

## Technical Data Sheet

Chemtools® Pty Ltd | Ph: 1300 738 250 (+61 2 9833 9866) | Unit 2, 14 – 16 Lee Holm Road ST MARYS NSW 2760  
Safety Data Sheets, product photos, and other information can be obtained by visiting [www.chemtools.com.au](http://www.chemtools.com.au)



### Rapidstick™ 8-300 Methacrylate Structural Adhesive

PART NUMBER	AVAILABLE SIZE*
8-300-25	25ml 1:1 Dual Cartridge
8-300-50	50ml 1:1 Dual Cartridge
8-300-400	400ml 1:1 Dual Cartridge

\*Available colours and/or sizes may change without notice.

#### DESCRIPTION

Chemtools® Rapidstick™ 8-300 Methacrylate Structural Adhesive is a two-component, 100% reactive toughened adhesive with excellent impact, peel, and shear resistance in a convenient 1:1 mix ratio. Its non-sagging and thixotropic formulation is specifically designed for bonding a wide variety of metals, thermoplastics, thermosets, and composite assemblies.

8-300 fills gaps up to 9.5mm and is room temperature cured with a short open time. It is typically used for automotive components, marine assemblies, sporting goods, electronics enclosures, electrical appliances, furniture, plastic fabrications, metal fabrications, and signs.

Recommended bonding surfaces include, but are not limited to:

Acrylic	PVC	Polycarbonate	Fibreglass	PBT	PPO
ABS	FRT	Polyurethane	Epoxy	Wood	RIM
Nylon	FRP	Polyesters	Gelcoats	Styrene	Aluminium
CRS	Stainless Steel	Galvanised Steel			

#### ADVICE ABOUT DISPENSING EQUIPMENT

Care must be taken to ensure compatibility between the adhesive components and the materials in the equipment that they contact. All wetted metal components should be constructed of stainless steel or aluminium, or have a sufficient thickness of chemically resistant material that prevents contact between the adhesive components and the base metal.

Contact with copper, zinc, brass, or other alloys containing these materials must be strictly prevented. All non-metallic seals and gaskets should be fabricated from Teflon® or UHMW polyethylene-based materials.

#### COVERAGE GUIDE

		MMA COVERAGE CHART					BOND LINE COVERAGE ↓
CARTRIDGE TYPE		BEAD SIZE (ROUND) VS APPROX. BOND LINE COVERAGE PER CARTRIDGE					
1:1 MIX RATIO		1/8 inch 3.175 mm	1/4 inch 6.35 mm	3/8 inch 9.525 mm	1/2 inch 12.70 mm	5/8 inch 15.875 mm	
50ML		12,649.2	3,149.6	1,397	787.4	508	mm
		126.50	31.50	13.97	7.87	5.08	cm
		1.26					M
200ML		55,575.2	13,868.4	6,197.6	3,454.4	2,209.8	mm
		555.76	138.68	61.98	34.55	22.10	cm
		5.56	1.39				M
400ML		101,015.8	25,273	1,126.8	6,299.2	4,038.6	mm
		1,010.16	252.73	11.27	62.99	40.39	cm
		10.10	2.53				M

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### APPLICATION

All surfaces must be clean and dry, and free of dust and grease. Best results will be achieved with surfaces that have been lightly abraded immediately prior to bonding.

Always dispense a quantity of adhesive at start-up to ensure the adhesive exiting the tip of the mixer is a uniform colour, without streaks. If previously opened or aged material is being used, allow the purged material to cure to confirm quality before proceeding.

Carefully dispense a sufficient quantity of adhesive onto the substrate to ensure that the bond gap will be completely filled when the parts are joined. Allow for squeeze-out at the edges of the bond to ensure coverage.

Carefully secure or clamp parts to prevent joint movement while the adhesive sets. Do not apply excessive pressure that can cause excessively thin gaps and starve the bond line.

Test the curing adhesive at the edges for fingernail hardness before removing any clamps or fixtures.

### CURING

Working time is the approximate time after mixing components A and B that the adhesive remains fluid and bondable.

Fixture time is the approximate time after mixing components A and B required for the adhesive to develop sufficient strength to allow careful movement, unclamping, or demolding of assembled parts. Parts can generally be put into service when 80 percent of full strength is developed.

The time to achieve 80% cure is approximately 2-3 times that required for fixturing.

Note: The chemical curing reaction that occurs when components A and B are mixed generates heat. The amount of heat generated is controlled by the mass and thickness of the mixed product. Large masses over 12.7mm thick can develop heat in excess of +121°C and can generate harmful, flammable vapours. Large curing masses should be carefully moved to a well-ventilated area where the chance of personal contact is minimised.

### CLEAN-UP PROCEDURE

Adhesive components and mixed adhesive should be removed from mixing and application equipment with a suitable industrial solvent or cleaner before the mixed adhesive cures. Once cured, soaking in a strong solvent or paint remover will be required to soften the adhesive for removal.

### TECHNICAL DATA

#### ADHESIVE PROPERTIES (UNCURED)

	Adhesive	Activator
Viscosity @ 25°C (Brookfield RVT)	40,000 – 60,000	40,000 – 60,000
Flash Point (TCC)	10.5°C	10.5°C
Density (lbs/gal)	8.55	8.71
Mix Ratio (Weight & Volume)	1	1

Mixed Viscosity, cps	90,000 – 100,000
Working Time	4 – 6 minutes
Fixture Time	12 – 15 minutes
Full Cure	24 hours
Coverage (lb)	148 sq.in @ 0.10"
Service Temperature	-40°C to +121°C
Shelf Life	12 months from the date of manufacture

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### ADHESIVE PROPERTIES (CURED)

Gap Filling	Up to 9.5mm
Shore Hardness (ASTM D2240)	78D
Elongation	19%
Tensile Shear Strength (ASTM D2240)	4,200 psi
Impact Resistance	19 ft.lb./in.

### LAP SHEAR STRENGTH DATA (ASTM D1002) AFTER 7 DAYS @ 25°C

*Result: Lap Shear Strength figures are lower for the plastic surfaces due to substrate failure which means substrate is failing before the adhesive bond.*

Substrates	Lap Shear Strength & Failure Mode
Stainless Steel / Stainless Steel	3,480 psi – Cohesive Failure
Aluminium / Aluminium	3,190 psi – Cohesive Failure
ABS / ABS	1,500 psi – Substrate Failure
FRP / FRP	1,700 psi – Fibre Tear
Aluminium / ABS	2,200 psi – Substrate Failure

### CLEAVAGE PEEL DATA (ASTM D3807)

*Result: Has the ability to withstand at high levels of peel stresses.*

Stainless Steel / Stainless Steel	Initial Strength: 20 pli
	Average Strength: 18 pli

### CHEMICAL RESISTANCE DATA

The chemical resistance was studied by bonding the Aluminium/Aluminium as per specification and cured for 7 days @ 25°C, then kept immersed in the media listed here and tested for Lap Shear Strength (ASTM D1002).

Effect of 1 month immersion in different media:

Media	Lap Shear Strength
Petrol	3,250 psi
Acetic Acid (10%)	3,190 psi
Xylene	3,200 psi
Lubricating Oil – HD30	3,300 psi
Paraffin	3,150 psi
Water @ 23°C	3,145 psi
Water @ 90°C	3,000 psi

### ENVIRONMENTAL RESISTANCE DATA

*Result: Excellent resistance to harsh environment conditions.*

*Notes: The Lap Shear Strength had increased after environmental cycle and performed better under these conditions compared to the substrates bonded. Substrates may have less resistance to these conditions compared to adhesive.*

Condition	Lap Shear Strength & Mode of Failure
Initial	3,480 psi – Cohesive Failure
Environmental Cycle – 30 days	3,950 psi – Cohesive Failure

Lap Shear Strength (ASTM D1002) – Stainless Steel / Stainless Steel

Environmental Cycle = 8 hours @ -30°C, 8 hours @ 85°C, 8 hours @ 30°C, @ 100% Relative Humidity

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### SHELF LIFE

**12 months from the date of manufacture** in accordance with the following conditions:

Store continuously between 13°C and 23°C. Long term exposure above 23°C will reduce the shelf life of these materials. Prolonged exposure of activators, including cartridges which contain activators, above 37°C quickly diminishes the product's reactivity and should be avoided. Shelf life can be extended by refrigeration (8°C - 12°C). Do not freeze.

### FIRST AID & SAFETY PRECAUTIONS

**Always refer to Safety Data Sheet/s before use.** Use proper Personal Protection Equipment. Do not get in eyes, on skin, or on clothing. Use with adequate ventilation. Avoid breathing fumes. Keep away from heat, sparks, open flames, and hot surfaces. This product may produce adverse health conditions, ranging from minor skin irritation to serious systemic effects. It should not be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheet/s for this product have been fully understood by all persons who will work with the material.

### STORAGE & TRANSPORT

**Refer to Safety Data Sheet/s for recommendations.** As a general precaution, keep containers tightly closed, protect from sunlight, and do not expose to temperatures exceeding 50°C. Store in a cool, dry place at room temperature (5 – 40°C). Do not return any unused material to its original container. Containers should be secured and stored upright during transit.

### DISCLAIMER

Every effort has been made to ensure the information provided in this document is accurate at the date of publication. Chemtools® Pty Ltd expressly recommends that the user make his/her own assessment to determine the suitability of the product for its intended purpose prior to application. Chemtools® Pty Ltd shall not be responsible for loss, damage, or injury, resulting from the reliance upon, or failure to adhere to, any recommendations or information contained herein; nor from abnormal use of the material; nor from any hazard inherent in the nature of the material.