



# FIT30 15

## TWO COMPONENT METHACRYLATE

### KEY FEATURES

- Fast curing
- Non-sag, application on vertical surfaces
- Excellent environmental resistance
- Minimal surface preparation



### DESCRIPTION

FIT structural adhesives have been designed for bonding a wide range of dissimilar substrates including metals, plastics and composites materials for all industrial applications. The new properties of the FIT range allow structural bonding while keeping flexibility, strength and fatigue. Non sagging properties allow vertical application.

FIT range, patented methacrylate structural adhesive, shows unmatched performance in term of resistance, flexibility and non-sagging properties. FIT range has been developed to resist the most aggressive environments and extreme conditions. It shows unprecedented results facing weathering and ageing.

### RANGE OF APPLICATION

The FIT30 15 is recommended for the following substrates:

Metals	Composites	Plastics
Steel	Polyester	PVC
Stainless Steel	Vinylester	PS
Aluminum	Epoxy	ABS
Galvanized steel	Acrylic (Elium)	PC
		PMMA

### PRODUCT CHARACTERISTICS

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Characteristics	FIT30 15
System	Two components 10:1 Volume Ratio
Polymerization	Room Temperature

### ADHESIVE PROPERTIES

PHYSICAL PROPERTIES		
PROPERTIES	RESIN	HARDENER Bostik SAF DX
Appearance	Off-white	White
Density (+/- 0,02)	1.07	1.16
Viscosity @ 23°C	350 000 - 600 000 <sup>1</sup>	80 000 - 250 000 <sup>2</sup>
Type	Non-sag	

CURING PROPERTIES	
PROPERTIES	FIT30 15
Open time [min]	6 - 8
Fixture time @23°C [min]	12 - 15
Full Cure [hours]	24

MECHANICAL PROPERTIES	
PROPERTIES	FIT30 15
Lap Shear strength on GFRP <sup>7</sup>	DF <sup>6</sup>
Tensile Strength at break [MPa] <sup>4</sup>	15 - 17
Tensile Modulus [MPa] <sup>4</sup>	1000 - 1200
Hardness [Shore D]	70 - 80
% Elongation at break <sup>4</sup>	25 - 30

## WEATHERING AND AGEING RESISTANCE

Lap shear strength (MPa) with ISO 4587 after D3 cycle.  
D3 cycle NF EN ISO 9142 7 ageing cycles (7 days).

LAP SHEAR STRENGTH (MPa) <sup>3</sup> thickness 250 µm		
Substrates	Before ageing cycles	After ageing cycles D3
Aluminum	19.0 CF <sup>5</sup>	16.0 CF
Stainless steel	18.0 SCF <sup>8</sup>	18.0 SCF
Steel	20.0 CF	20.0 CF
GFRP <sup>7</sup>	9.0 DF <sup>6</sup>	8.0 DF

## NOTES

1. Brookfield viscosity (mPa.s) mobile T-F @ 10rpm
2. Brookfield viscosity (mPa.s) mobile RV7 @ 10rpm
3. ISO 4587
4. ISO 527-1A
5. CF: Cohesive Failure
6. DF : Delamination Failure
7. Glass Reinforced Fiber Polymer
8. SCF: Special Cohesive failure

## SURFACE PREPARATION

Use AEC T700 to remove grease, contamination or poorly adhering oxides from metal surfaces. Most plastics require a simple cleaning before bonding. Some may require sanding for better performances.

## PRECAUTIONS

Adhesive contains methacrylate monomers and is flammable. Materials must be stored in cool place away from sources of heat. During the polymerization, the chemical reaction causes a typical smell, please use the product in a well-ventilated area. When the adhesive two components are mixed, an exothermic reaction can occur and generates heat. The amount of heat is dependent on the mass and thickness of the mixed product.

Read material Safety Data Sheet before handling or using this product.

## APPLICATION

Optimum qualities are obtained at room temperature, ideally between 18°C and 28°C without post-curing. Follow the instructions on the product operating guide or contact your Bostik representative for any information concerning product use, dispensing equipment or substrates application.

## STORAGE

FIT30 15 shelf life is 9 months in unopened original packaging. Product may be stored in a closed container in a dry place at temperature between 15°C and 25°C. Exposure to higher or lower temperature will result in a reduction of the stated shelf life.

## PACKAGING

FIT30 15 adhesive is available in 50mL 490mL and 825mL side by side cartridges, 20L pails or 200L drums. FIT30 15 50mL cartridges require the use of M5.4/16 mixers. FIT30 15 490mL cartridges require the use of MFX10-18 mixers. FIT30 15 825mL cartridges require the use of MGK1420 mixers.

For packaging information please call your Bostik sales or technical representative.

## LIMITED WARRANTY

To the maximum extent allowed by law, Bostik disclaims all other express or implied warranties, including without limitation warranties of merchantability and fitness for a particular purpose. Unless otherwise stated in the limited warranty, the sole remedy for breach of warranty is replacement of the product or refund of the buyer's purchase price. Bostik disclaims any liability for direct, incidental, consequential, or special damages to the maximum extent allowed by law. Disclaimers of implied warranties may not be applicable to certain classes of buyers and some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days of discovery of a problem, and must be submitted with written proof of purchase.

## BOSTIK HOTLINE

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