



39897 PATCH PANEL ADHESIVE

TECHNICAL DATA SHEET

Description

39897 PATCH PANEL ADHESIVE is a non-sag, two component methacrylate adhesive system formulated to quickly bond metal surfaces without the use of an external primer. **39897** is a revolutionary fast-set acrylic that does not leave an after tack or waxy feel when fully cured. This adhesive is an easy to use 1:1 adhesive that maintains its strength over a wide temperature range and contains glass beads to insure adequate bond line control. Recommended substrates include steel, galvanized steel, aluminum and stainless steel.

Features

- Methacrylate technology
- Quick cure time
- Superior impact and peel strength
- Excellent environmental resistance
- Minimal surface preparation
- Glass beads for consistent bond line thickness
- 100% reactive
- Non-sagging gaps filled up to 1/2"

Typical Cured Properties

Peel strength (pli) on steel	20-40	ASTM D 3167
Tensile lap shear @ 77°F (25°C) (psi) on steel	3000-3800	ASTM D 1002
Tensile lap shear @ 175°F (79°C) (psi) on steel	2400-2600	ASTM D 1002
Bond line thickness	0.005-0.010" (0.127-0.254mm)	

Typical Uncured Properties

	Part A	Part B	Mixed
Working time @ 77°F (25°C)	-	-	5-10 minutes
Set time @ 77°F (25°C)	-	-	15-20 minutes
Color	Cream	Light Yellow	Light Yellow

Packaging

Container 7 oz **DUAL-MIX** cartridge with two static mixers

Handling and Application

PREPARATION: Bonding surfaces should be clean, dry and free of contamination. Minimal surface preparation is required for **39897**, and superior bonds can be formed on most substrates following directions.



MIXING:

It is highly recommended that adhesives be dispensed through a static mixer. Once mixed, **39897** should achieve a uniform color. This is important! Heat build up during and after mixing is normal.



Use Static Mixers: **70011 INTEGRAL NUT SQUARE STATIC MIXERS** (6 pack) or **70012 INTEGRAL NUT SQUARE STATIC MIXERS** (50 pack)

APPLICATION:



Use enough material to completely fill the joint when parts are clamped. Always follow step by step directions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time.

NOTE: Partial panel replacements are not warranted for cosmetics, as they may show a bond line or halo due to techniques in workmanship.

CURING:



Parts should remain undisturbed during the interval of time between the material's working time and set time. After the set time is achieved, the material has reached handling strength. Temperatures below 55°F (13°C) will slow the cure; above 85°F (29°C) will accelerate cure rate. To enhance cure time, heat to 120-140°F (49-60°C) for 15 minutes. At 77°F (25°C), **39897** sets in 15-20 minutes and fully cures in 30 minutes.

WELDING:



39897 is versatile and can be used with traditional welding methods or resistance spot welding techniques when following OEM recommendations.

CLEANUP:



It is important to clean up excess adhesive from the work area and application equipment before it cures. Use appropriate cleaning materials compliant with VOC regulations in your area. Keep containers tightly closed after use. Remove static mixer after use and replace with cap.

STORAGE:



39897 PATCH PANEL ADHESIVE should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **39897** is 1 year when stored at 40-77°F (4-25°C). Exposure above room temperature will reduce shelf life.

TECHNICAL CONSULTATION SERVICE

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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Users should review the Material Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and product label are available upon request.

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