BONDING & SEALING

DINITROL 870 MMA
Structural Adhesive

for Plastic and Metal bonding

- High strength
- Little or no surface preparation
- Fast curing
- Overpaintable
- Non sagging
- Excellent impact, peel and shear strength
- Very good chemical- and UV resistance

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DINITROL 870 MMA

Product

DINITROL 870 MMA is a fast curing, easy to use structural 2-component methyl methacrylate adhesive, designed for structural bonding of thermoplastic, metal and composite assemblies. DINITROL 870 MMA cures by a chemical reaction of the two components (mixing ratio 1:1), forming a durable polymer resistant to elevated temperatures, moisture, fuel, many solvents and chemicals. DINITROL 870 MMA is not suscepti-ble to off-ratio mixing, because it cures by free radical chain-polymerization at room tempe-ra-ture. It has a working time of 4 to 6 minutes and achieves 75% of ultimate strength in 20 minutes
at room temperature (23°C). DINITROL 870 MMA offers a combination of high strength and stiff-ness as well as the ability to bond a wide range of substrates. DINITROL 870 MMA is supplied in ready to use double cartridges to be dispen-sed as a non-sagging gel.

Applications

- Bumpers, spoilers, lights, front grills
- Cosmetic surface repair
- Insert and brackets
- Lights, covers
- Airbag housing
- Body panels reinforcements
- Dash boards
- Interior parts
- Aluminium frames and windows

Substrates

Plastics
PMMA
ABS/ASA
PVC
Polycarbonate
Polypropylene

Composites
Polyester
SMC
GRP
Vinyl Ester
Epoxy

Metals
Aluminium
Stainless Steel
Steel
Galvanised Steel

* For not mentioned substrates and additional information please contact DINOL.

Repair of PP/EPDM bumper

Bonding of aluminium frame

Bonding of metal insert in PP/EPDM bumper

Technical Data

Basic material:	Methyl methacrylate (MMA)
Curing method:	Free radical peroxide initiated
Mixing ratio:	1 : 1
Working open time (23°C):	ca. 4 – 6 minutes
Fixture time (23°C):	ca. 20 minutes
Full cure:	ca. 24 hours
Shore hardness:	ca. D78
Specific gravity mixture:	ca. 1.03 g/ml
Gap filling:	1 mm to 9 mm
Tensile strength:	ca. 29 MPa
Elongation at break:	ca. 19%
Solvent percentage:	0%
Isocyanate percentage:	0%
Temperature resistance:	-40°C till +125°C
Chemical resistance:	Excellent to hydrocarbons, acids and bases, salt solutions
UV- and weather resistance:	Excellent
Colour:	White
Packaging:	50 ml double cartridges (other packaging on request)

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