



# Rapid Bond

Two-components methacrylate adhesive offering extreme levels of strength, speed and flexibility for the structural bonding of modern materials



## Features & Benefits

- High shear strength - ideal for use on structural joining of metals, composites and plastics
- Primerless bonding for most metals, including steel and aluminum - minimal surface preparation
- Excellent resistance to hydrocarbons, acids and salt solutions - wide range of application possibilities in harsh environments, excellent aging properties
- Room temperature cured - does not attack surfaces, no yellowing and fast cure with rapid strength build
- Latest acrylic elastomer chemistry - remains flexible and allows filling large bond gap

P/N	Product	S/C	Packaging
86850	Rapid Bond 5min Black	RB5B-50	50 ml cartridge with nozzle
86851	Rapid Bond 5min Off-White	RB5W-50	50 ml cartridge with nozzle
86392	Nozzles		Pack of 6 short mixer nozzles
86852	Rapid Bond 5min Off-White	RB5W-220	220 ml cartridge with nozzle
86853	Rapid Bond 15min Black	RB15B-220	220 ml cartridge with nozzle
86854	Rapid Bond 15min Off-White	RB15W-220	220 ml cartridge with nozzle
86752	Nozzles		Pack of 6 mixer nozzles

## Application

Ideal for structural joining of metals, (including aluminium, stainless steel) GRP, composites, plastics, (includes ABS, acrylics, vinyl, PVC, polycarbonates), epoxy laminates and gel coats where high impact strengths are needed.

Typical uses include: door skins, bumper assemblies, automotive spoilers, vents, housings, mouldings, signs and displays.

## Instructions

1. Abrade surface to be bonded with medium grit paper, then wipe clean.
2. Cleaning with KENT Acrysol or Soft Surface Cleaner is preferred.
3. Balance cartridge, then attach correct nozzle and insert into applicator gun.
4. Extrude first 20 mm of KENT Rapid Bond and discard to ensure a proper mix has been achieved in the nozzle.
5. Apply KENT Rapid Bond to one surface only, press parts together with finger pressure only. Ensure that the bond gap is completely filled when the two parts are joined. Allow for squeeze out at the edges of the bond, to ensure even filling.
6. Carefully clamp parts, if required, to secure the bond and prevent joint movement while the adhesive cures. Do not apply excessive pressure that may cause an excessively thin bond line.
7. Use a sharp paring tool to remove excess adhesive, partially cured adhesive can be removed with sharp knife, cured material can be removed by sanding / scraping.

N.B.: Always use in a well-ventilated area. Apply KENT Rapid Bond in beads across surface of larger areas.



## Technical Information

### General info

<b>Base:</b>	2K Methyl Methacrylate
<b>Consistency:</b>	Liquid (paste)
<b>Colour:</b>	Black / Off white
<b>Shelf life:</b>	9 months
<b>Custom tariff code:</b>	3506 1000 (Rapid Bond) 3923 5090 (nozzles)
<b>VOC:</b>	650 g/l

<b>Cure mechanism:</b>	Catalytic / exothermic	<b>Lap shear:</b>	CRS:	25,1 MPa
<b>Mixing ratio:</b>	1:1		Aluminium:	22,3 MPa
<b>Specific gravity:</b>	1.00 g/ml (mixed product)		Galvanized steel:	19,5 MPa
<b>Working time:</b>	5 min (23° C / 50% R.H.) // 15 min (23° C / 50% R.H.)		SMC:	3,2 MPa
<b>Curing time:</b>	20 min (23° C / 50% R.H.) // 55 min (23° C / 50% R.H.)		PP:	2,4 Mpa
<b>Full cure:</b>	24 hours (23° C / 50% R.H.)		PMMA:	5,3 MPa
<b>Gap fill:</b>	up to 5.0 mm			
<b>Shore D:</b>	63 (EN ISO 868 @ 23° C)			
<b>Volume change:</b>	<10%			
<b>Application temp:</b>	+15°C to + 25°C			
<b>Temp resistance :</b>	- 35°C to +100°C			
<b>Tensile strength :</b>	24 MPa (ASTM D638 @ 23° C)			
<b>Lap Shear:</b>	20 - 25 MPa (ASTM D 1002)			
<b>Elongation at break:</b>	33%			
<b>Tensile modulus:</b>	1800 Mpa			
<b>Storage:</b>	Store in a dry place indoors between 5° C and 25° C			



SDS available on [www.kenteurope.com](http://www.kenteurope.com)

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**KENT (United Kingdom) Ltd, Forsyth House, Pitreavie Drive, Pitreavie Business Park, Dunfermline, Fife KY11 8US** Tel : 0800 136925 or 01383 723344 between 08:30-17:30 Monday-Thursday, 09:00-15:00 on Fridays'. For out of hours queries please Fax us on 01383 735829 or Email: [KENTsales.UK@kenteurope.com](mailto:KENTsales.UK@kenteurope.com)

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