

<b>Product</b>	<b>Protac® 7490 Structural Acrylic</b>		
<b>Description</b>	Protac® 7490 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, glass, carbon fiber, thermoplastics, thermosets and composite assemblies.		
<b>Features</b>	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 long 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, laminated glass, Styrene, Stainless Steel, Carbon Steel, Galvanized Steel, Aluminium, glass 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	White	White
	Viscosity at 23°C, Brookfield Pa.s	130000-140000	50000-60000
	Density (gm/ml)	1.11	1.10-1.15
	Mix Ratio by Volume	10.0	1.00
	Shore Hardness	70-80D	
	Elongation	35%	
	Tensile Shear Strength	14-15 MPa (ISO 527-1A)	
<b>Cure Characteristics</b>	Working Time	90 minutes	
	Handling Time	120 minutes	
	Full Cure	24 hours	
	Service Temperature	-40 °C to 150°C	
<b>Lap Shear Strength</b>	Aluminum (6060)	19.0 MPa	
	Stainless Steel	20 MPa	
	Steel	21 MPa	
	PMMA	Substrate failure	
	ABS	Substrate failure	
	FRP	16.0 MPa	
<b>Impact Strength</b>	Galvanised steel	15-20 N/mm (ISO 113-43)	

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<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 490ml 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.
<b>Notes</b>	The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Novachem 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.