



Key Features

- 7-10 minute handling time
- Suitable for metals & plastics
- Natural coloured
- Bonds common materials
- Thermal curing process

Stykra 1000

Methacrylate Adhesive

Model No: **GA1000**

The Stykra 1000 is a fast acting 2-part methacrylate adhesive. Suitable for a wide range of material and part assembly. The rapid 7-10 minute handling time provides a fantastic benefit for assembly lines and fabrication work. Suitable for bonding all manner of materials including: Metals including aluminium, stainless steel, mild steel, polycarbonate and acrylic sheets.

Properties of uncured material

Item	Unit	Spec	Test Method
Colour	-	Yellow / white	-
Appearance	-	ThixotropicGel	-
Viscosity	cps	400,000 to 600,000	Brookfield T Bar
Cure System	-	Exothermic	-
Open time	minutes	7	20°C 10g mass
Full Handling Strength	minutes	12	@ 20°C
Minimum Service	°C	-10	-

Performance of cured material

Item	Unit	Spec	Test Method
Aluminium	N/mm ²	20.4	ASTM D1002 lapshear
Stainless Steel	N/mm ²	38.4	ASTM D1002 lapshear
Mild Steel	N/mm ²	38.4	ASTM D1002 lapshear
GRP	N/mm ²	substrate fail	ASTM D1002 lapshear
ABS	N/mm ²	substrate fail	ASTM D1002 lapshear
Acrylic	N/mm ²	substrate fail	ASTM D1002 lapshear
Tensile Test	N/mm ²	Up to 30	ASTM D638 tensile
Gap Fill	mm	4mm	-
Operating Temperature	°C	-55 to +120	-

Unless stated otherwise all values given are average. All of the adhesives in our range should be thoroughly tested on the substrates in the particular application they are intended for. Stykra will not be responsible for the product failure unless full testing has been completed. The customer has to decide on the tapes suitability for the intended purpose.