

AXIOM 100 PM

ACRYLIC ADHESIVE

AXIOM 100 PM is a pre-mix, high performance two part structural acrylic adhesive from Bostik, which provides high strength bonds to a wide range of substrates.

The two component adhesive is extruded as a single pre-mixed bead using a twin cartridge system. The system's ease of use and accuracy of application mean increased productivity.

AXIOM 100SA/AXIOM 100 PM is now approved by the UK Ministry of Defence quality assurance. The release document relating to AXIOM 100 SA/AXIOM 100 PM is AFS No.2318.

Additional Features:

- * Fast bonding, handling strength in approximately 10 to 15 minutes at 22°C.
- * Easy to use cartridge system for accurate application.
- * Excellent temperature resistance (-40°C to +120°C).
- * Up to 4mm gap fill.
- * Non-sagging.
- * Controlled mixing for consistent bond strength.
- * Simple 1:1 ratio mix.
- * Various pack sizes to suit different application requirements.
- * Tough, durable bonds with excellent bond strength across a wide range of substrates.
- * Good chemical resistance.
- * Low odour acrylic adhesive and activator.

RECOMMENDED USE

AXIOM 100 PM Acrylic Adhesive provides high strength bonds across a wide range of most plastics, composites and many common metals.

Typical uses are:-

- * For structural bonding.
- * For products assembly and repair.
- * Bonding plastics including polycarbonate, rigid polystyrene and acrylic e.g. Perspex.
- * Bonding most common metals including aluminium, mild and stainless steel.

BONDING INSTRUCTIONS

FOR 50ML AND 200ML CARTRIDGES:

1. For best results use on clean, dry substrates between +10°C to +30°C.
2. Insert the cartridge into the slot on the gun.
3. Once the cartridge is secure, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixer nozzle.
4. Attach the mixer nozzle and dispense adhesive until a uniform colour is evident.
5. Apply the mixed adhesive to one joint surface, immediately bringing the two surfaces into contact, and apply firm steady pressure for approximately 3 minutes.
6. The cartridge can be resealed, if only partly used by removing the mixer, cleaning the two cartridge openings and replacing the cartridge cap.

This Product Data Sheet covers just one of a large range of products supplied by Bostik Findley Limited. Full information on these products and advice on application is freely available from our fully trained staff throughout the country. In addition, specialist technical advice is available from our Technical Services Department. This Product Data Sheet supersedes all previous technical information on this product, and users of it are cautioned to ensure that it is the current issue. Destroy all previous Product Data Sheets, and if any doubt, contact Bostik Findley Limited, quoting the code number in the top right hand corner on the front of this document. This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. The company cannot accept any responsibility for loss or damage that may result from the use of this information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

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FOR 5 LITRE ADHESIVE AND 5 LITRE ACTIVATOR L (PM):

1. For best results use on clean, dry substrates between +10°C and +30°C.
2. When using automated dispensing equipment, follow the equipment manufacturers instructions.
3. Ensure that the dispenser is set at the correct adhesive to activator ratio, one to one by volume.
4. The adhesive and activator should be mixed by using the correct size static mixer.
5. Apply the mixed adhesive to one joint surface and immediately bring the two surfaces into contact and apply firm, steady pressure for approximately 3 minutes.

Some plastics are sensitive to environmental stress cracking when used with adhesives. Polycarbonate, rigid PVC, ABS, and polystyrenes fall into this group. AXIOM 100 PM presents a low risk, but it is advisable to check the suitability of the system on these materials before use.

SURFACE PREPARATION:

Surfaces to be bonded should be free from dust and dirt, as good surface preparation e.g. abrasion and solvent cleaning improve bond strength and durability.

Aluminium:	Advisable to degrease with BOSTIK CLEANER/ THINNER N (M576) and abrade or grit blast, then degrease again.
Ferrous Metals:	Advisable to degrease with BOSTIK CLEANER/THINNER N (M576). For high stress durability degrease then grit blast, then degrease again.
Thermoplastics:	Wipe surface with a dry cloth and where appropriate degrease with isopropanol.
Thermosets:	Advisable to clean with BOSTIK CLEANER/THINNER N (M576). For high stress applications substrate should be lightly abraded then cleaned with BOSTIK CLEANER\THINNER N (M576).
Sheet Moulding Compounds (SMC):	Advisable to clean with BOSTIK CLEANER\THINNER N (M576), lightly abrade and clean with solvent again.

For cleaning off uncured resin BOSTIK CLEANER/THINNER N (M576) can be used. Cured adhesive is best removed by trimming with a knife or abrasion.

CURE TIME:**AXIOM 100 PM**

Open Time:	Approximately 3 minutes
Working Time:	4-8 minutes
Handling Time:	10-15 minutes
Full Cure:	24 hours (All at +22°C)

TYPICAL CHARACTERISTICS

	<u>Part A</u>	<u>Part B</u>
Physical Form:	Viscous liquid	Viscous liquid
Appearance:	Off white	Yellow
Specific gravity:	1.0	1.0
Mixing ratio by volume:	1.0	: 1.0
Temperature resistance:	-40°C to +120°C	
Temporary temperature resistance:	+200°C for 20 minutes (avoiding load stress)	

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Maximum gap fill: 4 mm
Application temperature: +10°C to +30°C
Tensile shear strength: Up to 24 Mpa (dependant on substrates being bonded)

PACKAGING

Please refer to Customer Service Department for current package sizes and accessories.

STORAGE

Store in a dry cool place between 5 and 25°C.

SHELF LIFE

1 year after the date of manufacture stored under the above conditions.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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