

**MEGACRYL™ S140** is a two-part methyl methacrylate adhesive designed for structural bonding of engineered thermoplastics, metal and composite assemblies. Combined at a 10:1 ratio, thixotropic non-sagging formulation. This adhesive combines high strength and durability with the ability to adhere to a wide range of substrates with a minimum of surface preparation. Used in Automotive, Marine, Electronics, Plastic Fabrication, Signs, Metal Fabrications etc.

Monomer Form (Liquid)	
Base Resin	Modified Acrylic
Colour	Cream (Part A) Yellow or Black (Part B) Yellow or Black (Mixed)
Viscosity (Adhesive Part A)	90,000-100,000 mPa·s
Viscosity (Hardener Part B)	30,000-35,000 mPa·s
Flash Point	Approx. 10°C (51°F)
Shelf Life @ 20°C	12 months unopened
Toxicity	Low to moderate (see SDS)
Mix Ratio	10:1

Cure Times Available		
	Working Time	Fixture Time
S140-05	2 mins	5 mins
S140-20	8-10 mins	15-20 mins
S140-40	20-25 mins	35-40 mins
S140-90	40-45 mins	70-90 mins

Polymer Form (Solid)	
Tensile Strength at Break ASTM D638	14 MPa
Over Lap Shear Strength ISO4587	18-20 MPa
Hardness acc. to ASTM D2240	70 Shore D
Service Temperature	-40°C / +121°C
Elongation	20 - 30%

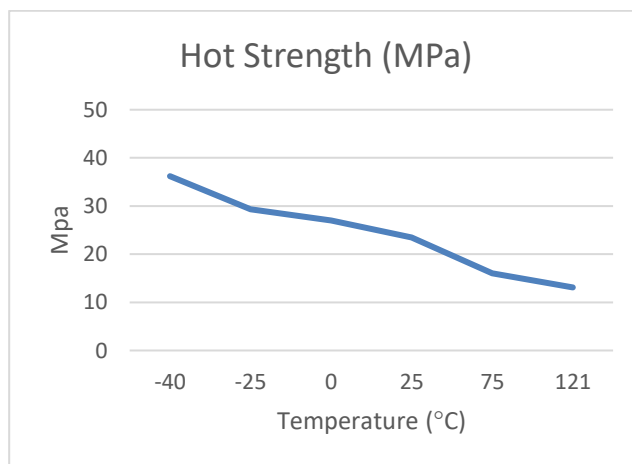
## Features and Benefits

- Minimal Surface Preparation Required.
- High Lap Shear Strength.
- High Peel Strength.
- Resistance to Wide Range of Chemicals.
- Impact Resistance.
- Medium Flexibility
- Room Temperature Cure.
- Various Cure Speeds Available

## MEGACRYL™ S140 SERIES STRUCTURAL ADHESIVE TECHNICAL DATA SHEET



## Temperature Resistance



Lap Shear Strength ASTM D 1002  
304 Steel / 304 Steel

## General Instructions

**MEGACRYL™ S140** is a 10:1 meter-mix product for ease of application. While Megacryl adhesives typically require little to no prep, the effectiveness can vary based on the material and contamination levels. For best results, surfaces should be free from grease, dirt, and other contaminants. A simple wipe with a dry rag or light

solvent is often sufficient for plastics, coated metals, and raw metals. However, be mindful of oxidation and scaling on metals, as these can impact adhesion. For composites, dust-free surfaces can be bonded directly, though light abrasion may be necessary to remove mould releases and/or enhance surface area. Make sure the bond joint has uniform coverage and that a sufficient amount of adhesive is in the bond area. It is important to have the adhesive applied, parts aligned and positioned, within the established work times for the product. To ensure maximum performance in the finished assembly parts should remain undisturbed until the fixture time is reached.

### Curing

Curing commences upon mixing of Part A and Part B. Working time is the approximate time after mixing that adhesive remains liquid and usable. Fixture time is the time after which parts may be moved and/or unclamped. 80% of final strength develops within 1 hour.

### Recommended For

#### METALS

- Aluminium
- Steel
- Stainless
- E-Coated Metal

#### THERMOSETS

- Fibreglass
- Phenolic
- Epoxy
- RIM Urethane
- Polyurethane
- Liquid Moulding Resin

#### THERMOPLASTICS

- Acrylic
- ABS
- Polycarbonate
- Nylon/PA
- Vinyl
- PVC
- Peek
- PBT Blends
- PET Blends

### Storage

Product should be stored in a cool dry place out of direct sunlight. Shelf life is dependent on the product being stored properly at temperatures between 15 to 20°C. The shelf life is twelve (12) months in original sealed containers. Shelf life can be extended by refrigeration. **Do NOT freeze.**

### Safety and Disposal

**For safe handling information on this product, consult safety Data Sheet (SDS).** Disposal should be in accordance with local and/or national regulations.

### Handling and Clean-Up

Clean up is best before the adhesive has cured. Cleaners containing NMP (N-methyl pyrrolidone) or Citrus terpene provide the best results. On cured adhesive repeat use may be required.

### Compatible Components

Static Mixing Nozzles	Part Number
490ml 10:1 Static Mixer	MIX400101B



Dispensing Guns	Part Number
490ml 10:1 Dispenser	GUN400101



### Packaging

Size	Product	Part Number
490ml Dual Cartridge	S140-05	S14049005
490ml Dual Cartridge	S140-20	S14049020
490ml Dual Cartridge	S140-40	S14049040
490ml Dual Cartridge	S140-90	S14049090

### Important

The data contained herein is offered in good faith based upon information that is believed to be accurate and reliable, but no warranty, express or implied, regarding the accuracy of such information is made. The conditions or methods of handling, storage, use and disposal of this product are beyond our control and may be beyond our knowledge. For this and other reasons, we do not assume responsibility and expressly disclaim liability for loss, damage or expense arising out of or in any way connected with the handling, storage, use or disposal of this product. Any recommendations of use are provided as a guide only and do not remove the need for prior testing. No guarantee is made that use of the product will give desired results in all situations. It is the responsibility of the user to determine the products suitability for their intended purpose. In every case, we urge and recommend the user conduct their own tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own conditions.

### Contact Us

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