

A-K Series Structural Adhesives

L&L Bond A-K Series is a range of high performance, room temperature curing structural adhesives formulated to meet the demanding requirements of the global commercial vehicles industry.

Key features include

- *Primerless adhesion to metals, composites and plastics including low surface energy plastics such as polypropylene and polyethylene*
- *Enhanced worker safety, with low / no odor*
- *Non-flammable systems*
- *Low shrinkage for reduced read through and rework*
- *Clear structural adhesive system available*
- *Wide range of cure speeds to suit most applications*
- *High tensile strength and elongation*
- *Available in a variety of thixotropy levels to suit specific application requirements*
- *Full cure at room temperature via two component technology*
- *Available in cartridges, pails, and drums*

Typical applications

- *High / sleeper cab roof structures*
- *Aerodynamic side trims*
- *Side wall assembly*
- *Door and luggage door assemblies*
- *Grill assemblies*
- *Bumper/fender modules*
- *Interior trim - dashboards, headliners, door panels etc.*
- *Mounting bracket bonding*



PRODUCT	PRODUCT DESCRIPTION	MIXED COLOR	CHEMISTRY	MIX RATIO	OPEN TIME (min)	FIXTURE TIME (min)	LAP SHEAR STRENGTH*	TENSILE STRENGTH	TENSILE MODULUS	ELONGATION AT BREAK (%)
A-K015	Clear fast curing MMA.	Clear	MMA	1:1	1-2	3-4	15.0 MPa 2,175 psi	14.5 MPa 3,350 psi	800 MPa 116,000 psi	1-5%
A-K060	General purpose non-sag MMA for bonding for metals, plastics and composites.	Tan	MMA	1:1	10-20	30-45	18.0 MPa 2,610 psi	21.5 MPa 3,100 psi	1550 MPa 224,250 psi	30-45%
A-K070	Fast-curing non-sag adhesive designed for hard-to-bond metals. Bonds well to plastics and composites.	Tan	MMA	1:1	7-9	15-18	18.8 MPa 2,725 psi	23.1 MPa 3,350 psi	1550 MPa 224,250 psi	3-5%
A-K075	Non-sag Adhesive designed for hard-to-bond metals. Bonds well to plastics and composites.	Tan	MMA	1:1	9-10	18-22	19.0 MPa 2,755 psi	23.9 MPa 3,450 psi	1565 MPa 227,000 psi	3-5%
A-K083	Fast-curing, non-sag adhesive designed for hard-to-bond plastics and composites. Bonds well to metals.	Tan Black	MMA	1:1	5-7	9-12	20.0 MPa 2,900 psi	24.3 MPa 3,525 psi	1670 MPa 242,125 psi	5-10%
A-K085	Adhesive designed for hard-to-bond plastics and composites. Bonds well to metals.	Tan	MMA	1:1	9-12	12-15	17.7 MPa 2,565 psi	22.6 MPa 3,275 psi	1450 MPa 210,250 psi	10-20%
A-K090	Fast-curing, non-sag general purpose MMA for bonding for metals, plastics and composites.	Tan	MMA	1:1	4-7	18-22	16.6 MPa 2,410 psi	24.5 MPa 3,550 psi	1450 MPa 210,250 psi	30-45%
A-K348	Fast-curing non-sag impact resistant MMA with high elongation and excellent adhesion to metals, composites and plastics.	Grey	MMA	10:1	3-6	8-10	18.0 MPa 2,610 psi	15.5 MPa 2,250 psi	550 MPa 79,750 psi	70%
A-K350	Impact resistant, non-sag MMA with high elongation and excellent adhesion to metals, composites and plastics.	Grey	MMA	10:1	16-22	25-35	15.1 MPa 2,190 psi	17.5 MPa 2,500 psi	725 MPa 105,125 psi	70%
A-K510	Low-viscosity, low odor, non-flammable advanced acrylate that is spreadable and can be used in laminating applications.	Purple	HEMA/PEMA	1:1	7-10	10-12	13.6 MPa 1,970 psi	7.6 MPa 1,100 psi	122 MPa 17,700 psi	>20%
A-K520	Low odor, non-sag non-flammable advanced acrylate for general purpose bonding of metals, plastics and composites.	Amber	THFMA	1:1	8-10	10-12	18.1 MPa 2,625 psi	5.4 MPa 785 psi	305 MPa 44,250 psi	8-15%
A-K540	Specifically formulated for bonding low surface energy plastics.	Amber	Acrylate Mix	1:1	5-10	45-60	7.2 MPa† 1,045 psi†	7.0 MPa 1,015 psi	800 MPa 116,000 psi	1-3%

* 1.5 mm cold-rolled steel, bondline 0.3 mm thick, 25.4 mm x 12.7 mm overlap

† 3 mm polypropylene

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