ORDERING INFORMATION
STOCK NO.: 20500
PACKAGE SIZE: 50ml Cartridge

DESCRIPTION
Devweld 530 is a two-part 1:1 methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies. Devweld 530 offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

FEATURES
• Room temperature cure
• Non-sagging
• Will fill gaps of up to 4mm
• Excellent load bearing qualities
• Resistant to weathering and humidity
• Excellent shear, peel and impact strength
• No surface preparation
• 100% reactive
Mixing
Devcon Devweld 530 is available in pre-measured 50ml cartridge form. The cartridge should be used with the appropriate manual Applicator Gun and Static Mixer Nozzle. The Static Mixer Nozzle enables the material to be thoroughly mixed when dispensed, and thus can be applied directly to the surfaces to be bonded.

Please note: Once the product goes beyond its working time the nozzle has to be thrown away and a new nozzle used for further dispensing.

Application
Apply mixed adhesive directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended working time. To assure maximum bond strength, surfaces must be mated within the specified working time of the adhesive. Use sufficient material to insure 100% joint fill when parts are mated and clamped. All adhesive applications, part positioning and clamping should occur before the working time of the mix has expired. Movement of the part after the working time has expired can result in bond strengths lower than normal. Ensure that the assembly remains undisturbed until fixture has occurred.

Effect of Temperature
Application of adhesive at temperatures between 18°C and 26°C will ensure proper cure. Temperatures below 18°C will slow cure speed; above 26°C will increase cure speed. The viscosity’s of Parts A and B of this adhesive are affected by temperature.
STORAGE AND SHELF LIFE
All Devcon Adhesives should be stored in a cool, dry place when not used for a long period of time. A shelf life of 1 year from date of manufacture can be expected when stored at room temperature 22ºC in their original containers. Shelf life may be extended by refrigeration (7ºC - 12ºC). This product should never be frozen.

HANDLING AND STORAGE
WARNING! This product is flammable (Parts A and B). Contents include Methacrylate Ester. Keep containers closed after use. Avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of the reach of children. Keep away from heat, sparks and open flames.

NOTE: Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time (film thickness cures in excess of 4mm should be avoided wherever possible). The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air and volatile components as evidenced by gas-sing. To prevent this, use only enough material as needed for use within the working time for the product, and confine gap thickness to no more than 4mm. Do not dispense waste material into plastic cups as heat may melt container. Do not hold metal containers of Devweld adhesive during curing or else heat generated may cause burning.

CLEAN UP
Clean up is best accomplished before the adhesive cures. For cured adhesive carefully scrape it away and wipe with a solvent. Spills should be cleaned up with an absorbent material and disposed of as flammable material.

PRECAUTION
For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

WARRANTY
Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.

DISCLAIMER
All information on this data sheet is based on laboratory testing and is not intended for design purposes. Devcon makes no representations or warranties of any kind concerning this data.

For product information visit www.devconeurope.com alternatively for technical assistance please call +353 61 771 500.