



Technical Datasheet HOLDIT M3295

Revised Date: June 2011

Description

HOLDIT M3295 is a two component structural Methacrylate adhesive, designed for the bonding of high strength metal and composite applications. M3295 has been formulated from innovative technology, including our revolutionary adhesive system. This unique system enables the M3295 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use.

Applications

HOLDIT M3295 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners.

Typical examples shown below:

- Bonding metal fasteners to moulded composite parts.
- Bonding aluminium and stainless steel lettering in the sign manufacturing industry.
- Bonding automotive carbon fibre body panels.
- Bonding GRP in the marine industry.
- Bonding dissimilar metals for trailer fabrication.

Instructions for Use

1. Always consult the MSDS before using M3295 for the first time.
2. Carry out surface preparation where required.
3. Remove cap, and attach mixture nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner.
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

Properties of Uncured Material.

Resin	Methyl Methacrylate
Colour	Green/Pink
Appearance	Translucent Liquid
Shelf Life	12 months
Viscosity Brookfield T Bar	5,000 cPs
Cure System	Exothermic
Open Time	2-3 mins @ 20°C
Handling Strength	4-5 mins @ 20°C

Performance of Cured Material

ASTM D1002 Lapshear	Up to 25Nmm ²
ASTM D638 Tensile Strength	Up to 25Nmm ²
Gap Fill	2mm
Max Operating Temperature	-55°C to 125°C
Full Cure Time	24 hours



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Storage

HOLDIT M3295 should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C. This product has a 12 month shelf life from manufacture when stored at 22±4°C.

Presentation

HOLDIT M3295 is available in 25ml and 50ml cartridges.

Health & Safety in Use

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{mPa}\cdot\text{s} = \text{cP}$