



Rapid Bond 4 min Black

Two-components methacrylate adhesive offering extreme levels of strength, speed and safety 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
- Latest acrylic elastomer chemistry - remains elastic and allows filling large bond gap

P/N	Product	S/C	Packaging
86567	Rapid Bond 4 minutes Black	RB4B	50 ml twin cartridge with nozzle
86031	Rapid Bond short nozzles	RPNS	Bag of 6 nozzles

Application

Ideal for structural joining of metals (including aluminium, stainless steel), GRP, composites, glass, plastics (including 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.

See next page for more applications.

Instructions

Always use in a well-ventilated area. When components are mixed together heat is generated, the amount of heat will depend on the thickness of the bond line.

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. 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. Working time is approx. 4 minutes. Final cure is achieved after 24 hours.
8. 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 apply KENT Rapid Bond in beads across surface of larger areas.



Technical Information

General info

Base:	2K Methyl Methacrylate
Consistency:	Thixotropic
Colour:	Black
Shelf life:	12 months
Custom tariff code:	3506 1000
VOC:	430 g/l

Cure mechanism:	Catalytic / exothermic	Shear strength :	Steel/steel:	306 kg/cm ²
Mixing ratio:	1:1		Alu/alu:	275 kg/cm ²
Specific gravity:	0.97 g/ml (mixed product)		ABS/ABS:	184 kg/cm ²
Working time:	approx. 4 min (23° C / 50% R.H.)		GRP/GRP:	163 kg/cm ²
Fixture time:	approx. 10 min (23° C / 50% R.H.)		PC/PC:	82 kg/cm ²
Full cure:	24 hours (23° C / 50% R.H.)	Elongation at break:	19 %	
Gap fill:	0.75 – 4.0 mm	Chemical resistance:		
Hardness:	Shore D 78	Water:	Very good	
Volume change:	<5%	Saltwater:	Very good	
Application temp:	Material: +10° C to +30° C	Oil & Grease:	Very good	
	Workplace: +6° C to +30° C	Petrol & Diesel:	Very good	
Temp resistance :	- 50° C to +120° C	Water 90° C:	Good	
		Acetic acid 10%:	Good	
		Xylol:	Good	
		Strong Acids & Alkaline:	Not recommended	



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