

<b>Product</b>	<b>Protac® 7310 Methacrylate Structural Acrylic</b>
<b>Description</b>	Protac® 7310 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, thermoplastics, thermosets and composite assemblies.
<b>Features</b>	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.
<b>Applications</b>	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.
<b>Advantages</b>	Little or no surface preparation. High resistance to hydrocarbon based fuels (petrol, jet fuel, motor oil, and hydraulic fluids).

**Physical properties – uncured adhesive**

	<b>Liquid</b>	<b>Adhesive</b>	<b>Activator</b>
Appearance		Off-White	Off-White
Viscosity at 25°C, Brookfield RVT		200,000	200,000
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	70
Elongation %	5-10
Adhesive Tensile Shear	
Steel/Steel	22 MPa
Aluminium/Aluminium	19 Mpa
PVC/PVC	Substrate failure
SMC/SMC	Substrate failure
ABS/ABS	Substrate failure
PMMA/PMMA	Substrate failure

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<b>Cure Characteristics</b>	Working Time	8-10 minutes
	Fixture Time	18-22 minutes
	Functional Cure	1 – 3 hours
	Full Cure	24 hours
	Service Temperature	-40°C to 120°C
<b>Application</b>	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.	
<b>Packaging</b>	Available in 50ml and 400ml cartridges. This product is also available in pails and drums to use with dispensing equipment.	
<b>Storage</b>	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.	
<b>Safety</b>	Consult the Material Safety Data Sheet.	
<b>Data ranges</b>	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.	
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