

ACRALOCK®

Engineered Bonding Solutions

ACRALOCK Structural Adhesives by Engineered Bonding Solutions, LLC are advanced two component primerless methacrylate structural adhesives designed to bond chemically to most surfaces, providing a permanently locked or integrated assembly of steel, aluminium, engineered plastics, high performance composites and other materials in mix ratio 1:1 and 10:1.

ACRALOCK Structural Adhesives, mix ratio 1:1

1:1 Products are available as: 200 l drum | 20 l pail | 400 ml cartridge | 50 ml cartridge

ACRALOCK SA 1 series are advanced two component, 1:1 mix ratio, high shear strength, high temperature resistant, coupled with excellent toughness, medium elongation, universal and primerless metal bonding adhesives.

SA 1 series is available in different adhesive and activator combinations to achieve three working times of 5, 15 and 50 min in natural color and is designed to bond as received metals, composites and plastics including difficult to bond surfaces like Stainless Steel, Nylon, Rubbers and Galvanized metals with minimal to no surface preparation.

SA 1 series is the best choice for applications where high temperature resistance is necessary.

Acralock SA 1 series is R1, HL3 fire approved according EN 45545 - 2.



ACRALOCK HS 1 series are advanced two component, 1:1 mix ratio, high shear strength coupled with excellent toughness, medium elongation, universal and primerless metal bonding adhesives.

HS 1 series is available in different adhesive and activator combinations to achieve two working times of 5 min and 15 min in black color and is designed to bond as received metals, composites and plastics including difficult to bond surfaces like Stainless Steel, Nylon, PolyDCPD (Telene), Rubbers and Galvanized metals with minimal to no surface preparation.

HS 1 series is approved for Telene Bonding.

ACRALOCK SA 1-300 series are advanced two component, 1:1 mix ratio, medium shear strength, medium gap fill coupled with excellent toughness, medium elongation, general purpose and primerless metal bonding adhesives.

SA 1-300 series is available in different adhesive and activator combinations to achieve two working times of 5 min and 15 min in natural color and is designed to bond as received metals, composites and plastics including difficult to bond surfaces like Stainless Steel, Nylon, Rubbers and Galvanized metals with minimal to no surface preparation.

SA1-300 series is the best choice when a 1:1 system for medium gap fill application is required.

ACRALOCK SA 1-500 series are advanced two component, 1:1 mix ratio, medium shear strength, high viscosity, high gap fill coupled with excellent toughness, medium elongation, general purpose and primerless metal bonding adhesives.

SA 1-500 series is available in different adhesive and activator combinations to achieve 4 working times of 10, 30, 60 and 90 min in grey color and are designed to bond as received metals, composites and plastics including difficult to bond surfaces like Stainless Steel and Galvanized metals with minimal to no surface preparation. SA1-500 series is the best choice when a 1:1 system with long open time and less sagging is required.

ACRALOCK HT 1-900 series are advanced two component, 1:1 mix ratio, high shear strength, very high temperature resistant, high gap fill coupled with excellent toughness, low elongation, special primerless metal bonding adhesives.

HT 1-900 series is available as a high viscosity version of 60 and 90 min working time and is designed to bond as received metals, composites and plastics including difficult to bond surfaces like Stainless Steel and Galvanized metals with minimal to no surface preparation.

HT 1-900 series was specially developed for elevated temperature applications and fulfills the DNVGL CP0086 windcraft criterias.



Product	Description	Colour	Mix Ratio	Viscosity (Pas)	Working Time (min)	Fixture Time (min)	Gap Fill (mm)	Tensile Strength (MPa)	Tensile Elongation (%)	Lap Shear Strength (MPa)
SA 1 series, 1:1 ratio, low gap fill, galvanized surface bonding, low viscosity structural adhesive series										
SA 1-05	Low Gap Fill Galvanized High Temperatur	natural	1:1	A: 200 - 400 B: 200 - 400	5 - 8	> 15	0,1 - 5	18 - 25	50 - 75	22 - 30
SA 1-15		natural	1:1	A: 200 - 400 B: 200 - 400	15 - 20	> 45	0,1 - 5	18 - 25	50 - 75	22 - 30
SA 1-90		natural	1:1	A: 200 - 400 B: 200 - 400	45 - 55	> 180	0,1 - 5	18 - 25	50 - 75	22 - 30
HS 1 series, 1:1 ratio, low gap fill, Telene bonding, low viscosity, structural adhesive series										
HS 1-05	Low Gap Fill Galvanized Telene Bonder	black	1:1	A: 100 - 300 B: 100 - 300	4 - 7	> 15	0,1 - 5	18 - 20	75 - 100	20 - 22
HS 1-15		black	1:1	A: 100 - 300 B: 100 - 300	15 - 20	> 45	0,1 - 5	18 - 20	75 - 100	20 - 22
SA 1 - 300 series, 1:1 ratio, medium gap fill, low viscosity, general purpose structural adhesive series										
SA 1-305	Medium Gap Fill Galvanized General Purpose	natural	1:1	A: 100 - 300 B: 100 - 300	5 - 8	> 15	0,5 - 10	18 - 20	70 - 90	18 - 20
SA 1-315		natural	1:1	A: 100 - 300 B: 100 - 300	15 - 20	> 45	0,5 - 10	18 - 20	70 - 90	18 - 20
SA 1 - 500 series, 1:1 ratio, large gap fill, high viscosity, general purpose structural adhesive series										
SA 1-510	Large Gap Fill High Viscosity Galvanized	grey	1:1	A: 300 - 500 B: 200 - 500	10 - 15	> 45	0,5 - 15	18 - 20	100 - 150	18 - 20
SA 1-530		grey	1:1	A: 300 - 500 B: 200 - 500	30 - 40	> 120	0,5 - 20	18 - 20	100 - 150	18 - 20
SA 1-560		grey	1:1	A: 300 - 500 B: 200 - 500	50 - 65	> 150	0,5 - 25	18 - 20	100 - 150	18 - 20
SA 1-590		grey	1:1	A: 300 - 500 B: 200 - 500	80 - 100	> 200	0,5 - 25	18 - 20	100 - 150	18 - 20
HT 1-900 series, 1:1 ratio, high viscosity, high temperature resistant structural adhesive series										
HT 1-960 HV	Very High Temp. Large Gap Fill	grey	1:1	A: 300 - 500 B: 200 - 400	50 - 70	> 180	0,5 - 50	31 - 35	10 - 40	28 - 31
HT 1-990 HV	Very High Temp. Large Gap Fill	grey	1:1	A: 300 - 500 B: 200 - 400	90 - 100	> 240	0,5 - 50	31 - 35	10 - 40	28 - 31