MAKOBOND ADHESIVE PASTE 160

PRODUCT DESCRIPTION

Makobond AP 160 demonstrates outstanding shear and peel strength while boasting impressive impact resistance. It adheres effectively to various surfaces including ceramics, metals, glass, wood, and select plastics. This two-component epoxy adhesive featuring a 2:1 mixing ratio, 60-minute work time, and reaching handling strength within around four hours.

PRODUCT HIGHLIGHTS

• High shear and peel strength • Easy mixing • High Performance • Impact Resistant

PRODUCT CHARACTERISTICS

	AP 160A	AP 160B
Viscosity @ 25°C	20-50K cps	8-14K cps.
Specific Gravity	1.11	1.03
Color	Off White	Amber

HANDLING PROPERTIES

Adhesive Paste 160	
Mix Ratio By Weight, Resin, Hardener	100:50
Mix Ratio By Volume, Resin, Hardener	2:1
Mixed Viscosity @ 25°C	Thin Paste
Pot Life @ 25°C	60-75 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	77-80D	D2240
Lap Shear (psi) Aluminum to Aluminum	4,600 psi	D1002

HANDLING AND CURING

Measure out proper weights of AP 160 and mix until uniform with no streaks are present throughout. Scape container for any unmixed material. Apply AP 160 to prepared surface and let set at 25°C (77°F) for at least 4 hours. Once the material has set, a quick post cure of a couple hours at 65.6°C (150°F) will provide full properties.

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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
AP-160A	2 lbs	8 lbs	40 lbs	450 lbs
AP-160B	1 lbs	4 lbs	20 lbs	225 lbs
AP-160 Kit	3 lbs	12 lbs	60 lbs	675 lbs

STORAGE AND **SAFETY**

Makobond AP 160 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.