.
Applications	Ideal for bonding all types of PVC, Polycarbonate, Acrylic, Fiberglass, PBT, PPO, ABS, FRT, Polyurethane, Epoxy, Wood, RIM, Nylon, FRP, Polyesters, Gelcoats, Styrene, Stainless Steel, Carbon Steel, Galvanized Steel, Aluminium, etc. Ideal for automotive components, transportation industry, sporting goods, electronics parts, tool handles, appliances, computer assemblies, electrical components, furniture, marine assemblies, plastic fabrications, sign & Display, composite assemblies, etc.
Advantages	Little or no surface preparation. High resistance to hydrocarbon based fuels (petrol, jet fuel, motor oil, and hydraulic fluids).

Physical properties – uncured adhesive

Liquid	Adhesive	Activator
Appearance	Off-White	Off-White
Viscosity at 25°C, Brookfield RVT	50,000	50,000
Flash Point (TCC), °C	10.5	10.5
Density (gm/ml)	.97	.97
Mix Ratio by Volume	1.0	1.0

Physical properties – cured adhesive

Gap Fill	Up to 5mm
Shore Hardness, D	80
Elongation %	5-10
Adhesive Tensile Shear	
Steel/Steel	26 MPa
Aluminium/Aluminium	17 Mpa
PVC/PVC	Substrate failure
SMC/SMC	Substrate failure
ABS/ABS	Substrate failure
PMMA/PMMA	Substrate failure

Cure Characteristics	Working Time	4-6 minutes
	Fixture Time	12-15 minutes
	Functional Cure	1 – 3 hours
	Full Cure	24 hours
	Service Temperature	-40 °C to 120°C
Application	All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding. Proper mixing is required for the curing and adhesive strength development. Excess adhesive can be wiped away with organic solvents. Adhesive bond should be allowed to develop full strength before subjecting to any service loads.	
Packaging	Available in 50ml and 400ml cartridges. This product is also available in pails and drums to use with dispensing equipment.	
Storage	Store product in the unopened container in a dry location. Ideal storage temperature range is 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.	
Safety	Consult the Material Safety Data Sheet.	
Data ranges	The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and are verified on a regular basis.	
Notes	The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Novachem Corporation Limited and its agents cannot assume liability or responsibility for results obtained in the use of its product by persons whose methods are outside or beyond our control. It is the user's responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the user's responsibility to observe and adapt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.	