



SAF30 120 SA

TWO-COMPONENT METHYL METHACRYLATE

KEY FEATURES

- Long open and fixture times, cure time of approximately 120 minutes
- Non-sag application on vertical surfaces
- Excellent environmental resistance

DESCRIPTION

Designed with patented methyl methacrylate technology, Bostik's SAF structural adhesive product line offers unmatched chemical, environmental, mechanical and fatigue resistance for many industrial applications. Able to bond a wide range of dissimilar substrates, including composites, metals and plastics, the SAF product line features high elongation from 30-250%, smart viscosity formulation, minimal surface preparation and a wide range of open and curing times.

RANGE OF APPLICATION

The SAF30 120 SA is recommended for the following substrates:

METALS	COMPOSITES	PLASTICS
Steel	Polyester	PVC
Stainless Steel	Vinyl ester	PS
Aluminum	Epoxy	ABS
	Acrylic (Elium)	PC
		PMMA

PRODUCT CHARACTERISTICS

CURING PROPERTIES

Properties	Result
System	Two-component 10:1 volume ratio
Polymerization	Room temperature



TYPICAL PHYSICAL PROPERTIES

Properties	Resin	Hardener Bostik SAF D
Appearance	Off-White	White
Density (+/- 0.02)	1.17	1.16
Viscosity @77°F (23°C)	90,000 - 150,000 ¹	90,000 - 140,000 ²
Type	Non-sag	

CURING PROPERTIES

Properties	Result
Open time [min]	80 - 100
Fixture time @77°F (23°C) [min]	105 - 150
Full cure [hours]	24

MECHANICAL PROPERTIES

Properties	Result
Lap shear strength [MPa/psi] ³ thickness 250µm	11 / 1,160
Tensile strength at break [MPa/psi] ³	12 - 14 / 1,740 - 2,031
Tensile modulus [MPa/psi] ³	800 - 900 / 116,030 - 130,534
Hardness [Shore D]	65 - 70
Elongation at break ⁴	30%

WEATHERING AND AGING RESISTANCE

Lap shear strength (MPa/psi) with ISO 4587 after D3 cycle.
D3 cycle: NF EN ISO 9142, 7 aging cycles (7 days).

LAP SHEAR STRENGTH (MPa/psi)³ THICKNESS 250µm

Substrates	Before aging cycles	After aging cycles D3
Aluminum 6060	11.2 / 1,624 CF	11.5 / 1,668 CF
Stainless steel	7.6 / 1,102 AF	9.8 / 1,421 CF/AF
FPR	8.3 / 1,204 DF	9.0 / 1,305 DF

NOTE

¹Rheometer viscosity (mPa.s) @20s⁻¹

²Brookfield viscosity (mPa.s) mobile RV7 @ 10 rpm

³ISO 4587

⁴ISO 527-1A

⁵DF : Delamination Failure

SURFACE PREPARATION

Use an appropriate cleaning agent, such as isopropyl alcohol, to remove grease, contamination or poorly adhering oxides from metal surfaces. Most plastics require a simple cleaning before bonding. Some may require sanding for better performances.

PRECAUTIONS

Adhesive contains methacrylate monomers and is flammable. Materials must be stored in cool place away from sources of heat. During the polymerization, the chemical reaction causes a typical smell; please use the product in a well-ventilated area.

When the adhesive's two components are mixed, an exothermic reaction can occur and generates heat. The amount of heat is dependent on the mass and thickness of the mixed product.

Read material Safety Data Sheet before handling or using this product.

APPLICATION

The optimum quality is obtained at room temperature, ideally between 64 – 82°F (18 – 28°C) without post-curing.

Follow the instructions on the product operating guide or contact your Bostik representative for any information concerning product use or dispensing equipment.

STORAGE AND SHELF LIFE

The SAF30 120 SA shelf life is 9 months in unopened original packaging. The product may be stored in a closed container in a dry place at temperature between 59 – 77°F (15 – 25°C).

Exposure to higher or lower temperature will result in a reduction of the stated shelf life.

PACKAGING

For packaging information please call your Bostik sales or technical representative.

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BOSTIK HOTLINE

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