



## MD CLEARBOND 1:1

07.10.2024

MD CLEARBOND is a transparent, low-odor acrylic adhesive with medium viscosity. The mixing ratio is 1: 1. With MD CLEARBOND transparent bonding of glass and plastics can be made. MD CLEARBOND is shock and vibration resistant

### Uncured Properties

Resin (A)	Methacrylate Blend
Hardener (B)	Amine accelerated resin
Viscosity (A)	approx. 90.000 mPa.s
Viscosity (B)	approx. 10.000 mPa.s
Density (A)	1,01 g/ml
Density (B)	0,99 g/ml
Mix ratio	1:1
Shore hardness D	55
Shelf life (Optimal storage temperature 15-25 ° C)	9 months
Pot life	45 - 90 sec.
Fixture time	3 minutes
Final curing	24 hours
Temperature resistance	-55°C to +120°C, short-term up to +140°C
Cured properties	
color	transparent
Gap filling	3 mm
Tensile elongation	8 %
Lap shear strength	21 MPa

The values are average values. They serve merely for your information but assume no warranty.

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The information in this product has been compiled to the best of our knowledge and is intended purely for information purposes. No claims can be inferred therefrom. Before use, thorough experiments should be carried out. Our brochure represents a basis. Responsibility for possible measures to protect property and persons lies with the user. Safety data sheets on the required standard are available for all products on request.



Properties		
<ul style="list-style-type: none"> <li>○ Clearbond is a low odour, clear Acrylic adhesive with medium viscosity</li> <li>○ Clearbond combines the speed of the faster methacrylates with toughness, to enable bonding of similar and dissimilar materials, which include most plastics.</li> <li>○ Shock- and vibration-proof</li> <li>○ Clearbond is not UV resistant</li> </ul>		
Typical bonding properties - Test method ASTM D1002		
Steel	Cohesive Failure	<21N/mm <sup>2</sup>
Aluminium	Substrate Failure	<18N/mm <sup>2</sup>
PMMA	Coh Failure	<5N/mm <sup>2</sup>
PVC	Coh Failure	<5N/mm <sup>2</sup>
ABS	Sub/Coh Failure	<5N/mm <sup>2</sup>
Epoxy	Adhesive Failure	12N/mm <sup>2</sup>
Phenolics	Sub/Coh Failure	<7N/mm <sup>2</sup>
PDCPD	Adhesive Failure	<11N/mm <sup>2</sup>
Polycarbonat	Adhesive Failure	<4N/mm <sup>2</sup>
Processing information (25 g)		Processing information (50 g)
<p>The bonding surfaces must be clean, oil and grease free (e.g. with Marston Cleaner). Excellent results are obtained by a mechanical roughening of the adhesion surfaces. Twist off cap, attach and tighten the mixing nozzle. Push the material out with the dispensing gun and discard the first 2 g, as they are not yet mixed at 1:1. Setting time can be curtailed at high temperatures. Join work pieces together and fix. Store opened cartridge in a cool, dry place.</p>		<p>As with the 25 g cartridge, in addition: Insert the cartridge into the dispensing gun and then close. Twist off cap, attach and tighten the mixing nozzle. Push the material out with the dispensing gun and discard the first 2 g, as they are not yet mixed at 1:1.</p>
RoHS conform / WEEE- conform		
Packaging	Item number	
14 dual springes à 25 g	MMB.C.S25	
12 double cartridges à 50 g	MMB.S.C50	

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