

Product	Protac® 7430 Structural Acrylic				
Description	Protac® 7430 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, glass, thermoplastics, thermosets and composite assemblies.				
Features	<p>Combined at a 10:1 mix ratio, non-sagging thixotropic formulation. Excellent impact, peel and shear resistance. Excellent low and high temperature properties. Room temperature cure with a range of open times. Suitable for paint bake cycle applications up to 200°C. Service temperature maximum 150°C with no loss of mechanical properties.</p>				
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, Aluminum, Carbon Steel, Galvanized Steel, Composite assemblies, glass etc.				
Advantages	Little or no surface preparation. High resistance to hydrocarbon based fuels (petrol, jet fuel, motor oil, and hydraulic fluids).				
Physical properties	Liquid	Adhesive		Activator	
	Appearance	Cream		White/Black	
	Viscosity at 23°C, Brookfield Pa.s	135,000-140,000		50,000-60,000	
	Density (gm/ml)	1.05-1.10		1.10-1.1	
	Mix Ratio by Volume	10		1.00	
	Shore Hardness	75D			
	Elongation	30%			
	Linear Shrinkage	<1%			
Cure Characteristics	Grade	7430-5	7430-15	7430-45	7430-60
	Handling Time (mins)	5	15	45	60
	Working Time (mins)	2	7	20	30
	Full Cure	24 hours			
	Temperature range	-40 °C to 200°C			
	Service Temperature	-40 °C to 150°C			
	Paint Bake Cycle	200°C / 20 mins			
Lap Shear Strength	Aluminum (6060)	25.0 MPa			
	Aluminum 6061	19.0 MPa			
	Aluminum 1050	18 MPa			
	Stainless Steel	20 MPa			
	Steel	21 MPa			
	PMMA	Substrate failure			
	ABS	Substrate failure			
	FRP	16.0 MPa delaminated failure			

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 490ml 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.