

DELO®-MAFLEX 8191

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 product is normally used in a temperature range of -55 °C to +100 °C; depending on the application, other limits may be more reasonable

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 mixed adhesive 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 8002: firmness to touch in approx. 5 min

Technical data

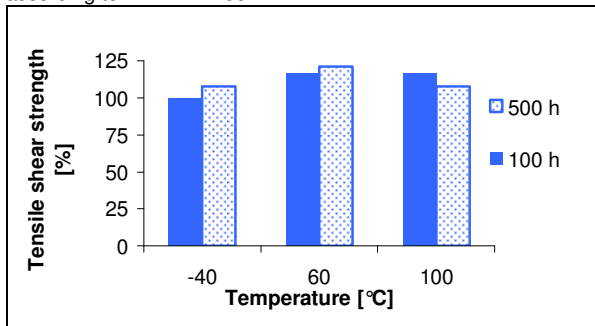
Color of resin	yellowish milky
Filler	unfilled
Mixing ratio	no - mix

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Density of resin [g/cm ³] at room temperature (approx. 23 °C)	1	
Viscosity of resin [mPas] Brookfield at 23 °C	20000	20000 cP
Curing time until firmness to touch [min] tensile shear strength 1 - 2 MPa at room temperature (approx. 23 °C) activator DELO-QUICK 8002	approx. 5	
Curing time until functional strength [h] tensile shear strength > 10 MPa at room temperature (approx. 23 °C) activator DELO-QUICK 8002	1	
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	3190 psi
Tensile shear strength Al/Al [MPa] DIN EN 1465 component thickness: 1.6 mm after 72 h at room temperature (approx. 23 °C)	24	3480 psi
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)	7	4.0005 lb./in.

Performance under temperature influence

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



Storage life
at room temperature (max. 25 °C) in unopened original container

6 months

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.

Many product properties are subject to temperature and may change permanently, especially at high temperatures.

It is the user's responsibility to test the suitability of the product for the intended purpose and temperature range of use by considering all specific requirements. Type and 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.

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

see quality assurance test report

Converting table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{g} / 28.3495 = \text{oz.}$

$\text{Mpa} \times 145 = \text{psi}$

$\text{mPas} = \text{cP}$

$\text{N} \times 0.225 = \text{lb.}$