

Product	Protac® 7302 Methacrylate Structural Acrylic
Description	Protac® 7302 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, thermoplastics, thermosets, and composite assemblies with little to no surface preparation.
Features	Convenient 1:1 mix ratio formulation. Excellent impact, peel and shear resistance. Room temperature cures with very 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, Galvanized Steel, Aluminium, etc. Ideal for automotive components, sporting goods, appliances, computer assemblies, electrical components, furniture, marine assemblies, plastic fabrications, sign & display, 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	White	Off-white
Viscosity @ 25 °C, Brookfield RVT	90,000	90,000
Density (g/ml)	1.02	1.02
Mix Ratio (W:V)	1	1

Physical properties – cured adhesive

Shore Hardness	60 - 70D
Elongation%	20
Adhesive Tensile Shear (Steel/Steel)	27.23 Mpa
Adhesive Tensile Shear (Al/Al)	>27 Mpa
Adhesive Tensile Shear (ABS/PVC)	10.34
Adhesive Tensile Shear (Fiberglass)	>11.37

Cure Characteristics	Working Time	2 - 3 minutes
	Fixture Time	5 minutes
	Functional Cure	1 hours
	Full Cure	24 hours
	Service Temperature	-40°C to 125°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.