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# Structural Adhesive Multi Cure 240

Product Data Sheet

## Product Description

Vibra-TITE Multi Cure 240 is an activated acrylic adhesive designed for fast fixturing on metal and magnet materials and a no mix system. The Product is developed to be used with Activator 600 or 638.

### Typical Applications

Vibra-TITE 240 may be used in applications that require very fast assembly. This adhesive is designed for DC motor assembly, magnet bonding and bonding of pre-coated sheet metal. Automated assembly lines with short cycle times will benefit from the rapid cure of 240. The product has the capability to produce tough, durable bonds with outstanding impact and peel resistance.

### Properties of Uncured Material

| | |
|---|---|
| Chemical Type | Acrylic |
| Appearance | clear/amber |
| Toxicity | Low |
| Viscosity @ 25ºC, cP | |
| Brookfield RVT, | |
| Spindle TA @ 2.5 rpm | 20,000-80,000 |
| Spindle TA @ 20 rpm | 6,500-17,000 |
| Specific Gravity | 1.16 |

### Performance of Cured Material

| | |
|---|---|
| Fixture Time | 30 seconds @ 72$^{o}$F |
| Full Cure Time | 24 hrs @ 72$^{o}$F |
| Temperature Range | -60$^{o}$F to 212$^{o}$F (-51$^{o}$C to 100$^{o}$C) |

24 hr Grit blasted Steel Lap Shear
12 Nmm$^{2}$ (1700 psi)

72 hr Grit blasted Steel Lap Shear
> 12 Nmm$^{2}$ (1700 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 600 or 638.

**(Shear strength values)**

| Environment | Temp. | % of initial strength |
|---|---|---|
| Air reference | 87 | 100 |
| Unleaded gasoline | 87 | 10 |
| Motor oil (10W-30) | 87 | 100 |
| Auto trans. fluid | 87 | 100 |
| Water/glycol 50/50 | 150 | 35 |
| Humidity, 100% RH | 50 | 40 |

## General Information

### Storage

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