RUDOLPH BROS. & CO.
ADHERING TO QUALITY

1-800-375-0605
Option 8 for 24/7 Service

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AAS 5310

Metal Bonding Methacrylate Adhesive

PRODUCT DESCRIPTION

AAS 5310 is a 1:1 meter- mix, methacrylate-based, structural adhesive formulated to bond almost all engineered thermoplastics, thermosets, composites and metal structural elements together in any combination. It has excellent adhesion to as-received metal surfaces including aluminum, stainless and plated steels and forms tough, high strength bonds without surface preparation, primers, or chemical wipes. It features a medium cure time for assembly flexibility to allow for positioning and multiple operations but provides for faster fixturing. AAS 5310 has outstanding durability and environmental resistance to many common industrial solvents, fuels, lubricants and environmental conditions. This product is formulated as a non-sag, creamy gel with matched viscosity for both parts, and is easy to dispense through static mixer tubes and other dispensing equipment.

PROCESS & PERFORMANCE BENEFITS

Primerless	**Room Temperature Cure**
As received bonding	**Convenient 1:1 mix ratio**
Chemically resistant	**Gap filling to 0.125 inches**
Bonds diverse substrates	**Extended working time**

UNCURED PROPERTIES

	Part A	Part B
Viscosity, cps Spindle TD, 2.5rpm)	200,000	200,000
Density (lbs/gal)	8.07	8.05
Color	Off White	amber
Flash Point (LCC)	51°F	51°F
Mix Ratio (wt & volume)	1 : 1	

CURING PROPERTIES*

Mixed Viscosity, cps (#4, 6rpm)	200,000
Mixed Density (lbs/gal)	8.05
Working Time	8-10 minutes
Fixture Time	18-22 minutes

* Curing properties are highly dependent on the specific application and the materials being bonded. The ranges used here are based on representative examples of typical applications.

CURED PROPERTIES

Hardness	70D
Elongation	25%
Operating Temp	-40° - 250°F

BOND PERFORMANCE

PPO-HIPS.....Stock Failure
Fiberglass/Fiberglass*.....Stock Failure
PVC/PVC.....Stock Failure
Steel/Steel.....4200 psi
SMC/SMC.....Stock Failure
ABS/ABS.....Stock Failure
PMMA/PMMA.....Stock Failure
Alum/Aluminum.....>3300psi
Peel Strength, Steel/Steel(ASTM D1876).....15-20 pli
Impact Strength FG/FG, Auto Side Impact.....>13 J/ in2
*Fiberglass to gelcoat or gelcoat to gelcoat provides stock failure

CHEMICAL RESISTANCE

AAS 5310 exhibits excellent resistance to commonly encountered service environments and chemicals. Depending on the materials being bonded, AAS 5310 will retain bond strength in boiling water, salt water, salt fog, kerosene, gasoline, diesel fuel, antifreeze, hydraulic fluids, and cutting oils. Resistance to specific chemicals and environments must be tested.
NOT RECOMMEND FOR EXPOSURE TO: Crude oil, toluene, MEK, Acetone,100% low molecular weight aromatics, aldehydes, and ketones.

PACKAGING & SHELF LIFE

The AAS 5310 is available in cartridges, pails, and drums. The material can be used with conventional meter/mix/dispense equipment. All materials should be stored in a cool place when not used for an extended period of time. Shelf life of this product is six (6) months at 23°C when stored in original sealed container. Shelf life may be extended with refrigeration. Do not freeze.

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