



ENGINEERING STANDARDS

Material Specification

LIMITED USE
HN2425

Adhesive - Acrylic, Two Part

Do Not Use on New Programs; No Replacement

1. SCOPE

The material described by this specification is a two-part acrylic adhesive used for bonding unprepared metals or plastics. This adhesive is quick curing, has good impact and peel strength.

REFERENCES

HN1000

ASTM D1475

ASTM-D1002

GMW3059

2. REQUIREMENTS

Property	Test Method	Requirement
Colour	Visual	Off-white paste
Specific Gravity	ASTM-D1475	1.5 max
Mix ratio (by volume)	Pre-packaged cartridges	10 : 1
Time to Handling Strength @ 23°C	-	2 hours
Complete Cure @23°C	-	24 hours
Lap Shear Strength to Aluminium@23°C	ASTM –D1002	12 MPa min

4. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses A and C.

5. HAZARDOUS MATERIALS

Refer HN 1000, Clause H.

6. RESTRICTED AND REPORTABLE SUBSTANCES

- (i) All substances and parts must meet the requirements of GMW3059.
- (ii) All chemical components present in materials supplied to this specification must comply with Australian NICNAS (National Industrial Chemicals Notification and Assessment Scheme) obligations.

7. APPROVED SUPPLIERS AND MATERIALS

Material known to meet the full requirements of this specification:

APPROVED SUPPLIER	APPROVED MATERIAL
Lord Australia	403/19
3M	Scotch-Weld DP-8005

8 Release and Revisions

This standard was originated in November 2003. It was first published in November 2003.

Issue	Publication Date	Description (Organization)
1	NOV 2003	Initial publication.
2	MAY 2009	-Revised section "6.RESTRICTED AND REPORTABLE SUBSTANCES" to directly refer to GMW3059 and NICNAS requirements -Section "7. APPROVED SUPPLIERS AND MATERIALS" -Approved material added
3	FEB 2016	Limited for Current Use. (Materials)
4	MAR 2016	Corrected Release and Revision Issue number published in error in previous version as Issue 16 to Issue 3. (Materials)