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Technical Data Sheet

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JIONT ADHESIVE CHMA600

CHMA600 is a two-part methacrylate structural adhesive designed for bonding and assembling solid surface, natural stone, and sintered stone .It create excellent adhesion for acrylic solid surface ,polyester artifical stone.polyester artificial stone, quartz stone, and natural stone, with outstanding yellowing resistance.

When CHMA600 is used with a hardener at a 10:1 ratio, the gel time is 5-10 minute and the curing time is 10-25 minutes. After CHMA600 hardening, it exhibits excellent ultraviolet stability, non-yellowing, high-temperature resistance, good water resistance, good impact resistance, and abrasion resistance.

Physical properties (unhardened) -room temperature 23°C

	Component A	Component B
Viscosity, CP:	20000-60000	2000-4000
Color:	Translucent or transparent (colorable)	Milky white or transparent
Density, G/CC):	1.05-1.2	1.05-1.1
Mixing ratio, volume:	10	0.9-1.1
Mixing ratio, weight	10.1	1

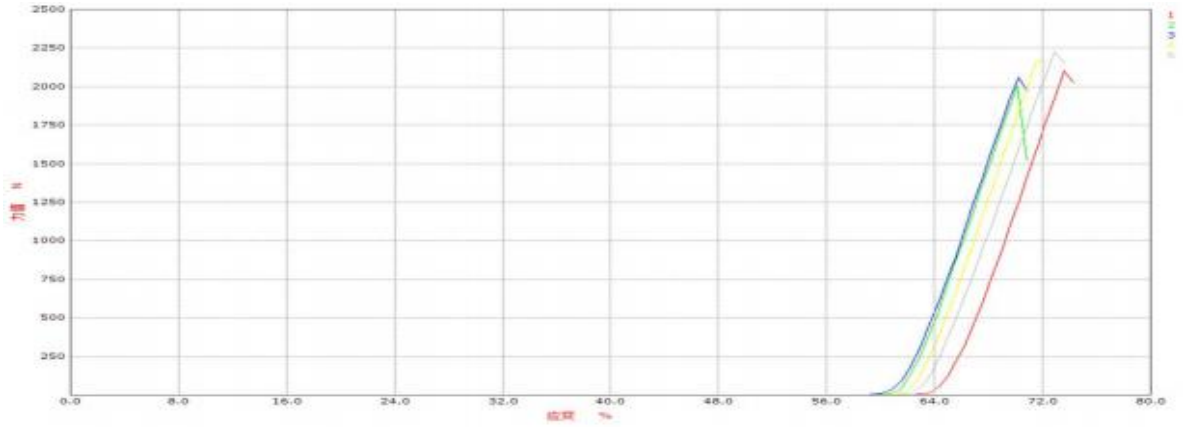
Operating time under different temperature conditions (the following data were measured under experimental conditions, with a mixing ratio of 10:1 by volume and a mixing amount of 10g)

Ambient Temperature ℃	Operating time min	initial curing time min	Polishable time (min)	extrusion
0	45	90	120	Difficult
5	30	60	90	normal
10	20	40	60	better
15	15	25	35	better
20	10	18	25	better
25	5	15	20	better

Note: The above datas are obtained in the laboratory with a mixing adhesive quantity of 10g. Actual construction environments, substrates, and adhesive quantities may vary slightly. If the temperature is below 10°C, appropriate heating is recommended.

Mechanical properties (after hardening) -room temperature cured for 72 hours

Three-point bending strength (MPa) (acrylic solid surface sheet /acrylic solid surface sheet) ≥16. Refer to GB/T2567-2008, Section 5.3 Bending Test.



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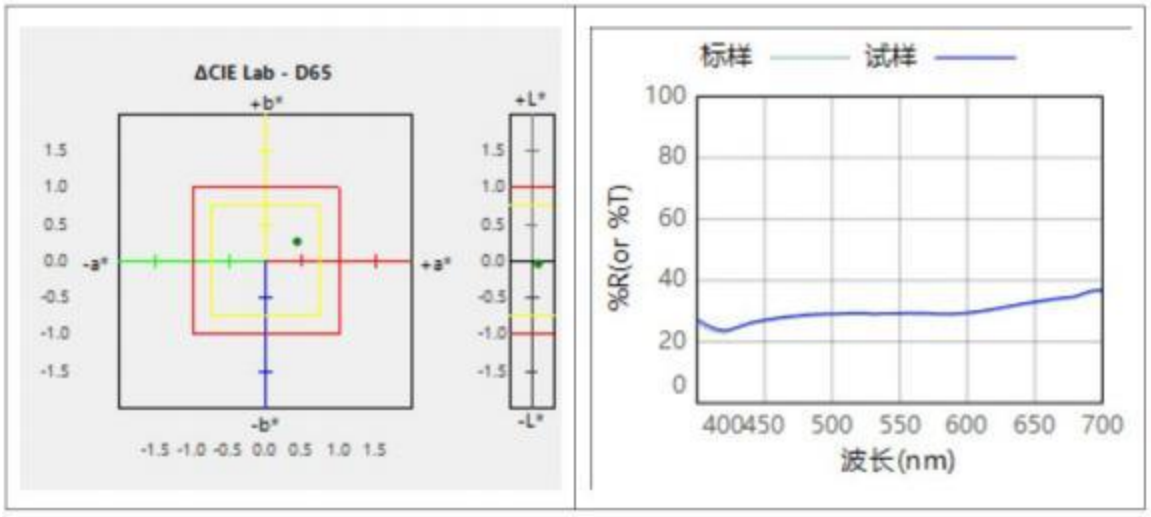
Weather resistance:

Aging resistance and yellowing performance: Refer to Standard GB/T16422.3-2006/ISO4892-3:2006.

Black standard temperature 60℃±3℃ and UVA340 UV light intensity 0.76W, under the condition of radiation exposure for 8hours, followed by 4 hours of connsation at black standard temperature 50℃±3℃.

ISO105-A02-1993: Gray card grade ≥4 or color difference meter test b-value ≤2.5.

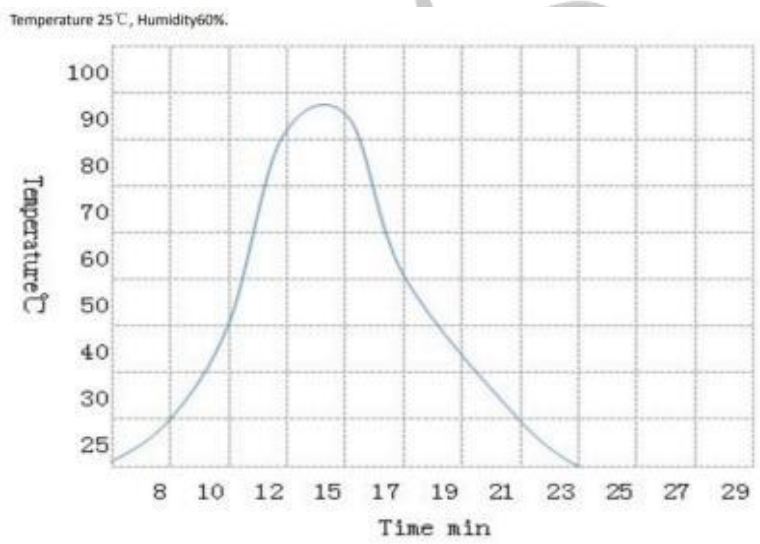


Temperature resistance: -55℃ to 121℃

Glass transition temperature Tg: 105℃

Heat release curve:

According to the 10:1 volume ratio mixed 10g test, the exothermic peak is reached in about 13 minutes



Recommended maximum coating thickness: 9.5mm (0.375 inches).

Advantages：

Yellowing resistance,fast hardening ,100% complete reaction ,can be sanded and polished ,color can be customized, no special surface treatment is required.

Environmental resistance:

Good water resistance, good impact resistance, abrasion resistance, high-temperature resistance, and UV resistance .

Applicable material:

Solid surface , sintered stone ,polyester artifical stone

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Precautions:

When not in use, seal the container to avoid contact with skin and eyes. In case of accidental contact, wash the skin with soap and water. The eye area must be rinsed with water for 15 minutes and seek medical attention immediately.

Due to the characteristics of rapid hardening , mixing a large amount of CHMA600 will releases a large amount of heat energy, and at the same time it releases heat, it also releases gas , just like boiling . The recommended maximum adhesive thickness is 9.5mm.

Operation method:

1. Operational Tools and Equipment

CHMA600 can be glued manually or with automatic equipment.

For the automatic glue application of the production line, a 10:1 two-liquid type, metering/mixing glue dispenser is used (the mixing device must be a static mixing tube or a dynamic mixing tube). However, the pipe joints and pumps of the dispenser must be made of stainless steel, and copper or copper-containing alloy materials must not be used. And the material of the oil seal and the compression should be Teflon, Teflon-coated PVC foam or PE. Viton, BUNA-N, chloroprene rubber or other elastomers should not be used. For related information, please consult our company.

2. Bonding method

Coat the mixed CHMA660 on either side of the two substrates on one side. After the glue is applied, it is necessary to complete the bonding, adjust the bonding surface, and apply pressure to fix it within working hours. After the initial curing of CHMA600 is achieved, it can be polished, packaged or assembled.

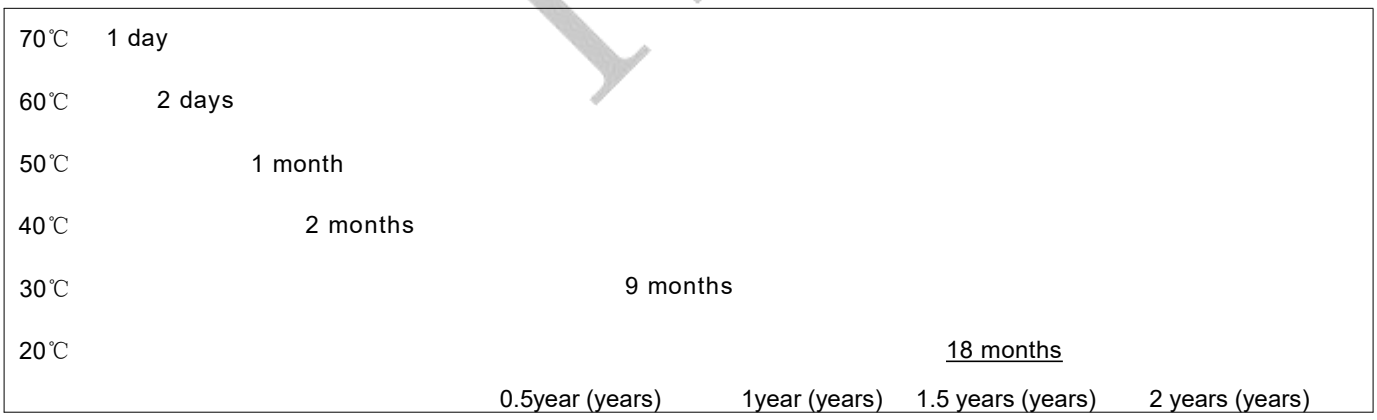
In order to maintain the normal curing speed, please apply glue at 15℃~30℃. If the temperature is lower than 15°C, the curing speed becomes slower, and if the temperature is higher than 30°C, the reaction speed becomes faster. The viscosity of the main agent and hardener of CHMA600 will change due to temperature.

In order to maintain the stable operation of the metering/mixing dispensing function of CHMA600, the main agent and hardener must be kept at an appropriate temperature. The maximum coating thickness should not exceed 9.5mm.

Storage period:

The shelf life of the main agent in CHMA600 is 18 months from the date of manufacturing when stored at 12.7°C (55°F) to 24°C (75°F), and 12 months for the hardener and round tube packaging. Prolonged storage at temperatures above 24°C will reduce the shelf life. Refrigeration at 7.2°C (45°F) to 12.7°C (55°F) can extend the shelf life.

The relationship between the storage period of sclerosing agents and storage temperature is shown in the following figure:



ILLUSTRATE:

The datas in this document are obtained under laboratory conditions. Due to the difference in use conditions, the terms should be analyzed and tested with reference to these data and usage conditions. Cohui adhesive does not guarantee the sales of cohui adhesive products and the use of cohui adhesive products under specific working conditions, and does not assume any direct , indirect or accidental loss responsibility.

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