

TECHNICAL DATASHEET

# STALOC EX-500 STRUCTURAL ADHESIVE

2-component modified acrylic

## PRODUCT DESCRIPTION

STALOC EX-500 has excellent impact, peel and tensile shear strength. The powerful adhesive offers excellent weather and temperature resistance. STALOC EX-500 is quick to set and only requires little surface preparation.

## PHYSICAL PROPERTIES

ATTRIBUTE	UNIT	SPECIFICATION
basis		acrylate
colour		red / green
gel time	min	~ 3 to 4 min.
fixture time (depending on temp.)	min	4 to 6 min.
final cure	h	6 to 8 h
mixing ratio		1:1
shore hardness (ASTM D 2240)		55
temperature resistance	°C	-30°C to +150°C
application temperature	°C	+10°C to +30°C
shrinkage		0,75%
tensile strength (DIN 53283)	N/mm <sup>2</sup>	steel / steel: ~ 27 N/mm <sup>2</sup> aluminum / aluminum: ~ 23 N/mm <sup>2</sup> ABS/ABS: ~ 4,5 N/mm <sup>2</sup> composite / composite: ~ 6,5 N/mm <sup>2</sup> polycarbonate / polycarbonate: ~ 6 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 EX-500 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 EX-500; 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 4-6 minutes. Final hardening takes ~8 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

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

The information and data in this document are for information purposes only. STALOC cannot take responsibility for the results obtained by a third party, whose methods are not under STALOC control. The determination of the suitability for the user's purpose of any STALOC product is the responsibility of the client. Consequently, STALOC recommends testing of the products before using it for a series application. Moreover, it is the responsibility of the customer to ensure a safe environment for the user. STALOC therefore disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of STALOC products. STALOC cannot be held liable for any consequential or incidental damage resulting from the use of a STALOC product, including lost profits or damages of any other kind. Products or processes mentioned herein might be subject to released or pending patents or licences.

Issued: 04.05.2012



call STALOC



[www.staloc.com](http://www.staloc.com)