

Series	Features, Benefits & Applications	Adhesive	Working Time ¹ min.	Fixture Time ¹ min.	Ratio A:B Volume Weight	Mixed Density gm/ml lb/gal	Viscosity (10 ³ cps) A Comp. B Comp.	Tensile Strength ² psi (mPa) % Elongation	Shear Strength ³ psi (mPa)
SS100	Color Stabilized (White) UV Stabilized Intermediate Shear Strength High Toughness • 490 ml Cartridge or Bulk Containers ⁷ • Composites, Plastics, Primed Metals	SS115	12-18	>30	10:1	1.02	A: 150-220	2,800-3,200 (19 - 22) >140	2,000-2,400 (13 - 16)
		SS140	35-45	>80	5.68:1	8.45	B: 50-100		
SS200	General Purpose (Off White)⁶ Maximum Toughness High Shear Strength • 490 ml Cartridge or Bulk Containers ⁷ • Composites, Plastics, Primed Metals	SS208	8-12	>25	10:1	0.99	A: 170-220	2,000-2,500 (14 - 17) >200	2,400-2,800 (16 - 19)
		SS214	17-22	>35	7.69:1	8.22	B: 70-180		
		SS218	35-45	>80					
SS230 HV	Large Structures (Gray)⁶ Gap Fill up to 1.5" (39 mm), Non Sag Intermediate Shear Strength Maximum Toughness • Bulk Containers ⁷ • Composites, Plastics, Primed Metals	SS230 HV	25-130	45-260 ⁴	10:1 8.4:1	0.99 8.25	A: 900-1400 B: 120-180	3,000-4,000 (20 - 28) 150-230	1,700-2,100 ³ (12 - 15) 1,850-2,200 ⁵ (13 - 15)
SS300	Metal Bonder (Black or Off White)⁶ Primerless Metal Bonding Low Read Through High Shear Strength High Toughness • 50 and 490 ml Cartridge or Bulk Containers ⁷ • Composites, Plastics, Metals	SS305	4-6	>15	10:1	1.02	A: 190-250	2,000-2,200 (14 - 15) 100-125	2,500-2,800 (17 - 19)
		SS315	13-17	>30	8.75:1	8.51	B: 50-150		
		SS340	35-45	>80					
SS600	General Purpose (Black or Off White)⁶ Ease of Manual Dispensing High Shear Strength High Toughness • 50 and 490 ml Cartridge or Bulk Containers ⁷ • Composites, Plastics, Primed Metals	SS605 SS620	4-6 15-20	>15 >35	10:1 8.44:1	0.99 8.24	A: 150-250 B: 80-120	2,600-3,000 (18 - 21) >140	2,700-3,200 (19 - 22)
SS747	Large Structures (Gray)⁶ Gap Fill up to 1.5" (39 mm), Non Sag Intermediate Shear Strength Maximum Toughness • Bulk Containers ⁷ • Composites, Plastics, Primed Metals	SS747	35-130	85-260 ⁴	10:1 8.4:1	0.99 8.25	A: 900-1400 B: 120-180	3,000-4,000 (20 - 28) 150-230	1,700-2,100 ³ (12 - 15) 1,850-2,200 ⁵ (13 - 15)

Notes:

- Working/fixture times at 75°F (24°C) unless noted. Fixture time is minimum recommended time in fixture.
- All mechanical properties are based on post cure cycle, 1 hour @ 180°F (82°C).
- ASTM D1002 - 6061 Aluminum treated with MP100 Metal Primer (no primer needed with SS300 series). Bond strength attainable on other materials is limited and controlled by the strength and stiffness of the substrate.
- Single adhesive, selection of four activators. Please refer to the product data sheet for more specific information.
- ASTM D5868 - typical single lap shear strength of FRP to FRP bond.
- Cured adhesive colors are for products offered in cartridges. Several other colors are possible with products sold in bulk.
- Bulk Containers - 5 and 50 gallons (19 and 189 liters).