

Cartridge Products	Description	Color	Mix Ratio (vol)	Viscosity (cps)	Working Time (min)	Fixture Time (min)	Tensile Strength psi (Mpa)	Tensile Elongation (%) Postcured	Single Lap Shear Strength ^b psi (Mpa)
SA10-07WHT SA10-15WHT SA10-40WHT	Tough, white UV stabilized	WHT	10:1	A: 200,000-400,000 B: 100,000-200,000	07-12 15-20 40-50	14-24 30-40 80-100	2,100-2,600 (14.5-18)	125-150	2,700-3,200 (18-22) Primed
SF10-05 SF10-30	Flexible Primeless ^a	BLK	10:1	A: 200,000-300,000 B: 100,000-200,000	04-07 25-35	08-14 50-70	1200 - 1800 (12.4)	140-180	1400-2000 (13.8)
FA10-05 FA10-30	Flexible Primeless ^a	BLK	10:1	A: 200,000-300,000 B: 100,000-200,000	04-07 25-35	08-14 50-70	800-1,500 (6-10)	150-250	800-1,500 (6-11)
SA10-05 SA10-10	Universal Primeless	BLK/GRY /OWT	10:1	A: 200,000-400,000 B: 100,000-200,000	04-07 08-12	08-14 16-24	2,300-2,800 (15-19)	80-120	2,500-3,000 (17-20)
SA10-20 SA10-25	Universal Primeless	BLK/GRY /OWT	10:1	A: 200,000-400,000 B: 100,000-200,000	15-20 20-25	30-40 40-50	2,300-2,800 (15-19)	80-120	2,500-3,000 (17-20)
SA10-35 SA10-45 SA10-60	Universal Primeless Thick Gap	GRY/BLK	10:1	A: 800,000-1,200,000 B: 100,000-200,000	25-35 35-50 50-70	50-70 70-100 100-140	2,300-2,800 (15-19)	80-120	2,300-2,800 (15-19)
SA10-75 SA10-100 SA10-120	Universal Primeless Thick Gap	GRY	10:1	A: 800,000-1,200,000 B: 100,000-200,000	70-90 90-120 120-160	140-180 180-240 240-320	2,300-2,800 (15-19)	80-120	2,300-2,800 (15-19)
SA1-510 SA1-530 SA1-560 SA1-590	Universal Primeless Thick Gap	GRY	1:1	A: 200,000-400,000 B: 200,000-400,000	8-12 25-35 50-70 80-100	16-24 50-70 100-140 160-200	2,500-3,000 (17-20)	80-120	3,000-3,500 (20-24)
SA1-05 SA1-15 (HS1-05) SA1-15 (HS1-15)	High Strength Primeless used with HS1	NAT/ BLK	1:1	A: 200,000-400,000 B: 100,000-200,000	05-08 15-20	10-16 30-40	2,500-3,000 (17-20)	75-100	3,200-3,700 (22-25)
SA1-705 SA1-715 SA1-730	High Strength Primeless	GRY	1:1	A: 300,000-500,000 B: 50,000-100,000	05-08 15-20 35-45	10-16 30 40 70-90	2,500-3,000 (17-20)	30-60	4,000-4,500 (28-31)
HT1-9030 HT1-960 HT1-990	High Strength Primeless Thick Gap	GRY	1:1	A: 200,000-400,000 B: 30,000-60,000	25-35 50-70 80-100	50-70 100-140 160-200	4,500-5,000 (31-34.5)	10-20	4,000-4,500 (28-31)
SA1-303 SA1-305 SA1-315	General Purpose Primeless	NAT	1:1	A: 300,000-400,000 B: 100,000-200,000	02-04 04-06 15-20	04-08 08-12 30-40	2,500-3,000 (17-20)	50-75	3,000-3,500 (22-25)

E10-3 E10-6	Fast fixturing, Universal Primerless	OWT	10:1	A:125,000-225,000 B:100,000-200,000	2.5-3.5 5.5-6.5	3.25-4.75 7.25-8.75	2,000 (14)	20	2,500-2,900 (20)
M1-6 M1-18 M1-35	Superior bonding	GRY	1:1	A:100,000-200,000 B:200,000-400,000	5-8 16-22 30-40	20-30 50-70 90-130	3,500-3,900 (27)	20-30	2,500-3,200 (22)
M10-6 M10-18	Universal Primerless	NAT	10:1	A:300,000-500,000 B:80,000-120,000	6 18	10-14 30-40	2,200 (15)	10-20	3,000-3,500 (24.1)

^aPrimeless- meaning on most metal surfaces- no primer is typically needed, must read TDS notes! ^bShear strength properties are based on ASTM D1002 using unprepared Aluminum 6061 after 1 hour postcure at 82°C, unless noted primed with Acralock AP-1 metal cleaning/primer solution. All reported working times and colors are based on 75° F using combinations of adhesive and activators available for specific products. Please read and understand all product TDS and Safety Data Sheets, before using any Acralock adhesive.