



TDS 6002

General Description

Chemsure 6002 is a second generation acrylic adhesive, designed to combine high shear strength, with high temperature resistance, with the additional qualities of a rubber toughened adhesive. The adhesive works when mixed at a 1:1 ration through a mix nozzle, as well as with a bead on bead application system. This adhesive has incredible adhesion on a wide variety of substrates, whilst maintaining very high peel and impact strengths throughout.

Typical Applications

Sign Fabrication and Installation Automotive Assembly GRP Fastening Systems Magnet Bonding

Chemical Resistance

Excellent Resistant to:

- Hydrocarbons
- Acids and Bases (3-10 ph)
- Salt Solutions

Packaging

- 25ml Syringe
- 50ml Cartridge
- 250ml Universal
- 400ml Cartridge
- Bulk Dispensing Systems

Technical Features

Part A Colour	Green
Part B Colour	Pink
Mixed Colour	Purple
Working Time	2 Minutes
Fixture Time	6 Minutes
Viscosity	3500cps
Flash Point	12°C
Specific Gravity	1.02

Application Instruction

Please consult Chemsure 6002 application manual.

Technical Notes

Chemsure 6002 can be also applied at an offset ratio to increase the working time. The upper limit is 3.2 Part A to 1 Part B, which will allow 7 minutes open time, without any change in ultimate cured strength.

Chemsure 6002 is suitable for paint bake cycles up to 180°C for 20 minutes.

Typical Properties Cured Material

50% Ultimate Strength	1 Hour
Full Cure	6 Hours
Temperature Range	-35°C to 180°C
Gap Fill	3mm

ASTM D1002 Lapshears (Tensile Result)

Steel/steel	20-35 N/mm ²
Glass/Metal	16-22 N/mm ²
Polycarbonate *	13 N/mm ²
On ABS/ABS *	8 N/mm ²

* Substrate failure

Suitable Substrates

Ferrites	Ceramics	Steel	Gelcoats
Acrylics	Urethanes	Aluminium	Polyesters
GRP	Vinyl	St. Steel	Wood
FRP			

Terminology

(1) Working/Open Time: The time interval between application of adhesive to substrate, and the possible assembly/repositioning of the two mating parts @ 20°C

2) Fixture Time: The length of time after the substrate assembly that will allow a joint to support a 1kg dead weight. (Tested on a 12mm x 25mm overlapped joint @ 20°C)

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