

TECHNICAL DATASHEET

STALOC HP-950 STRUCTURAL ADHESIVE

adflex-technology

PRODUCT DESCRIPTION

STALOC HP-950 structural adhesive is a high-performance structural adhesive for bonded joints requiring high-strength, elasticity, impact resistance as well as resistance against tensile loads and vibrations.

The high elongation as well as the excellent resistance against UV radiation ensures a safe use of STALOC HP-950 structural adhesive.

STALOC's *Adflex-Technology* provides for an ideal combination between elasticity and bonding strength.

PRODUCT CHARACTERISTICS

- *adflex-technology* for extreme loads
- excellent UV- and ageing-resistance
- excellent resistance against water, saltwater, desalinated water, light acids and bases, various oils, etc.
- permanently elastic in a range from -40°C to +150°C

AREAS OF APPLICATION



- Flexible / sealing bonds for the construction of busses, caravans, rail and truck applications
- Bonding of composite materials
- Bonding of solar systems, sunroofs and terrace products
- Component bonding of boats, yachts and vessels
- Bonding of polyester parts onto metal structures
- Bonding of window profiles

TECHNICAL PROPERTIES

ATTRIBUTE	UNIT	SPECIFICATION
basis		Modified methacrylate adhesive <i>with adflex-technology</i>
colour		black
pot life	min	2 to 3 min.
finger-tight (depending on temperature)	min	4 to 6 min
final cure time	h	24 h
Mixing ratio		10:1
Shore hardness (ASTM D 2240)		74
Contains solvents		No
temperature resistance	°C	-40°C to +150°C
working temperature	°C	+10°C to +35°C
maximum elongation	%	140 %
shear strength (DIN 53283)	N/mm ²	non-alloy steel: 21 N/mm ² stainless steel 18 N/mm ² Alu: 19 N/mm ² ABS/ABS: substrate failure PMMA: substrate failure
Recommended gap	mm	250 µm to 3-4 mm
Shelf life at max. +20°C		approx. 9 months

CHEMICAL RESISTANCE

A = excellent resistance, B = minor effect, C = destructive effect

Substance	
Water	A
Saltwater	A
oil and grease	A
gasoline and diesel	A
water @ 90°C	B
Glycol / water-mixture (anti-freeze)	B
Acetic acid 10%	B
Xylene	B
Highly-concentrated acids	C

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. Use STALOC assembly cleaner for surface preparation. Roughening the surfaces increases the strength of the bond, but is not imperative. Mount the mixer and squeeze out the adhesive; the mixing ratio is controlled automatically. Mix the material until an even colour is achieved. Distribute the adhesive on the bonding surface using a spatula or similar if necessary. The fixture time is 12 minutes at room temperature. Lower temperatures increase the necessary fixture time. Final cure takes 24 hours. Seal the cartridge again after use, with the stopper (in the plunger). Do not use if ambient temperatures and substrate temperatures are below 10°C.

SUBSTRATE

The product can be used for the following substrates or bonding partners:

metallic materials:

- Aluminium (anodized, ground, blank)

- Carbon steel and tin plate steel
- Stainless steel
- Steel cast parts (galvanized, chrome plated, blasted, etc.)
- Non-ferrous metals (copper, brass, etc.)
- Painted metal surfaces

plastics:

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

composite and other materials

- GFK / CFK
- EPDM / PP-EPDM
- glass
- wood

SAFETY INFORMATION

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

PACKAGING / VOLUME

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

380 and 490ml cartridge – 6 pcs. per box

20 l and. 200 l drums optional

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