

TECHNICAL DATASHEET

# STALOC POWER 710

2-component power adhesive

## PRODUCT DESCRIPTION

STALOC POWER 710 adhesive has excellent impact, peel and tensile shear strength. The powerful adhesive offers excellent weather resistance. STALOC POWER 710 is quick to set and only requires little surface preparation. However, a gap of 0.5 to 1mm must be maintained to achieve optimal adhesion.

## PHYSICAL PROPERTIES

ATTRIBUTE	UNIT	SPECIFICATION
basis		methylmethacrylate
colour		creme
gel time	min	~ 15 to 18 min.
fixture time (depending on temp.)	min	30-35 min.
final cure	h	24 h
mixing ratio		1:1
shore hardness (ASTM D 2240)		66
temperature resistance	°C	-50°C to +120°C
application temperature	°C	+10°C to +30°C
shrinkage		5%
tensile strength (DIN 53283)	N/mm <sup>2</sup>	steel / steel: ~ 29 N/mm <sup>2</sup> aluminum / aluminum: ~ 27 N/mm <sup>2</sup> ABS/ABS: ~ 18 N/mm <sup>2</sup> composite / composite: ~ 16 N/mm <sup>2</sup> polycarbonate / polycarbonate: ~ 8 N/mm <sup>2</sup>
shelf life at +25°C	months	~ 9 months

## FEATURES

- Bonds metal, stone, ceramics, wood, plastics, etc.
- Extremely high strength
- Excellent resistance against chemicals
- Weather resistance
- Sustains a certain level of flexibility, even when finally cured
- Easy to use
- STALOC POWER 710 realizes high strength bonds with little surface preparation

## CHEMICAL RESISTANCE

A = excellent resistance, B = low effect, C = severe effect

substance	
water	A
saltwater	A
oils and greases	A
gasoline and diesel	A
water 90°C	B
glycol / water blend (antifreeze protection)	B
acetic acid 10%	B
xylene	B
highly-concentrated acid	C



## SUBSTRATES

The product is suitable for use on the following substrates:

### metal substrates:

- aluminum (anodized, sanded, blank)
- sheet metal
- stainless steel
- steel / casted steel parts (galvanized, sand-blasted, phosphated, chrome-plated, etc.)
- non-ferrous metals (copper, brass, etc.)
- painted metal surfaces

### plastics:

- ABS
- PA
- PC and PMMA
- Polyester
- PUR
- PVC
- TPO

### composite and other substrates

- fibre re-inforced plastics
- EPDM / PP-EPDM
- glass
- stone, ceramics, marble, natural stone, basalt, etc.
- wood

## APPLICATION INFORMATION

Recommended application – further information can be found in the material safety data sheet

The parts to be bonded must be clean and free of oil and grease. Roughening the surfaces increases the strength of the bond. Cut off the tip and squeeze out STALOC Power 710; the mixing ratio is controlled automatically. Mix the material until an even colour is achieved. Then apply to the parts using a spatula or similar. The fixture time is 30-35 minutes. Final hardening takes 24 hours. Seal the cartridge again after use, with the stopper (in the plunger). Do not use in outdoor temperatures below 10°C.

## SAFETY INFORMATION

Please send your request for the latest version of the material safety data sheet (MSDS).

## PACKAGING / VOLUME

25ml double cartridge - 14 pcs. per box

50ml double cartridge - 12 pcs. per box (use original STALOC guns for application)

400ml cartridge



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Issued: 04.05.2012



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