MEGACRYL™ S800 LO STRUCTURAL ADHESIVE

TECHNICAL DATA SHEET

MEGACRYL™ S800 LO is a two-part methyl methacrylate (MMA) structural adhesive, offering a low odour and fast curing formulation. This toughened semi-rigid structural adhesive is engineered to create robust and impact resistant bonds with minimal surface preparation, making it for a variety of material including metals, plastics and composites. Provides the same high-performance benefits of our other MMAs while offering a significantly reduced odour - making it safer and more comfortable to work with in enclosed or sensitive environments.

Properties (Uncured)		
	Part A	Part B
Base Resin	Acrylic	Peroxide
Colour	Cream	Black
Viscosity	50,000 – 55,000	23,000 – 25,000
Mix Ratio	10	1

Properties (Mixed)	
Colour	Black
Working Time	10 minutes
Handling Time *	15 minutes
Full Cure	60 minutes
Peak Exotherm Time	12 – 15 minutes

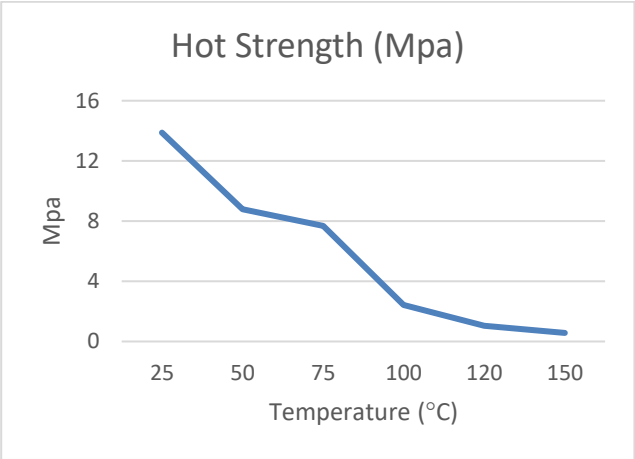
*Minimum Time to reach >0.3 MPa overlap shear strength

Polymer Form (Solid)	
Tensile Strength at Break (ASTM D638)	10 MPa
Over Lap Shear Strength (ISO4587)	14 - 16 MPa
Hardness acc. to *ASTM D2240*	60 Shore D
Elongation at break	240 %

Features and Benefits

- Minimal Surface Preparation Required
- Low-odour formulation
- Minimal hazard labelling
- Safer and more comfortable to use
- Impact Toughened
- Structural lap shear strength
- Resistance to Wide Range of Chemicals.
- Semi-rigid once cured
- Non-sag formulation

Temperature Resistance



Lap Shear Strength ISO4587
Aluminium / Aluminium

General Instructions

MEGACRYL™ S800 LO 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. Handling time is minimum time required to reach >0.3 MPa overlap shear strength. 80% of final strength develops within 1 hour. Note: Air inhibition during the curing process means low odour formulations can sometimes leave a 'tacky/sticky' surface. Minimising the area exposed to air will reduce this tacky/sticky surface, furthermore the tackiness reduces over time.

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

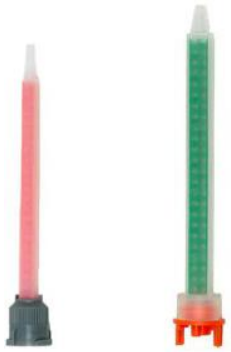
For safe handling information on this product, consult safety Data Sheet (SDS). Disposal should be in accordance with local and/or national regulations.

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
50ml 1:1 Static Mixer	MIX050101B
490ml 1:1 Static Mixer	MIX490101B



Dispensing Guns	Part Number
50ml 10:1 Dispensing Gun	GUN050101P
490ml 10:1 Dispensing Gun	GUN490101M

Packaging

Size	Product	Part Number
50ml Dual Cartridge	S800-15	S80015050
250ml Dual Cartridge	S800-15	S80015250
490ml Dual Cartridge	S800-15	S80015490

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

Engineering Adhesives & Lubricants (Aust) Pty Ltd
Tel: (07) 5531-4242
Fax: (07) 5531-4243
Email: info@eal.com.au
Website: www.eal.com.au
Postal address:
P.O. Box 863
Ashmore City
Queensland 4214

www.eal.com.au