

DELO®-MAFLEX 8193

No-Mix adhesive

Base

- methyl methacrylate system

Use

- flexible construction adhesive
- for high-strength and tension-equalizing bonding of metal, plastic, glass, wood, fabric and ceramic
- high tensile shear strength with excellent impact and peel resistance
- the cured product is normally used in a temperature range of -55 °C to +120 °C; for short times, it is also possible to apply higher temperatures

Processing

- supplied ready for use and can be processed well from the original container
- apply activator and resin separately
- first, apply the activator onto the less porous surface very sparingly
- apply the resin onto the second component
- the resin forms a skin on the surface within 5 min, which can impair the bonding
- speedy processing is necessary
- the product is distributed over the entire joining area through pressing of the component during joining
- after joining, the components should be fixed until the adhesive has reached firmness to touch
- the curing times and strengths in case of gaps > 0.4 mm must be determined in tests on original components
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use DELOTHEN cleaners for the cleaning of bonding surfaces

Curing

- at room temperature
- curing starts as soon as the activator is brought in contact with the resin
- activator DELO-QUICK 8003: firmness to touch in approx. 5 min

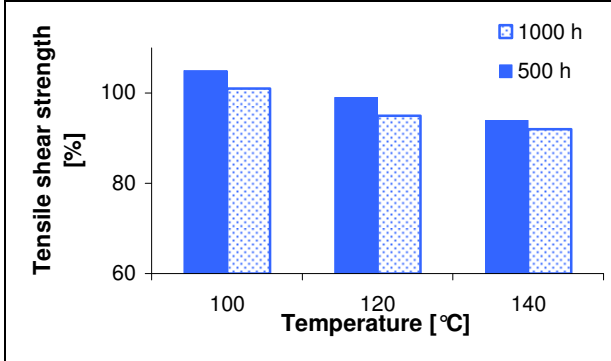
Technical data

Color of resin	yellowish
Filler	unfilled
Mixing ratio	no - mix
Density of resin [g/cm ³] at room temperature (approx. 23 °C)	1

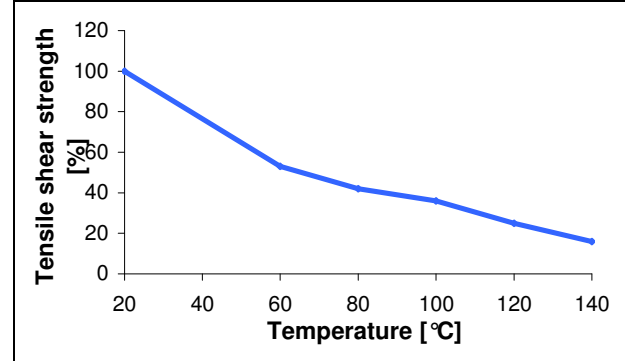
Viscosity of resin [mPas] Brookfield at 23 °C	30000
Curing time until initial strength [min] tensile shear strength 1 - 2 MPa at room temperature (approx. 23 °C) activator DELO-QUICK 8003	approx. 5
Curing time until functional strength [min] tensile shear strength > 10 MPa at room temperature (approx. 23 °C) activator DELO-QUICK 8003	45
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm after 24 h at room temperature (approx. 23 °C)	22
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm after 72 h at room temperature (approx. 23 °C)	25
Floating roller peel resistance St/St [N/mm] DELO Standard 38, sand-blasted component thickness: 1.5 mm and 0.5 mm adhesive layer thickness: 0.1 mm curing: 24 hat room temperature (approx. 23 °C)	8

Performance under temperature influence

Tensile shear strength Al/Al after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN 1465



Tensile shear strength Al/Al at temperature based on initial value at room temperature measured at determined temperature according to DIN EN 1465



Storage life 9 months
 at 0 °C to +10 °C in unopened original container

Instructions and advice

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this. It is the customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions. The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

Instructions for use

The instructions for use of DELO-MAFLEX are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

The properties in italics are part of the specification. Ranges with clear limits are defined for them and others, where applicable. In the course of the QA test, each batch is tested for these properties and the maintenance of the limits is ensured. The measuring methods used can deviate from those specified in the data sheet. Details can be found in the QA test report.