



M 8216 Plastic Aluminium

M 8216 is special two component adhesive, **fast curing in cold, polymer adhesive** having an excellent tenacity destined for fast reparation, constructional applications with open handling time, **filled with aluminium and titanium dioxide**.

M 8216 is suitable for bonding and reparation broad range of different surfaces incl. aluminium, aluminium alloy, steel, PVC, polyester, polycarbonate and zinc-coated iron.

M 8216 offers you an excellent tenacity, solidity, elasticity. It is specially suited for using in engineering, electronic (fibre-glass) and car industry and repair business. M 8216 is advised for aluminous and steel castings, conduite, pump casing, damaged flanges, keyseats of cast-iron components etc.

M 8216 is good temperature resistant 140 -145° C (longterm) and 170 - 180° C (short-term).

- ✦ **High temperature resistant**
- ✦ **Filled with aluminum and titanium dioxide**
- ✦ **Easy to use**
- ✦ **High chemical resistant**
- ✦ **Viscous – doesn't run down**
- ✦ **Fast curing**
- ✦ **Not fragile – doesn't crack**
- ✦ **Temperature expansivity such as aluminum**



Application methods:

- For better tenacity is suitable rough the surface (grinding machine, wire brush, rasper) and recess.
- Bonding surfaces must be clean and clear of fat, power and further impurities. Degrease with S 1950, S 1960.
- Mix the same quantity (weighted and voluminous) of both components and thoroughly mix.
- Apply to 1 surface and put both surfaces together under a small pressure.
- Remove the overflowing material before curing.
- Leave it to cure at room temperature at least 30 minutes at 20°C.
- Final curing come in 24 hours at 20°C.
- After 20 hours can be drilling, scurfing, coating or another way working.



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Typical adhesive characteristics:

Physical form	: viscous fluid
Chemical type	: component 1: resin with aluminum and additives component a 2: polymer with titanium dioxide
Colour	: component 1: light grey - aluminium component 2: white
Density	: component 1: 1,70-1,85 component 2 : 1,70-1,80
Hardness Shore D 24 hours	: 70 – 80
Viscosity /poise @ 25°C/	: component 1: 13000 – 15000 cps , component 2: 40000 – 45000 cps
Mixture proportion	: 1:1
Gelatination time	: 15 minut, úplné vytvrzení za 1 hod.
Temperature resistance	: - 40 + 140°C till + 180°C

Curing:

M 8216 cure minimally at +5°C, must be expected longer time than at 20 – 25°C.

Temperature influence accelerates grade of curing.

- ✚ Working time at 20 až 25°C is 3 - 4 minutes.
- ✚ Gelatination time at 20 till 25°C is 5 - 6 minutes.
- ✚ Get dry on the surface at 20 till 25°C is 10 - 15 minutes.
- ✚ Handling time at 20 till 25°C is 30 minutes.
- ✚ Final solidity at 20 till 25°C is 24 hours.

Exothermic top (100g mass) is 95 – 100°C

Typical commissure characteristic:

Tensile strength at break:	470 – 520 kg/cm² (ASTM D 638)
Bending resistance:	550 – 650 kg/cm² (ASTM D 790)
Strength on steel:	32 – 34 kg/cm² (ASTM C 482)
Compressive strength:	550 – 650 kg/cm² (ASTM D 695)

Bond strength M 8216 : Substrates Kg/cm²

steel- steel	276 - 342	polyester-polyester	31
aluminum – aluminum	284	hard PVC- hard PVC	35 substrate was broken
copper - copper	214	ABS-ABS	27
stainless steel - stainless steel	194	styrol-styrol	14
brass – brass	208	epoxy FRP-epoxy FRP	84 substrate was broken
chrome - chrome	132	fenol FRP-fenol FRP	65 substrate was broken
nickel - nickel	163		
zinc – zinc	187		

Chemical resistance: Good chemical resistance even to concentrated acids and alkali, oils and petrol.



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Packaging

M 8216 is supplied in 25 ml syringe cartouches.

Storage

If the product M 8216 is dry placed in closed vessels stocking at the temperature between 5 and 25°C , the storage will be 12 months.

Health and safety

This TDS doesn't contain MSDS. Read the Material Data Sheets of M 8216 before using.

Supplied by :



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