

Penloc GTH-T is a two component toughened acrylic adhesive for bonding various substrates, such as steel, stainless steel, aluminium, ferrites as well as ceramics, various plastics and FR4 and many more. The single components are brown and green, after mixing and in thin layers the material appears nearly transparent.

Advantages:

- Excellent heat resistance
- Excellent water resistance and hot water resistance
- High viscosity
- Rapid bonding
- High bond strength

Storage conditions: dark and dry place at 5°C to 23°C

Shelf life: in unopened original container at least for 6 months

Technical Data

Color	transparent
Resin	acrylate

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UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [mPa·s]	8000 to 10000
Flash point [°C]	> 90
Pot-Life [min.]	approx. 2

Curing (room temperature)

Handling Strength	5-10 min.
Full Strength	4-6 hours

Lap Shear Strength (* material failure)

Steel	28	N/mm ²
Stainless Steel	27	N/mm ²
Aluminium	23	N/mm ²

CURED PROPERTIES

Temperature Resistance	-30 to 180 °C
Hardness [Shore D]	65 to 75

**Adhesives
and more...**

TECHNICAL DATASHEET

Penloc® GTH-T

Lap Shear Strength (Steel/Steel) [MPa]	[PE-Norm P013]	approx. 28
Lap Shear Strength (Stainless Steel) [MPa]	[PE-Norm P013]	approx. 27
Lap Shear Strength (Aluminium) [MPa]	[PE-Norm P013]	approx. 23
Elongation at Break [%]	[PE-Norm P060]	approx. 5

The surfaces must be clean, dry, and free from grease and release agent. We recommend the use of a solvent with good water-absorption properties, e.g. Cleaner IP. Because of its anaerobic properties, Penloc® should not be used in inert atmospheres. Prevent curing of larger amounts of adhesive on small surfaces, as this can result in significant heat generation.

Before opening, place the cartridge upright, with the tip facing upwards, for at least two minutes to allow any air in the cartridge to rise to the top and to obtain a homogenous application.

Application option:

"bead on bead": with smooth and constant pressure on a stamp the two components are pressed out. They have to be applied on top of each other.

Microstatic Mixer: both components will be mixed in the tube. Within 3 minutes the substrates must be joined together.

Handling strength is reached after 5 - 10 minutes.

80% of bonding strength is reached after 1 hour.

Final strength is reached after 4-6 hours.

Adhesives
and more...