

# TECHNICAL DATASHEET

Issue date: 01-02-2017  
Review Date: 29-05-2017 REV00



## WETOR 109 - 2K METHACRYLATE STRUCTURAL GLUE (50ML)

Ref: 109

### DESCRIPTION

Adesivo à base de metacrilato para colagens fortes, resistentes e polivalentes.

### CHARACTERISTICS

- Bonds metal, wood, stone, plastic, and ceramic.
- Extremely high bonding strength.
- Weather resistant.
- Easy to apply.
- Achieves superior bonding with reduced or no surface treatment.
- Resistant to gasoline and kerosene.

### HOW TO USE

The surfaces to be bonded must be clean, free of oil and grease. Excellent results are obtained by mechanically wrinkling the bonding surface. Insert the double cartridge into the application gun and close. Screw on the cap, attach and tighten the mixing nozzle. Squeeze the material with the application gun and discard the first 2 g, as these are not mixed in a 1:1 ratio. Drying time is reduced at high temperatures. Join and fix the pieces of the work.

The processing should be carried out at room temperature (approx. +20 °C). Higher temperatures, such as +40 °C, reduce application and curing times by about 30%; lower temperatures of approximately +10 °C increase these times by about 50%, and at approximately +5 °C almost no reaction occurs anymore.

### HANDLING

Due to the product's high reactivity and associated exothermic reaction, large quantities should not be mixed. The heat generated by the process can lead to product evaporation and cause unpleasant odors. Do not dispose of excess material in plastic containers, as these could melt.

TECHNICAL SPECS	Part A	Part B	Final Product
Basic component:	Methyl methacrylate	Methyl methacrylate	Methyl methacrylate
Color:	Milky	Milky	Milky
Viscosity:	130,000 to 150,000	150,000 to 200,000	-
Density (20°C):	0.97 g/cm <sup>3</sup>	0.95 g/cm <sup>3</sup>	0.95 g/cm <sup>3</sup>
Flash point:	11°C	11°C	-
Coefficient of expansion (μ/m°C):	60-120	x	10-6
Mixing ratio (weight):	1	1	1:1
Mixing ratio (volume):	1	1	1:1
Work time (after prep):			3 to 4 min
Setting time:			10 to 12 min

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## TECHNICAL SPECIFICATIONS - PRODUCT AFTER CURING

Thermal resistance:	-55°C to +120°C
Elongation at break:	2.4%
Setting time:	1 hour
Shrinkage (7 days):	5%
Shore D hardness:	75
Crack filling:	1 - 10 mm

### Results according to ASTM D1002 (Shear strength):

Steel/Steel:	up to 30 N/mm <sup>2</sup>
Aluminum/Aluminum:	up to 27 N/mm <sup>2</sup>
Polycarbonate:	up to 13 N/mm <sup>2</sup>
ABS/ABS:	up to 8 N/mm <sup>2</sup>

## CLEANING

Cleaning is easier when the product is still liquid. Hardened material should be removed (scraped off) mechanically and cleaned with a solvent, such as acetone. Any spilled material should be collected with an absorbent and disposed of as flammable material.

## PRECAUTIONS

See Safety Data Sheet.

Store the opened cartridge in a cool, dry place.

## PACKAGING

Type:	Double cartridge for two-component product
Volume (total):	50 ml

## EXPIRY DATE AND STORAGE

WETOR 109 has a shelf life of one year from the date of production at temperatures below 20°C. The expiry date is indicated on the label. Temperatures above 25°C reduce shelf life. Lower temperatures (5–12°C) increase shelf life. Storage temperatures above +40°C and higher atmospheric humidity reduce shelf life to 6 months. The product must be protected from freezing (it should not be stored at very low temperatures). The product removed from the packaging may become contaminated during use. For this reason, do not return any remaining product to the original container.