

AQUABOND SR-3000 TECHNICAL DATA SHEET

Description: SR-3000 is a two part methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies¹. Combined at a 1:1 ratio, it has a working time of 4 to 6 minutes and achieves 75% of ultimate strength in 12 – 15 minutes at room temperature. SR-3000 offers a combination of high strength and stiffness as well the ability to bond a wide range of materials.

Recommended for bonding:

■ABS	■FRP	■Polyesters	■Styrenics
■Acrylics	■Gelcoats	■ Steel, Carbon ⁷	■ Urethanes
■Aluminum	■PVC	■Steel, Stainless	■ Vinyl Esters

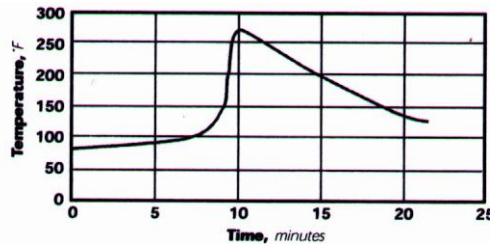
Adhesive properties:

	Adhesive	Activator
Viscosity <i>cP</i>	40,000- 60,000	40,000- 60,000
Color	Off-white	Yellow
Density <i>lbs/gal. (g/cc)</i>	8.40 (1.01)	8.00 (0.96)
Mix Ratio		
<i>by volume</i>	1	1
<i>by weight</i>	1	1

Cure characteristics:

Room Temperature

Open Time ² <i>minutes</i>	4 – 6
Fixture Time ³ <i>minutes</i>	12 – 15
Flash Point <i>°F (TCC)</i>	51°
Service Temperature <i>°F</i>	-67° – 250°
Gap Filling <i>inches</i>	Up to .125
Mixed Density <i>lbs/gal (g/cc)</i>	8.20 (0.98)



Typical Exotherm Curve⁵
(10 grams at 75°F)

Physical properties:

Cured/Room Temperature

Tensile <i>ASTM D-638)</i>		Lap Shear <i>(ASTM D-1002)</i>	
Strength <i>psi</i>	3,000 – 3,500	Cohesive Strength <i>psi</i>	3,000 – 35,000
Modulus <i>psi</i>	135,000 – 165,000		
Strain to Failure %	15 - 25		

Chemical Resistance:

Excellent resistance to:	Susceptible to:
Acids and Bases (3-10 pH)	Polar Solvents
Hydrocarbons	Strong Acids and Bases
Salt Solutions	