



Product Reference Guide

Series	Features, Benefits & Applications	Adhesive	Working Time ¹ min.	Fix- ture Time 1 min.	Ratio A:B Volume Weight	Mixed Densi- ty gm/ml lb/gal	Viscosity (10 ³ cps) A-Comp. B-Comp.	Tensile Strength ² MPA psi % Elonga- tion	Shear Strength ³ MPA psi
SG100	Color Stabilized (bright white with improved color UV resistance) UV Resistant Intermediate Shear Strength High Toughness • 490 ml Cartridge or Bulk • Composites, Plastics, • Primed Metals	SG100 – 15 SG100 – 40	12-18 35-45	>30 >80	10:1 5,68:1	1,02 8.45	A: 150-220 B: 50-100	19-22 2,800-3,200 140	13-16 2,000-2,400 ³
SG230 HV	Large Structures (Gray) ⁶ Gap Fill up to 39 mm (1.5") Non Sag Intermediate Shear Strength Maximum Toughness • 490 ml Cartridge or Bulk • Composites, Plastics • Primed Metals	SG230 – 30 SG230 – 45 SG230 – 60 SG230 – 80 SG230 - 120	25-35 35-45 50-70 70-90 100-130	>45 >60 >80 >140 >260	10:1 8.4:1	0.99 8.25	A: 900- 1300 B: 80-180	20-28 3,000-4,000 150-230	12-15 1,700-2,100 ³ 13-15 1,850-2,200 ⁵
SG300	Metal Bonder (Black or off white) ⁶ Primerless Metal Bonding Low Read Through High Shear Strength High Toughness • 50 and 490 ml Cartridge or Bulk • Composites, Plastics, Metals	SG300 - 05 SG300 - 15 SG300 - 40	4-6 13-17 35-45	>15 >30 >80	10:1 8.75:1	1.02 8.51	A: 180-250 B: 80-120	14-15 2,000-2,200 100-125	18-19 2,500-2,800 ³
SG1100^p	General Purpose 1:1 (Amber) Difficult to Bond Plastics & Galvanized High Shear Strength High Toughness • 50 and 400 ml Cartridges or Bulk • Composites, Plastics, • Primed Metals	SG1100-05 SS1100-05	4-6 13-17	>20 >45	1:1 1.05:1	1.013 8.45	A: 70-100 B: 80-120	12-15 1,700-2,100 >100	12-15 1,700-2,100 ³
SG1500^p	General Purpose 1:1 (Amber) Primerless Metal Bonder Maximum Shear Strength High Toughness • 10 ml syringes • 50 and 400 ml Cartridges or Bulk • Composites, Plastics, Metals	SG1500-05 SG1500-15 SG1500-30 SG1500-60	4-6 12-16 25-35 50-70	>15 >30 >60 >140	1:1 1.08:1	0.98 8.17	A: 80-120 B: 100-140	17-22 2,500-3,100 >80	19-22 2,700-3,200 ³
SG5000	General Purpose 1:1 (Amber/ Black/White) Primerless Metal Bonder Very High Shear Strength Low Toughness • 50 and 400 ml Cartridges or Bulk • Composites, Plastics, Metals	SG5000-05 SG5000-15 SG5000-30 SG5000-60	2-4 5-7 12-14 35-45	>6-8 >10- 12 >20- 25 >55- 60	1:1 1.08:1	0.97 8.09	A: 30-100 B: 50-120	31-32 4,500-4,600 <10	20-25 2,900-3,600 ³
PPX5	Ultimate Plastic Bonder Low Energy Surface No Primer or Surface Pretreat- ment on PP, PE and other low energy surfaces • 50 and 490 ml Cartridge or Bulk • PP & PE Plastics, Composites, Plastics, Metals	PPX5	4-6	>15	10:1	0.98 8.17	A: 6.5-8,5 ¹⁰ B: 5.5-7,0	5-15 ⁹ <2100 <10	<16 <2400

Notes: 1. Working/fixture times at 75°F unless noted. Fixture time is minimum recommended time in fixture.

3. ASTM D1002 - 6061 Aluminum treated with MP100 Metal Primer (no primer needed with SS300 and SS1500 series).

Bond strength attainable on other materials is limited and controlled by the strength and stiffness of the substrate.

5. ASTM D5868 - typical single lap shear strength of FRP to FRP bond.

7. Bulk containers 20 and 200 litres

9. based on 72h cured ASTM 1002, 12.5 mm overlap on plastics

Notes: 2. All mechanical properties are based on post cure cycle, 1 hour @ 82°C.

4. Single adhesive, selection of four activators. Please refer to the product data sheet for more specific information.

6. Cured adhesive colors are for products offered in cartridges. Several other colors are possible with products sold in bulk.

p. Preliminary data - New Product Series.

8. Test method Brookfield Cone & Plate at 24°C

10. Measured by Brookfield helipath