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Technical Data Sheet

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SINTERED STONE ADHESIVE CHMA660

CHMA660 is a two-part polymethyl methacrylate structural adhesive . It is used for seamless jointing and installation for porcelain slabs and sintered stone, seamless jointing of external corners, seamless jointing of walls and floors, etc..It has high bonding strength to sintered stone and ceramic slabs, fast curing, can be polished, and long-lasting non-yellowing.

When CHMA660 adhesive is used with the hardener in a ratio of 10:1, the gel time is 5-10 minutes, and the curing time is 10-25 minutes. After CHMA660 is hardened, it has excellent UV stability, non-yellowing, high temperature resistance, and 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	1.02-1.1
Mixing ratio, volume:	10	0.9-1.1
Mixing ratio, weight	10.1	1

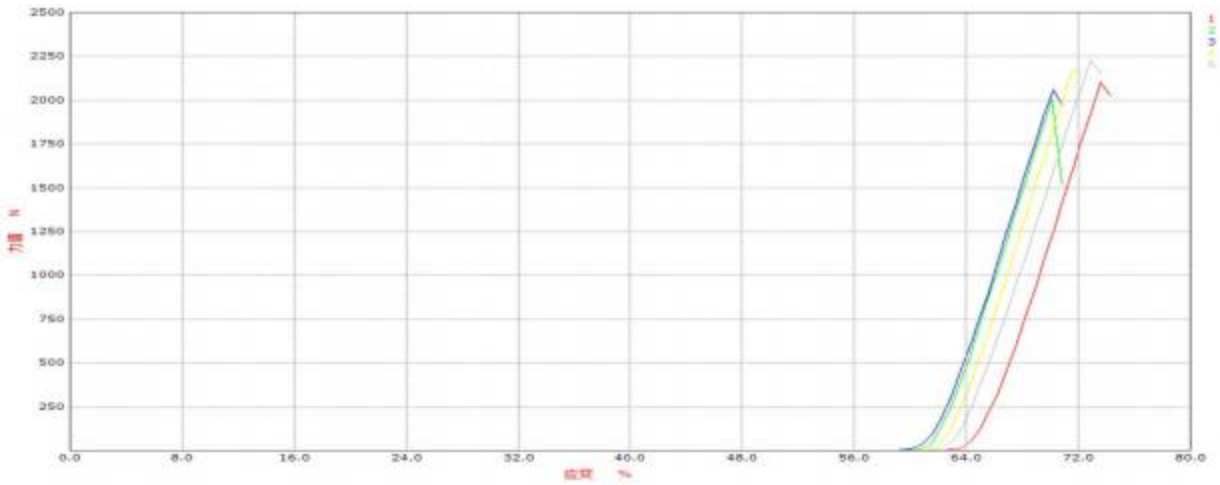
Operating time under different temperature conditions (the following data were measured under experimental conditions, with a mixing ratio of 10:1 by volume and a mixing amount of 10g)

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 measurements are obtained in the laboratory with a mixture of 10g adhesive. Actual application conditions, substrate types, 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

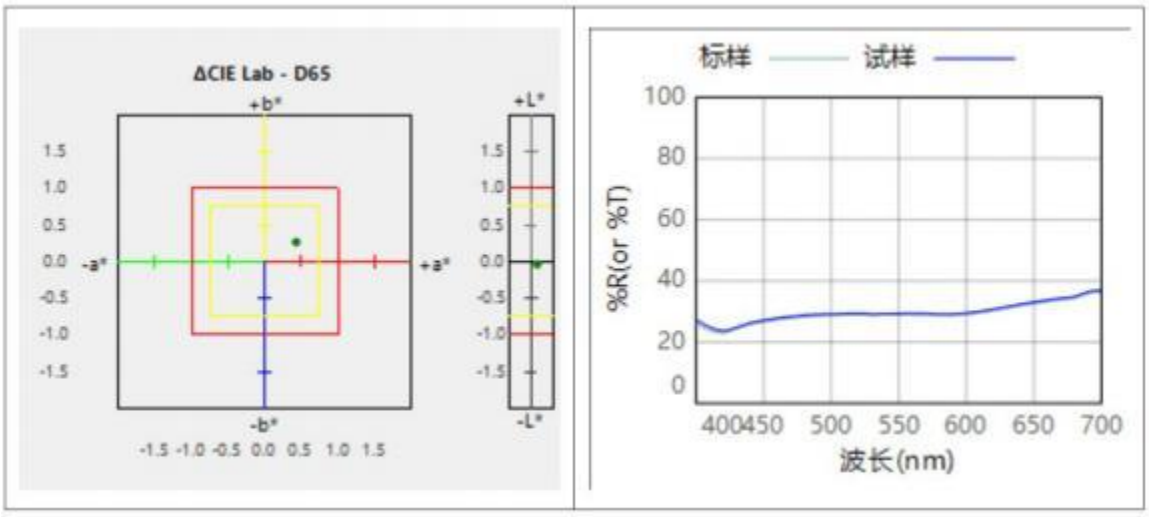
Three-point bending strength (MPa) ≥16 (sintered stone /sintered stone) – Refer to GB/T 2567-2008, Section 5.3 Bending Test



Weather resistance:

Anti-aging and yellowing performance: Refer to the standard GB/T16422.3-2006/ISO4892-3:2006. Under black standard temperature of 60℃±3℃ and UVA340 ultraviolet light intensity of 0.76W under the condition of radiation exposure for 8 hours, under black standard temperature of 50℃±3℃ condensation for 4 hours.

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

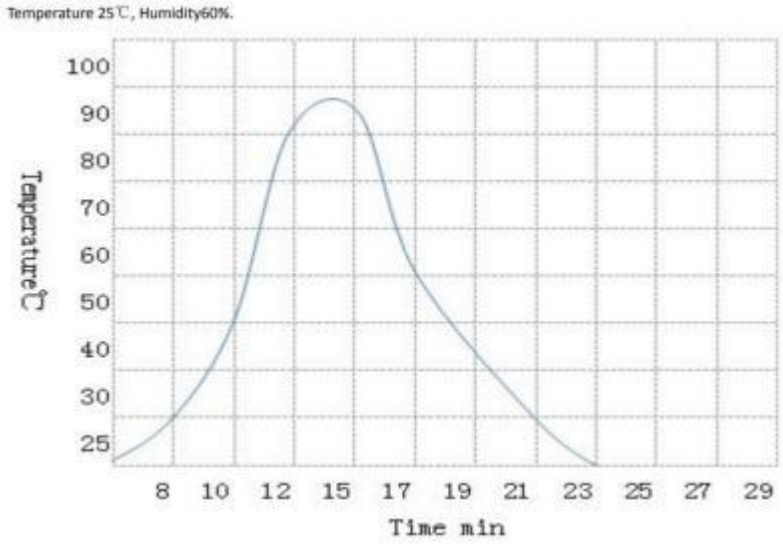


Temperature resistance: -55℃ to 121℃

Glass transition temperature Tg: 90℃

Heat release curve:

Mix 10g of the test substance at a volume ratio of 10:1, and the exothermic peak is reached in approximately 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:

Excellent water resistance, good impact resistance, abrasion resistance, high-temperature resistance, and UV resistance

Applicable material:

Sintered stone , ceramic slab .

Precautions:

Seal the container tightly when not in use 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 as soon as possible.

Due to the characteristics of fast hardening, mixing a large amount of CHMA660 will release a large amount of heat energy, and at the same time it releases heat, it also releases gas, just like boiling. The recommended maximum glue thickness is 9.5mm.

Operation method:

1. Operation tools and equipment

CHMA660 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 CHMA660 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 CHMA660 will change due to temperature. In order to maintain the stable operation of the metering/mixing dispensing function of CHMA660, the main agent and hardener must be kept at an appropriate temperature. The maximum coating thickness should not exceed 9.5mm

Storage period:

For CHMA660 at 12.7°C (55°F) ~ 24°C (75°F), the storage period of the main agent is 18 months from the date of manufacturing, and the hardener and round tube packaging is 12 months. Long-term storage in places above 24°C will shorten the storage period. Refrigeration at 7.2°C (45°F) ~ 12.7°C (55°F) can extend storage.

The relationship between storage period and storage temperature of hardener is as follows:

ILLUSTRATE:

The data 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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