

**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**

30731                    50gm  
30743                    1li

**SPECIFICATIONS**

ASTM C920 Type S, NS, Class 25; TT-S-00230C, TT-S-01543A, MIL-A-46106A, FDA CFR 177.2600, USDA Approved, NSF 51, UL Recognized Component.

**TURNKEY SOLUTIONS**

As an ISO 9001:2015 certified company, SAF-T-LOK can design or refine products to fit your company's specific needs and requirements.

For more information on any of our products or services please visit us on the Web at:  
[www.saftlok.com](http://www.saftlok.com)

**PRODUCT DESCRIPTION:**

**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. **SAF-T-LOK SA-26** 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.

**PRODUCT CHARACTERISTICS:**

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

**PERFORMANCE CHARACTERISTICS:**

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

TIME	STRENGTH
30 seconds	Handling Strength
<b>1 minutes</b>	<b>1200 psi</b>
5 minutes	2000 psi
<b>4 hours</b>	<b>2500 psi</b>

## B. Typical Mild Steel Cured Properties

	STRENGTH:	METHOD:
<b>Tensile/Shear:</b>	<b>2500 psi</b>	<b>ASTM D-1002</b>
Peel (t-peel):	35 lb/in	ASTM 1876
<b>Torsional Impact:</b>	<b>15 lb/in</b>	<b>Automotive</b>
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:****STRENGTH:**

<b>-50°F:</b>	<b>1000 psi</b>
75°F:	2500 psi
<b>150°F:</b>	<b>2000 psi</b>
260°F:	500 psi

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

**D. Tensile Shear Properties****SUBSTRATE:****STRENGTH:**

<b>Clean, mild steel:</b>	<b>2500 psi</b>
Oily, mild steel:	2200 psi
<b>Oily Steel @ 250°F:</b>	<b>2500 psi</b>
Oily Aluminum:	2500 psi
<b>Acrylic Plastic:</b>	<b>1800 psi</b>
PVC:	1500 psi
<b>Wood (Maple):</b>	<b>1500 psi</b>

**\* 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**

<b>SAE 10W30:</b>	<b>60 days</b>	<b>2500 psi</b>
Gasoline:	30 days	2000 psi
<b>Brake Fluid:</b>	<b>30 days</b>	<b>3200 psi</b>
Benzene:	30 days	2500 psi
<b>Water:</b>	<b>60 days</b>	<b>2500 psi</b>
Humidity (100% @ 120°F):	30 days	2100 psi

**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

**SPECIFICATIONS**

ASTM C920 Type S, NS, Class 25; TT-S-00230C, TT-S-01543A, MIL-A-46106A, FDA CFR 177.2600, USDA Approved, NSF 51, UL Recognized Component.

**TURNKEY SOLUTIONS**

As an ISO 9001:2015 certified company, SAF-T-LOK can design or refine products to fit your company's specific needs and requirements.

For more information on any of our products or services please visit us on the Web at:  
[www.saftlok.com](http://www.saftlok.com)

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

#### 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

#### SPECIFICATIONS

ASTM C920 Type S, NS, Class 25; TT-S-00230C, TT-S-01543A, MIL-A-46106A, FDA CFR 177.2600, USDA Approved, NSF 51, UL Recognized Component.

#### TURNKEY SOLUTIONS

As an ISO 9001:2015 certified company, SAF-T-LOK can design or refine products to fit your company's specific needs and requirements.

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

www.saftlok.com

- |               |                    |
|---------------|--------------------|
| ➤ Iron        | ➤ Ceramic          |
| ➤ Steel       | ➤ Wood             |
| ➤ Cast Iron   | ➤ Fabric           |
| ➤ Brass       | ➤ Phenolics        |
| ➤ Zinc        | ➤ Graphite         |
| ➤ Aluminum    | ➤ SBR Rubber       |
| ➤ Alinco      | ➤ Sintered Metal   |
| ➤ Ferrites    | ➤ Acrylics         |
| ➤ ABS         | ➤ Filled Nylon     |
| ➤ Rigid PVC   | ➤ Polyurethane     |
| ➤ Styrene     | ➤ Fiberglass Board |
| ➤ Epoxy Board | ➤ Polycarbonates   |
| ➤ Neoprene    | ➤ 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 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, preferable with a sliding motion.

**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.