

# Technical Data Sheet

## 5030 METHACRYLATE ADHESIVE

### Description

5030 is very versatile and can bond a wide variety of substrates without the need for surface primers or conditioners.

### Applications

- Metal fasteners to moulded composite parts
- Large diameter 2-part GRP mouldings
- Automotive carbon fibre body panels
- GRP in the marine industry
- Dissimilar metals for trailer fabrication

### Properties

- Yellow/white MMA
- 15 minutes open time @ 20°C
- Gap fill up to 5mm
- Temp range -50°C to 120°C
- Mix ratio 1:1

### Description

5030 MMA Adhesive is a two-component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications. 5030 has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the 5030 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use.

**Issue date: 07/08/2019 Ellsworth Adhesives Ltd**

Registered Office: 2 Langlands Avenue, Kelvin Business

Park, East Kilbride, Glasgow, G75 0YG, United Kingdom Registered No: 122624

Tel: +44 (0) 1355 231122 Fax: +44 (0) 1355 235266 Website: [www.ellsworthadhesives.co.uk/tooling](http://www.ellsworthadhesives.co.uk/tooling)

Warranty: The information given in this product data sheet are believed to be fully accurate. However, Ellsworth Adhesives Ltd shall not be liable for its content and make no warranty with respect thereto. For additional information we request you to contact Ellsworth Adhesives Ltd - visit our web-site: [www.ellsworthadhesives.co.uk](http://www.ellsworthadhesives.co.uk)

## Physical Data

Resin	Methyl Methacrylate
Colour Part A:	White
Colour Part B:	Amber/Black
Appearance	Thixotropic Gel
Viscosity Brookfield T Bar	120,000 to 150,000cps
Cure System	Exothermic
Open Time	15 minutes @ 20°C
Handling Strength	30 minutes @20°C

## Performance of Cured Material

ASTM D1002 Lapshear	Up to 30 Nmm <sup>2</sup>
ASTM D638 Tensile Strength	Up to 30 Nmm <sup>2</sup>
Gap Fill	5mm
Temperature Range	-55°C to 120°C

## Processing

1. Always consult SDS before using 5030 for the first time.
2. Carry out surface preparation where required.
3. Remove cap and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

## Storage and Handling

5030 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 12-month shelf life from manufacture.

**Issue date: 07/08/2019 Ellsworth Adhesives Ltd**

Registered Office: 2 Langlands Avenue, Kelvin Business

Park, East Kilbride, Glasgow, G75 0YG, United Kingdom Registered No: 122624

Tel: +44 (0) 1355 231122 Fax: +44 (0) 1355 235266 Website: [www.ellsworthadhesives.co.uk/tooling](http://www.ellsworthadhesives.co.uk/tooling)

Warranty: The information given in this product data sheet are believed to be fully accurate. However, Ellsworth Adhesives Ltd shall not be liable for its content and make no warranty with respect thereto. For additional information we request you to contact Ellsworth Adhesives Ltd - visit our web-site: [www.ellsworthadhesives.co.uk](http://www.ellsworthadhesives.co.uk)

## Disposal Consideration

5030 is available in 50ml and 400ml Nylon cartridges for use with a dispensing gun.

The technical specification and/or our technical advice, whether verbal, in writing or by trials is given in good faith and based on our test results obtained, but without warranty. It does not release the user from the obligation to test products supplied by us or any other third party as to the suitability for the intended application.

*A product Safety Data Sheet should be obtained from Ellsworth Adhesives Ltd prior to use.  
ATTENTION: Before handling, read product information, Product Safety Data Sheets and  
container labels for safe use, and any physical and/or health hazard information.*

**Issue date: 07/08/2019   Ellsworth Adhesives Ltd**  
Registered Office: 2 Langlands Avenue, Kelvin Business  
Park, East Kilbride, Glasgow, G75 0YG, United Kingdom   Registered No: 122624  
Tel: +44 (0) 1355 231122   Fax: +44 (0) 1355 235266   Website: [www.ellsworthadhesives.co.uk/tooling](http://www.ellsworthadhesives.co.uk/tooling)

Warranty: The information given in this product data sheet are believed to be fully accurate. However, Ellsworth Adhesives Ltd shall not be liable for its content and make no warranty with respect thereto. For additional information we request you to contact Ellsworth Adhesives Ltd - visit our web-site: [www.ellsworthadhesives.co.uk](http://www.ellsworthadhesives.co.uk)