

# ADHESIVE SELECTOR GUIDE

Adhesives		SA 10-05	SA 10-15	SA 10-35	SA 10-35 HV	SA 10-45 HV	SA 10-60 HV	SA 10-70 HV	SA 10-100 HV	SA 10-15 UVWHT	SF 10-05	SF 10-30	SVF 10-05	SA 1-05	SA 1-15	SA 1-90	!! NEW !! HS 1-05	!! NEW !! HS 1-15 BLK	!! NEW !! SA 1-300 series	!! NEW !! SA 1-500 series	!! NEW !! CC-10-10 CLR	SC 901	
Metals	Aluminum	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*4)*1)	*4)*1)	
	Anodized Aluminum	*5	*5	*5	*5	*5	*5	*5	*5	*5	*1	*1	*1	*5	*5	*5	*5	*5	*5	*5	*5	*5	*4)*1)
	Die - casting Aluminum	*5	*5	*5	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	
	Brass	*5	*5	*5	*1	*1	*1	*1	*1					*1	*1		*1	*1					
	Cast Iron	*5	*5	*5	*1	*1	*1	*1	*1					*1	*1		*1	*1					
	Carbon Steel	*5	*5	*5	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*4)*1)
	Sheet Metal	*5	*5	*5	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1		*1	*1					*4)*1)
	Ferrite	*5	*5	*5	*1	*1	*1	*1	*1					*1	*1		*1	*1					
	Cold Rolled Steel	*5	*5	*5	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1		*1	*1					
	Electro Plated Metals	*5	*5	*5	*1	*1	*1	*1	*1					*1	*1		*1	*1					
	E - Galvanized Steel													*1	*1		*1	*1					
	Hot Dipped Galvanized Steel													*4)*1	*4)*1	*4)*1	*4)*1	*4)*1	*4)*1	*4)*1	*4)*1		
	Hot Stripped Galvanized Steel													*4)*1	*4)*1	*4)*1	*4)*1	*4)*1	*4)*1	*4)*1			
	Copper													*1	*1		*1	*1					
	KTL coated Metals	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*5	*5					
	Powder Coated Metals	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*5	*5					
	Coil Coated Metals	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*5	*5					
Stainless Steel 1.4301, 1.4541, 1.4307	*5	*5	*5	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1		
Stainless Steel 1.4401, 1.4571, 1.4404	*1	*1	*1	*1	*1	*1	*1	*1	*1	*1													
Plastics	ABS & ABS Blends	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	
	PMMA	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	
	PBT & PET	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*5	*5				*5	
	Polyamid 6, 11, 12	*2	*2	*2									*5)*2	*5)*2		*2	*2		*2	*2			
	Polyamid 66	*2	*2	*2									*5)*2	*5)*2		*2	*2		*2	*2			
	Vinyls/PVC	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5
Thermosets	Polycarbonate	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	
	Polyurethanes																						
	Polyester	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*4)*5)
	Vinlyester	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	
	Epoxy	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	
	Phenolics	*5	*5	*5											*5	*5	*5	*5	*5	*5	*5	*5	
	Gelcoat/Topcoat	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*5	*5	*5	*4)*5	*4)*5	*5	*4)*5	*4)*5	*5	*5		*4)*5)
	RTM	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		*5	*5					
	SMC/BMC	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5				*4)*5	*4)*5		*4)*5	*4)*5				
	Pultrusion Laminates	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5	*4)*5					*4)*5	*4)*5		*4)*5	*4)*5				
RIM	P-DPCPD (Telene, Metton)	*4)*6	*4)*6											*4)*6	*4)*6		*6	*6					
	Polyurethane	*5	*5										*5	*5	*5	*5	*5	*5					
	Polyamid	*2	*2	*2										*4)*5	*4)*5		*4)*5	*5					
	PMMA/PC/ABS/PS/PVC	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5	*5		
Others	Polyolefines																						
	ESG Glas	*3	*3											*3	*3	*3							
	Enamel	*3	*3											*3	*3	*3							
	Ceramics	*3	*3	*3										*3	*3		*3	*3					
	Wood																						
	Plywood																						
	Rubber																						
	Metallics																						
	Honeycombed materials																						
	Concrete	*5	*5																				
	Natural Stones	*5	*5																				
	Automotive Paints																						
	PP/PE																						
	Teflon																						
	Viton																						

**Selection:**

- excellent choice
- good choice
- testing required
- not recommended

**Surface Preparation:**

- \*1) AP1 metal cleaner
- \*2) AP2 plastic cleaner
- \*3) AP3 glas cleaner
- \*4) Roughen 40 grit
- \*5) IPA wipe
- \*6) n-Heptane

All above mentioned recommendations are based on internal test results on various test substrates. Due to high potential variations in each substrate and surface chemistry this selection guide has to be used only as general guideline. EBS strongly recommends to test each substrate under final application scenario to determine correct suitability.