STRUCTURAL ADHESIVES

PRODUCT GUIDE



ACRALOCK® ENGINEERED BONDING SOLUTIONS

ACRAMAXX® ENGINEERED BONDING SOLUTIONS

ACRALOCK by Engineered Bonding Solutions, LLC, are advanced two-component methacrylate structural adhesives designed to bond chemically to most surfaces providing a permanently locked or integrated assembly of steel, aluminum, engineered plastics, high-performance composites, and other materials.















MARINE-WIND-LARGE COMPOSITE ASSEMBLY

SA10 and SA10-UV White | SA1-500

- Bonding stringers
- Liners
- Hull to deck joints
- Small parts
- Skid plates
- Aluminum
- Rub rails
- Spars
- Flanged webs
- Nacelle internal components
- Metal brackets
- Polyesters
- Epoxies
- PU
- Polycarbonates
- Acrylics
- Atyrenics
- ABS
- PVC
- CPVC
- Cold rolled steel
- Galvanized
- E-coated metals

BUS-HEAVY TRUCK-RAIL

FA10 | SF10 | SA10 | SA | HS1 | SA1-500 | SA1-700 | M4 | M10 | M1 | GB10

- Composite panels
- Flanged webs
- Roof
- Storage doors
- Metal extrusions
- Fenders
- Brackets
- Flat head studs
- Front and back caps
- Cab assemblies
- Polyesters
- Epoxies
- PU
- PVC
- ABS
- PC
- Acrylics
- Nylon
- Telene
- SMC
- Pultrusions
- Aluminum
- Stainless
- Cold rolled steel
- Galvanized
- E-coated metals

TRAILER BODY-SPECIALTY VEHICLE-WORK TRUCK-RV

FA10 | SF10 | SA10 | SA1 | HS1 | SA1-500 | SA1-700 | M4 | M10 | M1 | GB10

- Composite panels
- Fenders
- Hoods
- Flanged webs
- Roof
- Frames
- Doors
- Extrusions
- Aluminum
- Cold rolled steel
- Stainless
- Zinc chromated
- Galvanized
- E-coated
- ABS
- Polycarbonate
- Nylon
- Telene
- SMC
- Pultrusions

SIGNAGE-ARCHITECTURAL-INDUSTRIAL-CONSTRUCTION

C10 | SF10 | FA10 | SA1 | SA1-500 | SA1-700 | M4 | M10 | M1 | GB10

- Composite panels
- Flanged webs
- Tanks
- Extrusions
- Plastics
- Frames
- Granite
- Aluminum
- Stainless
- Cold rolled steel
- Galvanized
- Zinc chromated
- Solid surfaces
- Engineered stone
- E-coated
- Acrylics
- ABS
- Polycarbonate
- PVC
- CPVC

ACRALOCK®
ENGINEERED BONDING SOLUTIONS

10 TO 1 MIX RATIO PRODUCTS

Cartridge Products	Available Working Time Versions	Color	Mix Ratio (vol)	Flexibility Elongation Range (%)	Single Lap Shear Strength psi (Mpa)	Primary Use Applications SA10 products are all RINA Certified SA10, SF10 are EN 45545-2 Certified
C10	12, 12HV	Clear	10 to 1	Highly Rigid 1-3	2,100 (14)	Water-clear, rigid, fast-curing, low- and HV- (high viscosity) versions for acrylic and plastic bonding. Ideal for signage, granite, engineered stone, and solid surfaces.
SA10 (White)	7, 15, 40	WHT	10 to 1	Flexible 50-80	3,100 (21)	Flexible, bright white, with UV-resistant for use with primed metals , plastics, and composites. Ideal for marine and transportation.
GB10	5, 30	BLK GRY	10 to 1	Flexible 50-80	1,500 (10)	Best for cosmetic sensitive parts, very fast curing, low readthrough, flexible, low modulus to bond metals, plastics and composites, side wall bonding, Transportation
FA10	5, 20, 30	BLK/GRY OWL	10 to 1	Flexible 50-80	1,200 (9)	Flexible, fast-curing nylon bonding w/ sanding, low exotherm and readthrough on metals, plastics, and composites. Ideal for transportation.
SF10	5, 10, 20, 30	BLK/GRY OWT	10 to 1	Flexible 50-80	1600 (11)	Medium-strength, flexible adhesive with high-fatigue performance for metal, plastics, and composites. Ideal for transportation.
SA10	5, 10, 20	BLK/GRY OWT	10 to 1	Flexible 50-80	2,800 (19)	High-strength, flexibile for metals, plastics, and compos ites. Ideal for transportation.
SA10	35, 45, 60	BLK/GRY OWT	10 to 1	Flexible 50-80	2,600 (18)	High-strength, flexibile, thick gap filling for bonding for metals, plastics, and composites. Ideal for wind, marine, and transportation
SA10	75, 100	BLK/GRY OWT	10 to 1	Flexible 50-80	2,400 (16.5)	High-strength, flexibile, thick gap filling, very long open times for bonding for metals, plastics, and composites. Ideal for wind, marine, and transportation

10 TO 1 MIX RATIO PRODUCTS

Cartridge Products	Available Working Time Versions	Color	Mix Ratio (vol)	Flexibility Elongation Range (%)	Single Lap Shear Strength psi (Mpa)	Primary Use Applications SA1 products are EN 45545-2 Certified
SA1-300	3, 5, 15	NAT	1 to 1	Semi-Rigid 11-20	3,000 (21)	High-strength, Rigid, and general purpose for metals, plastics, and composites. Ideal for composites assembly.
SA1-500	10, 30, 60, 90	GRY	1 to 1	Semi-Flexible 21-49	3,300 (22)	High-strength, semi-flexible, and thick gap filling for metals, plastics, and composites. Ideal for marine, transportation, and wind.
SA1-05	5, 15	GRY/NAT	1 to 1	Flexible 50-80	3,600 (24.8)	Very high strength, flexible, excellent adhesion to pultrusions and SMC for metals, plastics, and composites. Ideal for transportation.
HS1	5, 15	BLK	1 to 1	Semi-Flexible 21-49	3,700 (25)	Semi-flexible adhesive modified SA1 for better adhesion to telene (PDCPD) for metals, plastics, and composites. Ideal for transportation.
SA1-700	5, 15, 30	GRY	1 to 1	Flexible 50-80	4,500 (31)	Highest strength, flexible adhesive for metals and hot/cold performances with better adhesion to pultrusions and SMC for metals, plastics, and composites. Ideal for transportation
HT1-30	30	GRY	1 to 1	Semi-Rigid 11-20	4,000 (27)	High Strength, high modulus, very low viscosty, semi-rigid adhesive for unique bonding applications.

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Cartridge Products	Available Working Time Versions	Color	Mix Ratio (vol)	Flexibility Elongation Range (%)	Single Lap Shear Strength psi (Mpa)	Primary Use Applications
E10	3	NAT	10 to 1	Semi-Flexible 21-49	2,000 (14)	An ultra-fast, non-halogenated curing system designed to bond metal, composites, and plastics. Ideal for electronics assembly.
M10	5,18,30	GRY NAT	10 to 1	Semi-Flexible 21-49	3,500 (24)	Semi-flexible, maximum metal bonding adhesive for most bare metals with good retention of properties after post bake oven exposure < 30 minutes @ 380°F. Bond to metals, plastics and composites used in Transportation and Signage.
M1	6,18	GRY	1 to 1	Semi-Flexible 21-49	3,300 (22.8)	Metal bonding adhesive that replaces welding, riveting, and brazing on most bare metal substrates, especially galvanized metals including electro zinc galvanized (EZG) steel. Also works on plastics and composites used in the transportation.
M4	6,18	GRY NAT	4 to 1	Semi-Flexible 21-49	3,400 (23.4)	Preferred Metal bonding adhesive that replaces welding, riveting, and brazing on most bare metal surfaces including electro zinc galvanized (EZG) steel, when subjected to high temperature post bake oven applications < 30minutes @ 400°F. Bonds to metals, plastics and composites used in Transportation and Signage.








ACRALOCK ADHESIVES ARE THE VEHICLE FOR CHANGING TRANSPORTATION:

Faster, Stronger, and Lighter Vehicles

All of our exclusive formulations are rapid-curing and substantially increase the throughput of assemblies of similar or dissimilar materials. **ACRALOCK** and **ACRAMAXX** adhesives form high-performance, durable, electrostatic bonds to bare metals which reduce under-film corrosion and provide the best combination of properties to ensure long-term durable strength and shock-load resistance. Please consider the various **ACRALOCK** adhesives that have been used for years in the transportation market, such as the SA10-, FA10-, and SA1-series, or the latest **ACRAMAXX** products for your vehicular assembly needs.

ACRAMAXX M10, M1 and M4 are our latest innovations designed to be used without primer on clean, bare metals. M10 is high strength 10 to 1 mix ratio product for bonding AL, SS, CRS to replace rivets, welding and can withstand short duration oven bake cycle ≤ 30 minutes @ 380°F. M1 was developed as a high strength 1 to 1 mix ratio product for bonding most bare metals AL, SS, CRS and most galvanized metals without primer for general applications that are not subjected to high temperature bake cycles. M4 is the latest innovation, developed as a 4 to 1 mix ratio adhesive, for bonding most bare metals AL, SS, CRS and most galvanized metals without primer for general applications and is able to withstand short duration oven bake cycle ≤ 30 minutes @ 400°F.

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+1-321-747-0160 | 1-800-411-GLUE
acralock.com
info@acralock.com
1455 Buffalo Road, Titusville, FL 32796
European inquiries: office@acralock.eu