

Penloc GTH-T is a two component toughened acrylic adhesive to bond various metals such as steel, stainless steel, and aluminium as well ceramics, FRP, etc .

**Advantages:**

- Excellent het resistance
- Excellent water resistance and hot water resistance
- High viscosity
- Rapid bonding
- High bond strength
- Application requires no mixing

storage conditions: dark, cold and dry place at room temperature  
shelf life: in unopened original container at least for 6 month

## Technical Data

Color	transparent
Resin	acrylat

## UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [mPa*]	8000 to 10000
Flash point [°C]	> 90
Pot-Life [min.]	approx. 2

## Curing

Handling Stenght	5-10 min.
Full Strength	4-6 hours

## Lap Shear Strength (\* material failure)

Stahl	28	N/mm <sup>2</sup>
Edelstahl	27	N/mm <sup>2</sup>
Aluminium	23	N/mm <sup>2</sup>

## CURED PROPERTIES

Temperature Resistance	-30 to 180 °C
Hardness Shore D	65 to 75

Our data sheets have been compiled to the best of our knowledge. The information included in our data sheets is exclusive information for the tended user and describes characteristics, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. In general, for guarantee claims, please refer to our standard terms and conditions.

**Adhesives  
and more...**

Lap Shear Strength (Stahl/Stahl) [MPa]	[PE-Norm P013]	approx. 28
Lap Shear Strength (Edelstahl) [MPa]	[PE-Norm P013]	approx. 27
Lap Shear Strength (Aluminium) [MPa]	[PE-Norm P013]	approx. 23

The surface must be clean, dry and free from fat and releasing agent. We advise a solvent which is able to absorb water, i.e. Panacol cleaner IP.

The adhesive can be dispensed out of a double syringe like a 1-component product.

The syringe must stay 2 minutes before using vertical (needle at the top), therefore the enclosed air can arise to the top.

For white syringes - draw of the slide - remove cap with a screw driver - keep cap for relock.

For black syringes - hit cap hard on a solid ground, the two pins will bore through the cap and open the syringe.

**"bead on bead"**: with smooth and constant pressure on a stamp the two components were pressed out. They have to applied one component and the other at the top.

**Microstatic Mixer**: both components will be mixed in the tube. During 3 minutes the substrates must be joined together.

Handling strength is reached after 5 - 10 minutes.

80% of bonding strength is reached after 1 hour.

Final strength is reached after 4-6 hours.

Adhesives  
and more...