KLEBER KB-XBOND AA510 Acrylic Adhesive

Product Introduction

KB-XBOND AA510 Is a low shrinkage two-component acrylic adhesive, it has excellent adhesion to metal materials, such as aluminum, cold rolled steel, galvanized steel, etc., in addition to engineering plastics PC-ABS also has a good adhesion, the bonding surface basically will not shrink.

Features and Benefits

- Good adhesion for wide application，
- No need for complex surface
- Thixotropy, no flow
- low shrinkage

Typical Properties

Properties	Unit	Part A	Part B	Mixed
Appearance	-	Black Paste	Grey Paste	Dark grey paste
Viscosity @ 25°C	Pa·s	100-200	100-300	-
Specific Gravity	g/cm3	0.95	1.65	1.20
Mix Ratio by Volume	-	2	1	-
Working Time @ 25°C	min	-	-	6-8
Time to Handle Strength @25°C	min	-	-	18-25

Typical Cured Properties

Properties	Unit	Test Method	Value
Lap Shear Strength, Aluminum @ 25°C	MPa	ASTM D1002	>6
Lap Shear Strength, PC/ABS @ 25°C	MPa	ASTM D1002	SB
Tensile Strength	MPa	ASTM D638	6
Elongation at Break	%	ASTM D638	190
Glass Trannsition Temperature	°C	DMA	43

Application

- Automotive
- Bus
- Train

Operation Process

- Mixing: mix the two parts at a ratio of 2:1 by volume, handheld cartridges or automatic dispense are recommended for accurately mixing.
- Applying: clean the substrates and apply the mixed adhesive to bond surfaces, join the parts and add enough pressure until the handling strength is reached.
- Curing: the mixed adhesive will reach full cure in 24 hours at room temperature. Cure can be accelerated with elevated temperature.

Shelf Life/Storage

- Shelf life of each component is 6 months from date of manufacture when stored under 25 °C in original unopened container.Storage temperatures of 40-50°F (4-10°C) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

Cautions：
The information provided in the Technical Data Sheet (TDS) (including product use and application recommendations) is based on our knowledge and experience of Kleber products. The data contained in this TDS is for reference only and is considered reliable. We cannot be held responsible for the results of others as a result of methods beyond our control. This product can have a variety of different applications and different working conditions in your environment, which is beyond our control. Therefore, Kleber assumes no responsibility for whether the product is suitable for your production process and conditions as well as the expected applications and results. We strongly recommend that you test the product before use to confirm the applicability of the product.

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