

erde™ G-FORCE is a high-performance structural adhesive on acryl-basis.

One of the remarkable features of the **G-FORCE** is its excellently flexibility, its high power on transfer and its good continualness on temperature.

Very well adhesion offers **G-FORCE** on steel, aluminium, copper, chromium, brass, nickel, zinc, polyester, PVC; ABS, epoxidharz, glass, wood, concrete, stone a.o.

TYPICAL PROPERTIES

Colour: Pink,Green

Viscosity 4,000

Specific gravity 1.01

Temperature Range -55°C to 125°C

Handling strength 5 minutes

Working strength 30-60 minutes

Full strength 24 hours

TEST RESULTS

The test results, shown on table 1 on page 2, were achieved after the following surface preparation:

STEEL: Polished with emery paper, washed with acetone and dried in desiccators for 24 hours.

OTHER METALS: Washed with Trichloroethylene, washed with acetone, then dried in desiccator for 24 Hours

PLASTICS: Washed with methanol, dried in desiccator for 24 hours.

TABLE ONE
MATERIAL TENSILE SHEAR

	kg/cm²
Steel/Steel	280
Zinc Chromate/Zinc Chromate	182
Nickel/Nickel	195
Chrome/Chrome	164
Brass/Brass	230
Stainless Steel/Stainless Steel	204
Copper/Copper	244
Aluminium/Aluminium	224
Zinc/Zinc	214
Epoxy FRP/Epoxy FRP	84*
Phenol FRP/Phenol FRP	65*
PVC/PVC	35*
Polyester/Polyester	31
Styrol/Styrol	24
ABS/ABS	47
PA-6 (Nylon 6)	20
Glass	50

TABLE TWO

Aluminium / Aluminium >5.00 >500	
(Mill finish)	
Aluminium / Aluminium >5.00 >500	
(Chromated finish)	
Stainless Steel / Aluminium >5.00 >500	
(Mill finish)	
Stainless Steel / Stainless Steel >5.00 >500	
Aluminium / Acrylic* 3.18 318	
(Chromated)	
Aluminium / Polycarbonate* 3.00 300	
(Chromated)	
Acrylic / Acrylic* 2.12 212	
Acrylic* / Polycarbonate 2.27 227	
Polycarbonate / Polycarbonate* 3.07 307	

TABLE TWO Continued

Komacel / Komacel* 0.65 65.6

Zintec / Zintec 5.00 >500

N.B. Tensometer had testing facility up to 5.00KN

*Denotes substrate failure of particular material.

ADDITIONAL DATA

erde™ **G-FORCE** should not be used on stressed acrylic ie flame polished edges or laser cut edges as the stress caused by the adhesive curing/shrinking process may cause tiny stress fractures in the acrylic. It is advisable to carry out bonding tests and leave for a period of 48 hours to determine its suitability for your specific application.

Surface Preparation

All surfaces should be abraded with medium grit emery paper, cleaned with Isopropyl alcohol and

wiped dry with a clean cloth. DO NOT use petroleum based products such as Methylated Spirits or

White Spirits to clean surfaces as these will degrade the adhesive over time and lead to bond failure. This degree of preparation is designed to represent typical working practices as opposed to

'laboratory conditions' where solvent cleaning and chemical etching of surfaces might be employed.

All metal to metal samples produced tensile shear strengths of >500 kg/inch², the limit of the tensometer used being 5Kn, and the samples remaining intact.

N.B.

Bonded area was one square inch in each case.

Chemical Resistance

Steel to steel dipped for 7 days.

Blank not dipped 283kg/cm² 0% loss.

Petrol 246kg/cm² 13 Water

225kg/cm² 20

Caustic Soda 10% 223kg/cm² 21

Ethly Acetate 91kg/cm² 68

Cylene 195kg/cm² 31 t