

<b>Product</b>	<b>Protac® 7411-CM Structural Acrylic</b>		
<b>Description</b>	Protac® 7411-CM is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, thermoplastics, thermosets, PMMA, ABS, PC and composite assemblies.		
<b>Features</b>	Combined at a 1:1 mix ratio Optically Clear Non Yellowing Excellent impact, peel and shear resistance. Excellent low and high temperature properties. Excellent environmental resistance. Room temperature cure with short open time.		
<b>Applications</b>	Ideal for bonding all types of Metals, PVC, Polycarbonate, Acrylic, PMMA, ABS, Fiberglass, Glass, PBT, PPO, 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).		
<b>Physical properties</b>	<b>Liquid</b>	<b>Adhesive</b>	<b>Activator</b>
	Appearance	Clear	Clear
	Mixed	Clear	
	Viscosity at 25°C, Brookfield RVT	8000	8000
	Density (gm/ml)	0.9-1.1	0.9-1.1
	Mix Ratio by Volume	1	1
<b>Lap shear strength</b>	PVC	5 N/mm <sup>2</sup>	
	Stainless Steel	25 N/mm <sup>2</sup>	
	Aluminum	18 N/mm <sup>2</sup>	
	ABS	5 N/mm <sup>2</sup>	
	FRP/FRP	8 N/mm <sup>2</sup>	
	Polycarbonate	3 N/mm <sup>2</sup>	
	PMMA	3.6 N/mm <sup>2</sup>	
<b>Cure Characteristics</b>	Working Time	45 – 70 seconds	
	Fixture Time	3 minutes	
	Full Cure	24 hours	

Elongation 10%  
Service Temperature -40°C to 125°C  
Shore Hardness 60D

- 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.