

MASTIKPLEXX 3295

CHEMICAL NATURE	METHYL METHACRYLATE
OPEN TIME	2 – 3 MIN.
FIXTURE TIME	5 – 6 MIN.
GAP FILLING CAPABILITY	0,5 – 2 MM
VISCOSITY	5.000 ± 500 MPAS

MASTIKPLEXX 3295 is a two component structural acrylic adhesive, designed for the high strength bonding of metals and applications in composite material.

PROPERTIES	PART A	PART B
CHEMICAL NATURE	Methyl Methacrylate	Catalyst
COLOUR	Green	Pink
DENSITY @ 23 °C	1,02 ± 0,02 g/ml	1,02 ± 0,02 g/ml
VISCOSITY @ 23 °C	5.000 ± 500 mPa.s	5.000 ± 500 mPa.s
MIX RATIO BY VOLUME	1	1
TYPICAL CHARACTERISTICS OF THE MIXED PRODUCT		
OPEN TIME @ 23°C	2 – 3 minutes	
FIXTURE TIME @ 23°C	5 – 6 minutes	
SETTING TIME (50 % final strength)	1 hour	
FULL CURE TIME	6 hours	
MIXED PRODUCT COLOUR	Light Grey	
DENSITY	1,02 ± 0,02 g/ml	
MINIMUM GAP FILL	0,5 mm	
MAXIMUM FUNCTIONAL GAP FILL	2 mm	
TENSILE STRENGHT	15 - 25 N/mm ²	
LAP SHEAR STRENGHT	15 - 25 N/mm ²	
OPERATING TEMPERATURE	- 30 / + 130 °C	

Application & Properties



- MK 3295 can bond a wide variety of materials such as metals, glass, epoxy, unsaturated polyesters, GRP.
- Used for the bonding of fastening elements in shaped metal to composite parts.
- Particularly suitable for bonding aluminium and stainless steel in manufacturing industry of advertising signs.
- Suitable for fixing the carbon fiber panels in the Automotive sector.
- Used in the marine industry for bonding.
- Fast cure.
- Good resistance to acids, bases, hydrocarbon solvents and salt solutions
- Excellent adhesion on different plastic substrates, without the use of specific surface primers

Application



- Before proceeding with the gluing, perform the preparation of the substrates (see next section).
- Remove the cap from the cartridge and bleed a small amount of product, to ensure that it is extruded the same volume of product from both cartridge sides (part A and part B).
- Connect a mixing nozzle to the cartridge and dispense a sufficient quantity of adhesive to ensure equal mixing between part A and B inside the mixer.
- Apply the adhesive on one of the two surfaces to be bonded and assemble the components carefully.
- Remove any excess adhesive before its polymerization.
- Leave on the adhesive the time required for developments sufficient handling strength.

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- Notes for the user: the open time is the period of time useful for the positioning of the parts to be assembled and that guarantees a good wettability of the surfaces.

The adhesive volume and application temperature have direct effect on open time of the Mastikplexx accelerating or slowing its exothermic reaction.

High temperatures and high volumes speed up the fixing reaction, low temperatures and thin layers of adhesive slow down this process.

Recommendations



- Preparation of the substrate

The substrates must be cleaned well, dry and free from dust oil or grease that can affect the bonding quality.

For cleaning use isopropyl alcohol, MK SOL-NEO or MK SOLV.13 according to local regulations.

Degrease PVC, glass and aluminium with an oil-free solvent such as Acetone.

Check the compatibility of the solvent with the substrate to be bonded.

If necessary, sandblast or mechanically abrade the surfaces to be bonded.

Storage & Packaging



- Il Mastikplexx 3295 can be stored for 12 months in their original and tightly closed container keep in a cool and dry place. The storage temperature must be between 12°C and 23°C. Prolonged storage at a temperature above 23 °C will reduce the expiry date of the product. Avoid direct contact with sunlight.

- 50 / 400 ml cartridges + mixers

Precautions for use



Mastikol® products are generally quite harmless to handle provided that certain precautions are normally taken when handling chemicals.

Avoid contact between substances and foodstuffs or food tools, and take all necessary precautions to avoid contact with the skin.

The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection.

The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents has to be avoided. Disposable paper should be used to dry the skin.

Adequate ventilation of the working area is recommended.

These precautions are described in greater detail in the safety data sheet for the individual products and should be referred to for further information.

Notes



The information and, in particular, the recommendations relating to the application and end-use of Mastikol® products, are given in good faith based on Mastikol®'s current knowledge and experience of the products when properly stored, handled and applied under normal conditions.

Mastikol® cannot assume responsibility for the results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability for the user's purpose of any production method mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.

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Users should always refer to the most recent issue of the technical data sheet for the product concerned, copies of which will be supplied on request.