

Product Description

Vibra-TITE Acrylic 225 is an activated Acrylic adhesive designed for fast fixturing on metal and ceramic materials and a no mix system. The Product is developed to be used with Activator 611.

Typical Applications

Vibra-TITE Acrylic 225 typical applications include bonding metal or ceramic close fitting rigid parts which are exposed to thermal cycling, like motor assemblies. Vibra-TITE Acrylic 225 cures between close fitting parts and the aid of an activator.

Properties of Uncured Material

Chemical Type	Acrylic
Appearance	Pale Yellow
Toxicity	Low
Viscosity @ 25°C, cP Brookfield RVT, Spindle 6 @ 20 rpm	14000-25000
Specific Gravity	1.05

Performance of Cured Material

Fixture Time w/activator	2-6 min @ 72°F
Full Cure Time	24 hrs @ 72°F
Temperature Range	-60°F to 212°F (-51°C to 100°C)

24 hr Grit blasted Steel Lap Shear
11 Nmm² (1600 psi)

72 hr Grit blasted Steel Lap Shear
>11 Nmm² (1600 psi)

Environmental and Fluid Resistance

Tests were conducted on Grit blasted Steel Lap Shears exposed to the following conditions after a 24hr room temperature cure. One lap shear was coated with Activator 611.

(Shear strength values)

Environment	Temp.	% of initial strength
Air reference	87	100
Unleaded gasoline	87	75
Motor oil (10W-30)	87	100
Auto trans. fluid	87	110
Water/glycol 50/50	150	75
Humidity, 100% RH	50	80

General Information

Storage

Product should be stored in a cool and dry location at temperatures between -10 °C to 30 °C. Optimal storage is 22±4°C. Shelf life is 18 months from date of manufacture when stored at 22±4°C.

Note

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.

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