

PRODUCT DESCRIPTION:

SAF-T-LOK SA-24 is a no premix acrylic bonding system designed to be used with our Solventless Activator. It provides high impact resistance, has low odor, is non-flammable, quick setting and offers high bond strength. **SAF-T-LOK SA-24** is impact resistance on a wide variety of substrates including oily or "as received" metals. No mixing is required. This structural adhesive is easy to use and is not stringy. SA-24 has excellent high temperature resistance, and is ideal for bonding close-fitting metal and magnets.

PRODUCT CHARACTERISTICS:

	ADHESIVE:	SOLVENTLESS ACTIVATOR:
Color:	Amber	Amber
Specific Gravity:	1.1 gm/cc	1.1 gm/cc
Viscosity:	15,000 cps	2-5 cps
Solids Content:	100%	100%
Flash Point:	>200°F	>250°F
Storage Stability:	12 months @ <75°F	12 months @ <75°F

PERFORMANCE CHARACTERISTICS:

A. Speed of Cure on Clean Mild Steel @ 77°F

TIME	STRENGTH
45 seconds	Handling Strength
2 minutes	1200 psi
15 minutes	2600 psi
25 hours	3500 psi

B. Typical Mild Steel Cured Properties

	STRENGTH:	METHOD:
Tensile/Shear:	3500 psi	ASTM D-1002
Peel (t-peel):	30 lb/in	ASTM 1876
Torsional Impact:	30 lb/in	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.

TECHNICAL SUPPORT

Our technical support team stand ready to assist you with your technical questions regarding your SAF-T-LOK products. On-Site support when necessary within 24 hours.

PART NUMBERS

30631	50gm
30643	1lb
30610	10 Ltr

TURNKEY SOLUTIONS

As an ISO 9001:2008 certified company, SAF-T-LOK can design or refine products to fit your companies specific needs and requirements.

For more information on any of our products or services please visit us on the Web at:
www.saftlok.com

C. Thermal Properties

TEMPERATURE:	STRENGTH:
-50°F:	1500 psi
75°F:	3500 psi
150°F:	3500 psi
260°F:	1900 psi

Recommended thermal range is -65°F to 350°F.

D. Tensile Shear Properties

SUBSTRATE:	STRENGTH:
Clean, mild steel:	3500 psi
Oily, mild steel:	3000 psi
Oily Steel @ 250°F:	1900 psi
Oily Aluminum:	3000 psi
Acrylic Plastic:	1800 psi
PVC:	1400 psi
Wood (Maple):	1500 psi

*** Substrate Failure**

The above data was 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.

E. CHEMICAL RESISTANCE

SAE 10W30:	60 days	3200 psi
Gasoline:	30 days	2700 psi
Brake Fluid:	30 days	3200 psi
Benzene:	30 days	2600 psi
Water:	60 days	1500 psi
Humidity (100% @ 120°F):	30 days	3300 psi

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RECOMMENDATIONS: SAF-T-LOK SA-24 adhesive bonds many surfaces without surface face preparation. Some surfaces and general comments to maximize adhesive bond strength are listed below.

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- Iron
- Steel
- Cast Iron
- Brass
- Zinc
- Aluminum
- Alinco
- Ferrites
- ABS
- Rigid PVC
- Styrene
- Epoxy Board
- Neoprene
- Ceramic
- Wood
- Fabric
- Phenolics
- Graphite
- SBR Rubber
- Sintered Metal
- Acrylics
- Filled Nylon
- Polyurethane
- Fiberglass Board
- Polycarbonates
- Polyethylene

COMMENTS:

“As received” substrates are generally suitable for bonding. Waxy coatings and heavy greases should be removed by solvent, or vapor degreasing. Certain grades if hard, bright or anodized coatings may require mechanical abrasion for best adhesion. Frequently coated with silicone or wax tape release agents. A solvent type wipe is recommended. Some grades require mechanical abrasion. Not recommended for bonding.

APPLICATION:

Surface Preparation – Most substrates require little, if any 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 a thin coating of Solventless Activator to one of the surfaces to be bonded. 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 4-6 drops per square inch of resin to the mating surface.
3. Cure is initiated when parts are mated, preferable with a sliding motion.

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