

SAF-T-LOK®

TDS SA-26

Structural Adhesive SA-26

GENERAL INFORMATION: SAF-T-LOK SA-26 is a two part, no premix acrylic bonding system. It provides high impact resistance, has low odor, is non-flammable, quick setting and offers high bond strength and impact resistance on a wide variety of substrates including oily or "as recieved" metals. No mixing is required. This structural adhesive is easy to use and is not stringy.

PHYSICAL PROPERTIES: -----Uncured-----

	ADHESIVE	ACTIVATOR
Color	Amber	Amber
Specific Gravity	1.0 gm/cc	1.3 gm/cc
Viscosity	30,000 cps	2-5 cps
Solids Content	100%	5%
Flash Point	>200°F	>250°F
Storage Stability	12 mo. @ <75°F	12 mo. @ <75°F

PERFORMANCE CHARACTERISTICS:

A. Speed of Cure on clean mild steel @ 77°F

TIME	Tensile/Shear STRENGTH
30 sec.	Handling Strength
5 min.	1200 psi.
1 min.	2000 psi.
4 hrs.	2500 psi.

B. Typical Mild Steel Cured properties:

	STRENGTH	METHOD
Tensile/Shear	2500 psi	ASTM D-1002
Peel (t-peel)	35 lb./in.	ASTM 1876
Torsional Impact	15 in. lb.	Automotive
Coefficient of Expansion	1.4 m/m°Cx10	

IMPORTANT NOTICE: All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. SAF-T-LOK International Corporation is not responsible for loss, claim or damages resulting from use of its products.

C. Thermal Properties:

TEMPERATURE	Tensile/Shear STRENGTH
-50°F	1000 psi
75°F	2500 psi
150°F	2000 psi
260°F	500 psi

Recommended thermal range is -65°F to 300°F.

TYPICAL TENSILE SHEAR PROPERTIES ON VARIOUS SUBSTRATES:

SUBSTRATE	Tensile/Shear STRENGTH
Clean, mild steel	2500 psi.
Oily, mild steel	2200 psi.
Oily Aluminum	2500 psi.
Acrylic Plastic	1800 psi.
PVC	1500 psi.
Wood (Maple)	1500 psi.*
ABS Plastic	1500 psi.
Epoxy Board	2000 psi.
Nylon (glass filled)	2000 psi.

*** Substrate Failure**

The above data were obtained on one half inch overlapped specimens, one inch wide. All specimens were allowed to cure for 72 hours at room temperature prior to testing. Specimens were pulled apart at one half inch per minute. Gaps were as small as possible, estimated 2 mils.

CHEMICAL RESISTANCE: SAF-T-LOK SA-26 resists water, gasoline, hydrocarbon oils, and common organic solvents.

SAE 10W30	60 days	2500 psi
Gasoline	30 days	2000 psi
Benzene	30 days	2500 psi
Water	60 days	2500 psi
Humidity(100% @120°F)	30 days	2100 psi

RECOMMENDATIONS: SAF-T-LOK SA-26 Adhesive bonds many surfaces without surface preparation. Some surfaces and general comments to maximize adhesive bond strength are listed below.

Iron	Ceramics	COMMENTS: "As recieved" substrates are generally suitable for bonding. Waxy coatings or heavy greases should be removed by solvent or vapor degreasing. Certain grades of hard, bright or anodized coatings may require mechanical abrasion for best adhesion.	
Steel	Wood		
Cast Iron	Fabric		
Brass	Phenolics		
Zinc	Graphite		
Aluminum	SBR Rubber		
Alinco	Sintered Metal		
Ferrites	Acrylics		
ABS	Filled Nylon		Frequently coated with silicone or wax type release agents. A solvent wipe is recommended. Some grades require mechanical abrasion.
Rigid PVC	Polyurethane		
Styrene	Fiberglass Board		
Epoxy Board	Polycarbonates		
Neoprene	Polyethylene		Not recommended for bonding

APPLICATION:

Surface Preparation - Most substrates require little, if any surface preparation. Adhesion is frequently best on clean mechanically roughened surfaces. Some plastics adhere better when cleaned or prepared according to the plastic manufacturer's recommendations.

1. Apply Activator to one of the surfaces to be bonded. Allow a few seconds for the solvent to evaporate. Surface will then have slightly oily appearance. For bond lines over .030 inches thick, application of activator to both surfaces is recommended. Porous surfaces may require heavier applications of activator.
2. Apply the resin to the mating surface.
3. Cure is initiated when parts are mated