



# Solid Surface Bonder 13-E

## Technical Data Sheet

### Product Overview

**Solid Surface Bonder 13-E** is a premium grade adhesive for bonding Solid Surface sheet goods and molded products.

**Solid Surface Bonder 13-E** is designed to produce tough, fast curing, invisible seams in Acrylic, Polyester and Modified Polyester solid surface materials. It will also provide a rigid thin line bond to many engineering polymers (Styrenics, ABS, PVC, FRP etc).

**Solid Surface Bonder 13-E** will provide improved performance properties over OEM adhesives in most applications, it is fully warranted and shelf stable for up to one year.  
The 10/1 mix ratio allows for packaging in many industry standard cartridges.

**Solid Surface Bonder 13-E** is available in a wide variety of colors to match all major brands of solid surface material (cross reference charts available on request)  
Custom colors are available as well as custom formulations, adjusted cure rates for automated systems, custom packaging, private labeling and bulk containers.

**Solid Surface Bonder 13-E** takes advantage of new technology to produce a hybrid polymer with the bond characteristics of Epoxies, plus the fast cure and UV stable clear appearance of Acrylics.  
Standard grade working time is 10/15 minutes and handling strength in 20/35 minutes temperature dependent.

Physical Properties:	Adhesive	Activator
Color	Clear or Tinted	Transparent
Specific Gravity	1.09	1.15
Mix ratio by volume	10/1	
Viscosity (cP,)	25-40,000	20/25,000
Working time (minutes @ 75 f.)	10/15	
Handling Strength (minutes @ 75 f.)	20/30	

Bond Strength examples on:	Acrylic e.g. (Corian™)	ISO/NPG POLYESTER	ORTHO POLYESTER
Flexural Strength (ASTM D- 790)	6000	5200	7400
Tensile Strength (ASTM D- 638)	3800	3250	4600
T-Peel (ASTM D-1876)	N/A	N/A	N/A
Lap Shear (ASTM D- 638)	N/A	N/A	N/A

### Mechanical Properties Cured

Impact Resistance (ISSFA 5.6)	PASS
Stain resistance (ISSFA 5.3)	PASS
Water resistance (ISSFA 5.8)	PASS
Heat resistance (ISSFA 5.9)	PASS
Hardness- Barcol (ASTM D-2583)	35/45

**Storage and handling:**

Methacrylate Adhesives and Activators are flammable and can be dangerous if used improperly. Avoid skin and eye contact. In case of eye contact flush with water for 15 minutes and get medical attention. Keep away from sources of ignition. Before use or handling, consult the appropriate Material Safety Data Sheet. (MSDS) information is supplied at time of initial purchase and may be requested from the manufacturer or downloaded from the web sight at- [www.integra-adhesives.com](http://www.integra-adhesives.com)

Store the adhesive in a cool area away from direct sunlight. High temperatures will reduce the shelf life of the adhesive and activator. Refrigeration is an acceptable means to increase storage life, however freezing should be prevented. Shelf life tests are based on constant temperature storage between 60 and 75 f.

**Dispensing:**

Integra adhesives are supplied in kit form at the appropriate mix ratio. Always maintain this ratio when mixing. Excess activator will cause higher than normal exotherm temperatures. Avoid mixing large quantities or creating thick cross sections (over ½ inch) as high temperatures may cause damage, skin burns and create the release of volatile vapors.

**Working time:**

The working time for the adhesive is indicated in the technical data sheet. The time is provided as an estimate of the time between mixing and set up of the adhesive. The working time is effected by the mixing ratio, air temperature, adhesive temperature, or the substrate temperature as well as the shelf life condition of the adhesive. For best results, use the adhesive at temperatures between 60 and 85 f. High temperatures increase the cure rate while lower temperatures slow the cure. Use at temperatures below 55 f. may cause incomplete cure.

**Disclaimer:**

The Information provided, is based on laboratory testing under controlled conditions. It is the responsibility of the end user to test the adhesive on the intended substrates under the conditions which they will be used, and to determine the suitability of the adhesive for the intended purpose. Integra Adhesives makes no representations or warranties of any kind with respect to the data on this form or the suitability for any specific application.