

## ADBOND 5531 Methacrylate structural 2 parts adhesive

### DESCRIPTION

ADBOND 5531 is a high performance two part methacrylate adhesive engineered to bond a wide range of plastics, metals and composites assemblies. It offers outstanding bond strength, is extremely durable, with excellent impact and weathering properties. It is 100% reactive and cure at room temperature. ADBOND 5531 greatly increases the reliability of finished assemblies with exceptional flexibility. It has the ability to with stand extreme temperature fluctuation, thermal cycling and resistance to a wide range of chemicals and environmental conditions.

### PHYSICAL PROPERTIES

Uncured	
Color	Resin (A part) : off white Hardener (B part) : amber
Viscosity	Resin (A part) : 60,000 cps Hardener (B part) : 60,000 cps
Mixed density	8.2
Mix ratio	1:1 (by volume) 1:1 (by weight)
Work time	10 minutes
THIX index	5
Flash point	11°C (51°F)

Cured	
Tensile strength	3000 to 3500 psi
Shear strength	3000 to 3500 psi
Handling strength	30 minutes
Gap fill (maximum)	0.125"
Temperature range	-55°C to 121°C (-67°F to 250°F)

### SUBSTRATES THAT ADBOND 5531 CAN BOND

#### Metals

- Aluminum (anodized or chemically etched)
- Clean steel
- Stainless steel
- Coated metals

#### Thermosets

- Fiberglass
- Phenolics
- Gel coats
- Epoxy
- RIM urethane

**ADBOND 5531**  
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- Polyurethane
- Liquid molding resins

## Thermoplastics

- Acrylics
- ABS
- Polycarbonates
- Nylons
- PPO's
- Vinyl
- Styrene
- PEEK
- PBT Blends
- PET Blends

**APPLICATION**

- Vertical and horizontal panel assembly for truck body, trailer, bus, etc.
- Roof bow
- Vehicle body assembly
- Bonding of decorative elements or interior finishes
- Metal reinforcement
- Steel doors channel

**SURFACE PREPARATION**

Surface must be free of dust, oil, grease, frost or any other contaminant. Use ADSEAL CLEANER 6003 to clean all surfaces. Let it evaporate 20 minutes before adhesive application.

**METHOD OF USE**

ADBOND 5531 is easy to apply with manual or pneumatic 2K / 1:1 ratio equipment. The use of a 3/8 x 24 element static mixer (Adfast code DS99824) is recommended to ensure adequate mixing. Bonding should be done before skin formation. For best adhesion film thickness should be generally at 0.006" depending on substrates. Temperature of substrates and adhesive should be the same. The product is best used at temperature between 18°C (65°F) and 27°C (80°F). Temperature below 18°C (65°F) will slow the cure speed of the material and viscosities will be higher. Temperature above 27°C (80°F) will cause the material to cure faster and viscosities will be lower. For consistent dispensing maintain temperature in the above mentioned range. Uncured adhesive can be cleaned with a solvent such as NMP or mineral spirit. Cured adhesive can be removed only mechanically.

**ADBOND 5531**  
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- 400ml cartridges kit
- Drum / pail kit

**STORAGE**

The shelf life of the ADBOND 5531 is one year from date of manufacturing. Shelf life is based on the products being stored properly at temperature between 13°C (55°F) and 24°C (75°F). Exposure to temperature above 24°C (75°F) will reduce the shelf life of the product.

**CAUTION**

Always consult sds before using the adhesive. Apply usual hygienic rules. Always test the product on your application before use. For industrial use only. For more information, please contact your technical representative. **ADBOND 5531 is flammable. Keep away from heat, sparks and open flame.**

**IMPORTANT****READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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