

Technical data sheet



Product: 6070

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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CYBERBOND AL 6070

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Tewipack Uhl GmbH
Industriestraße 15
D-75382 Althengstett

Telephone:
+49(0)7051/9297-0
Fax:
+49(0)7051/9297-99

E-Mail:
info@tewipack.de
Website:
www.tewipack.de

Managing director:
Alexander Uhl,
Michael Uhl
HRB 330424
Amtsgericht
Stuttgart

Bank details:
Sparkasse
Sindelfingen
Pforzheim
Calw
BLZ 666 500
85
Konto 17 787

Commerzbank
Sindelfingen
BLZ 603 400 71
Konto 8 001 166

Vereinigte
Volksbank AG
Böblingen
BLZ 603 900 00
Konto 80 089
003

Postbank
Stuttgart
BLZ 600 100
70
Konto 146
294 708



AL 6070

Technical Datasheet

AL 6070 is a two component methacrylate adhesive. It is especially suited for bonding metals to different plastics (e.g. ABS, PC, PVC, PMMA, Polyamide) and composites.

- low odour
- short open time

Physical properties - Liquid state

Base compound	Benzyl methacrylate
Shelf life	9 months
Density	A / B: 1,07 g/cm ³
Mixing ratio	1:1
Open time	1 - 3 min
Fixture time	3 - 5 min
Color component A	Transparent
Color component B	Transparent

Viscosity

Cone / plate, measured
at 20 °C

@ 0.5 s ⁻¹	10.000 - 20.000 mPa·s
@ 160 s ⁻¹	5.000 - 8.000 mPa·s

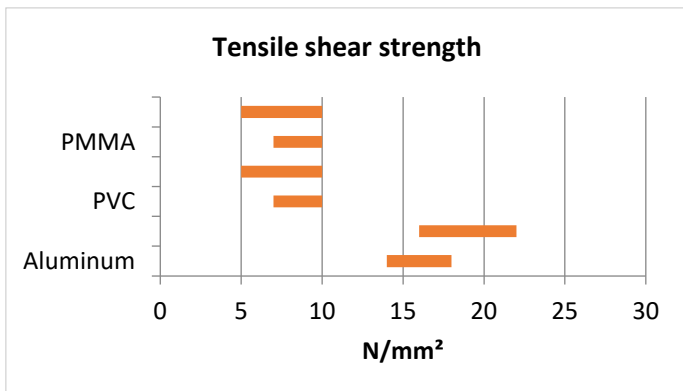
Physical properties - Polymer

Full cure in hours	24
Temperature range	-40 - 120 °C
Elongation at break	5 - 10 %
E-modulus	800 - 1200 MPa
Tensile strength	17 - 20 MPa

Adhesive performance Tensile shear strength

Substrate	N/mm ²		
Polycarbonate ▲	5	-	10
PMMA ▲	7	-	10
ABS ▲	5	-	10
PVC ▲	7	-	10
Stainless steel	16	-	22
Aluminum	14	-	18

▲ Substrate failure

**Resistance against solvents**

Solvent	Example	Resistance
Weak acids		+++
Weak bases		+++
Polar solvents		-
Strong acids and bases		-

+++ very good - limited

General Information about MMA adhesives

2-component methacrylate adhesives belong to the group of reactive adhesives. The reaction starts by mixing hardener and resin. Cyberbond offers these adhesives in double cartridges in 1:1 or 10:1 ratio with static mixing tubes. This allows an easy and quick application. Methacrylate adhesives are available in different viscosities from liquid to paste-like and with different curing times. They are characterized by excellent adhesion to metals, many plastics and composite materials. The mechanical properties range from flexible to rigid.

Measurement of Viscosity

Viscosity describes the flow-ability of a liquid. Cyberbond measures the viscosity of the products by means of the cone/plate method: the liquid is applied on a panel and a defined cone presses the liquid together and rotates. Newtonian fluids are measured at shear rate 160 s⁻¹, thixotropic products are measured at shear rate 0,5 s⁻¹ and 160 s⁻¹.

The viscosity is measured in mPa·s at 20 °C.

Clean Surface

Surfaces should be clean, dry and free of grease before bonding.

Storage

Store products in a cold and dark place at temperatures between 10 °C to 20 °C.

Safety Information for MMA adhesives

Please consult the SDS (Safety Data Sheet) before using. Keep the workplace clean and use in well ventilated areas only. Install suitable exhaust system at the workplace. Wear suitable safety glasses and gloves. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources.

The data mentioned in this TDS, particularly the recommendations and use of products are based on our recent knowledge and experience. Due to the fact of having so many different materials involved and conditions of applications which are out of our influence, we strongly recommend to do sufficient tests in order to guarantee that Cyberbond products are suitable for the intended process and applications. Except for wilful acts any liability based on such recommendations or any verbal advice is hereby expressly excluded.

For safe handling consult Material Safety Data Sheet (MSDS).

Cyberbond Europe GmbH
A H.B. Fuller Company
Werner-von-Siemens-Straße 2
31515 Wunstorf
Germany
Tel.: +49 / 50 31 / 95 66 - 0
www.cyberbond.de



H.B. Fuller

Cyberbond CB