

Constructive two-component methacrylate adhesive, low viscosity colour: pink / green, translucent when mixed

Application areas	<p>Wisacoll MMA 3095 is a fast, structural, heat-resistant and universal two-component adhesive</p> <ul style="list-style-type: none">▪ for discreet and clear connections indoors▪ for bonding a wide range of materials: metals, most painted and powder coated surfaces, composite materials, acrylic, various other plastics like e.g. PVC-hard, ABS, bakelit, GRP, glass (only indoors), wood, ceramics, stoneware etc.▪ well suited for bonding flat iron, sheet metal panels, corner angles, repair work on containers, holding elements, lamps, housings and roof modules▪ for filling cracks▪ ideal for joining stainless steel sleeves and caps or for attaching handles, decorative elements, metal table legs to glass or acrylic surfaces▪ for attaching hooks to ceramic and metal surfaces▪ ideal for furniture production, signs industry, machinery and apparatus engineering, metal construction, vehicle -manufacturing, handicraft and further applications
Product benefits	<ul style="list-style-type: none">▪ easy handling thanks to the double syringe (no gun necessary)▪ controlled and safe cross-linking▪ strong grip, excellent impact, peel and shear strength▪ high heat and vibration resistance▪ can be stove-enamelled (20 min / +180 °C)▪ resistant to water, gases, oils, hydrocarbons and many chemicals▪ no risk of corrosion▪ sandable and drillable when cured▪ cures without (air)humidity▪ recoatable and lacquerable
Base	methyl methacrylate (MMA)
Restrictions	<ul style="list-style-type: none">▪ When bonding different materials (especially outdoors), the thermal linear expansion of the different materials must be taken into account; if necessary, use an elastic assembly adhesive. We will be happy to be of assistance with your elastic bonding requirements.▪ Not suitable for PE, PP, PTFE (Teflon[®]), bitumen and waxy substrates.▪ Adhesion to transparent materials under the direct influence of UV rays on the adhesive surface is NOT guaranteed. Our range of products offers you a choice.
Cleaning agents	Wisaclean R 216 for cleaning non-absorbent adhesive surfaces and fresh product residues. The cured product can normally only be removed mechanically. To wash your hands, please use water and soap.

Processing

Acclimatise the product before processing.
This product is for specialist trained personnel.

The bonding surfaces must be sound, dry and free of dust and grease.
Clean non-absorbent surfaces with Wisaclean R 216.
Check treated and non-absorbent surfaces with an adhesion test.
Depending on the surface of the material, it will be necessary to determine whether the adhesion can be improved by sanding or priming the surface.

Open the container. Carefully squeeze out both components. Especially when using already opened cartridges, make sure that no hardened material enters the mixing tube. Only then screw on the static mixing tube.

To ensure optimum bonding, the two components must be thoroughly mixed. Apply the adhesive.
Join parts to be glued together as quickly as possible. Press or at least fix parts until sufficient functional strength is achieved.

Remarks

- The first approx. 2 g of adhesive mixture per static mixer are not yet optimally mixed and must therefore not be used for bonding (safety shot).
- If work is interrupted, ensure that the adhesive does not remain in the static mixer for too long (see point Max. processing time in the static mixing tube).
- When working continuously, several double syringes can be emptied with one static mixer. If work is interrupted for longer than the maximum processing time in the static mixer tube, the static mixer must be replaced with a new one.
- Alternatively, the adhesive can also be mixed externally (without a static mixer) using a spatula. Make sure that no air is mixed into the mass.
- The product is a strong exothermic reaction, ie mixing a high volume of adhesive may result in heat and smoke generation.
- Pressing time, time to functional strength and through-hardening are largely dependent on temperature and application quantity. The processor must add appropriate safety margins to the specified guide values.
- If necessary, protect parts that are not to be glued with a PE film.

Bonding of metals

- In most cases, the adhesion will be improved by sanding smooth surfaces with abrasive paper (e.g. P 120).
- Galvanised sheet metal must always be protected against permanent exposure to standing moisture (white rust formation). When bonding, it must be ensured that any moisture that occurs does not reach the bonding surface!

Colours

Binder (A-Component)	green
Hardeners (B-Component)	pink
Mixture	translucent (clear, slightly greyish transparent)

Density	ca. 1.02 g/ml (mixture)
Mixing ratio	parts by volume (A:B = 1:1)
Viscosity	ca. 3500 - 5000 mPa*s; the viscosity during processing at 15 °C is about twice as high as at +25 °C
Processing time	ca. 2 min (at +20 °C)
Max. processing time in static mixer	<2 min. at +24 °C; the processing time is halved at approx. +30 °C and approx. doubled at +10 °C Within this time, the adhesive in the static mixer MUST be completely renewed to maintain perfect mixing. If the interruption of work is longer than this time, the static mixer must be replaced!
1st functional strength	from ca. 1 h
Curing time	50 % final strength after ca. 1 h, at +20 °C 100 % final strength after ca. 6 h
Gap filling capacity	<3.0 mm
Recommended adhesive joint thickness	ca. 0.2 - 2.00 mm
Breaking elongation	max. 25 %
Tensile strength	ca. 16 - 22 N/mm ² acc. to ASTM D 1001
Tensile shear strength	ca. 20 - 35 N/mm ² ASTM D 1002 metal / metal at +20 °C ca. 16 - 22 N/mm ² ASTM D 1002 glass / metal at +80 °C
Recoatibility	Can be sanded and painted over after complete cross-linking with most paint systems. The adhered workpieces should only be overpainted after the adhesive has cured completely; own tests are necessary.
Film properties	tough-but-flexible
Temperature resistance	from -40 °C up to +180 °C (after complete cross-linking) up to +200 °C (for a short time)
Processing temperature	from +5 °C up to +25 °C
Flash point	ca. 10 °C
Substrates	Aluminium, steel, galvanized steel, stainless steel, construction steel, acrylic, glass fibre reinforced plastics, PVC-hard, ABS, bakelit, GRP, glass (only indoors), epoxy, polyester, polyurethane, many thermoplastics and duroplastic plastics (except PE and PP), wood-based materials, HPL, corian, natural stone, ceramics, stoneware. In case of other surfaces, own tests are required.

Further information



More information about this product (current technical data sheet, safety data sheet, certificates, product variants, etc.) can be found via the adjacent QR code.

Item no. + Colour

Wisacoll MMA 3095 green / pink

Delivery form / Content quantity

1:1 double syringes of 25 g (ca. 25 ml)
Larger containers on request.

Shelf life

In closed original packaging, protected from direct sunlight and stored in a dry place between +15 °C and +25 °C, the official shelf life is 12 months from date of production.
Higher temperatures reduce the shelf life. Over storage time, viscosity increases and reactivity decreases.

Accessories

Item no.	Brief description
SM.25-50.SC	Static mixer for 1:1 / 2:1 2C syringes green elements (16L)

Safety and disposal: Familiarise yourself with the valid Safety Data Sheets (SDS) for the products used. All applicable safety regulations and disposal instructions must be observed.

Observe: All information is based on careful examinations in the labs and our previous practical experience. They are non-committal notes. Due to the many materials that are marketed and the different processing methods, which we cannot influence, we can, of course, not assume any warranty, including under patent-law, for the result of your work. We recommend performing sufficient own tests to find out if the product meets the respective requirements. In addition, we refer to our terms and conditions of sale, delivery and payment, available at www.wisabax.ch/agb.html. © Wisabax AG - This technical data sheet replaces all older versions.

Have you noticed an unclear formulation or an error? Thank you for your feedback. In case of doubt, the German version of the technical data sheet applies.