

POWER BOND

LOS 305

LOS 305 is a two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies. Combined at a 1:1 ration, it has a working time of 4 to 6 minutes and achieves 75% of ultimate strength in 10 to 15 minutes at room temperature.

LOS 305 offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

Features

Excellent shear, peel and impact strength over a wide temperature range

Non-sagging

Will fill gaps of up to 4mm

Excellent load bearing qualities

Resistant to weathering and humidity

Room temperature cure

No surface preparation

Recommended applications

PVC & Vinyl	Steel/Carbon
ABS	Aluminium #
Acrylics (PMMA)	Stainless Steel #
Styrenic	Fibreglass
Vinyl Esters	Phenolics
PC Blends	Polysulfone
PBT Blends	PET Blends
Epoxy	E-coat & other coated metals
Gelcoats	Polyurethanes
Polyesters	

(# Primer suggested)

Application

Apply mixed adhesive directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended working time. To assure maximum bond strength, surfaces must be mated within the specified working time of the adhesive. Use sufficient material to insure 100% joint fill when parts are mated and clamped. All adhesive applications, part positioning and clamping should occur before the working time of the mix has expired. Movement of the part after the working time has expired can result in bond strengths lower than normal. Ensure that the assembly remains undisturbed until fixture has occurred.

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LOS 305****PRODUCT DATA****Physical Properties – Uncured @ 22°C**

	Part A	Part B
Viscosity, cP	40.000 – 60.000	40.000 – 60.000
Colour:	Off white	Yellow
Density, g/cc:	1.01	0.96
Mix ratio by volume and weight:	1	1

Mechanical Properties – Cured @ 22°C

Tensile Strength, Mpa (ASTM D638)	20-24
Modulus, Mpa:	931 – 1137
Strain to Failure (%):	15 – 25
Lap Shear (ASTM D 1002)	20 – 24
Mixed density:	0,98 g/ml
Working time:	4 – 6 minutes
Fixture time:	12 – 15 minutes
Full cure:	24 hours
Solvents:	None
Flashpoint:	9°C
Elongation:	15-25 %
Operation Temperature Range:	-55 to 121°C

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