



METHACRYLATE ADHESIVE

K-META 2134



K-META 2134 adhesive is composed of patented methacrylate adhesives and offers unmatched performance in terms of strength and flexibility. These adhesives have been designed for bonding a wide range of substrates, including metals and plastics, as well as composite materials for industrial applications. The exceptional properties of the K-META range allow structures to be bonded while maintaining flexibility and fatigue resistance. The products in the K-META range have been developed to withstand the most aggressive environments and extreme temperatures. They offer unprecedented results in terms of weathering and aging.

- **FAST CURING TIME**
- **VISCOUS GEL**
- **MINIMAL SURFACE PREPARATION**
- **AGING RESISTANCE**

SETTING TIME	6-8 min
COLOR	Crystal clear
SHORE HARDNESS	60 D
VISCOSITY	15,000 – 22,000

PROPERTIES	RESIN	HARDENER
Viscosity ¹ Brookfield @ 23 ° C mPas	15 000 – 22 000	15 000 – 22 000
Color	Light blue slightly opaque	Light pink slightly opaque
Density (20 ° C)	1.0	1.0
Type		Gel
Mixing ratio (weight and volume)	1	1
Handling time		45-70 s
Setting time		3 min
Optimal properties after (h)		24 hours
Lap shear strength (MPa) – Aluminium ²		13
Stress at break ³		12 – 13 N/mm ²
Tensile module (MPa)		700 - 800
Shore D hardness		60 D
% elongation at break ³		5 %
Temperature range		18°C – 28°C

Field of application : K-META 2134 is recommended for the following substrates :

Metals : steel, stainless steel, aluminum, powder-coated steel.

Others : glass, GFRP7, epoxy, acrylic.

Plastics : PMMA, PVC, PC, PS, ABS

THE BONDING KEY !



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Shear strength (MPa) thickness 250 µm

Substrates	Before aging cycles
Aluminium	13.0 EC ⁴
Inox	16.0 EC
GFRP ⁷	5.6 EE ⁶
PMMA	7.0 DS ⁵
Polycarbonate	4.0 DS
ABS	7.5 DS
PVC	9.0 DS

NOTE

1. Brookfield viscosity (mPa.s) Mobile T-D at 10 rpm
2. With ISO 4587
3. With ISO 527-1A
4. CF: Cohesion failure
5. SF: Substrate failure
6. EF: Elimination failure
7. Glass fiber reinforced polymer



PRECAUTIONS FOR HANDLING THE PRODUCT

The adhesive contains methacrylate monomers and is flammable. Materials should be stored in a cool place, away from heat sources. During polymerization, the chemical reaction causes a characteristic odor ; please use the product in a well-ventilated area.

When the two components of the adhesive are mixed, an exothermic reaction may occur and generate heat. The amount of heat depends on the mass and thickness of the mixed product. Read the safety data sheet before handling or using this product.

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SURFACE PREPARATION

Remove grease, non-adherent contaminations or poorly adherent oxides from metal surfaces. Most plastics require simple cleaning before gluing. Some may require sanding for best performance.



APPLICATION OF THE PRODUCT

The optimum qualities are obtained at room temperature, between 18°C and 28°C without post-polymerization. Follow the instructions in the product instructions for use or contact your KEOL representative for information regarding product use, dispensing equipment, or substrate application.



STORAGE AND PACKAGING

Shelf life in original unopened bottle : 6 months
Store continuously between + 15°C and + 25°C. Protect against freezing.

Conditioning :
50ml and 400ml cartridge

50 ml cartridges require the use of 16-element mixers.



The information, and particularly the recommendations regarding the application and the KEOL products, are given to you in good faith and are based on current knowledge and experience of the products having been properly stored, handled and applied under normal conditions.

KEOL cannot take responsibility for the results obtained by others since we have no control over their method.

It is up to the user to determine the suitability of the products for the specific application for any method. production costs mentioned in this document. Also, it is up to the user to adopt the necessary precautions as recommended for the protection of the establishment and the people against any kind of risks which could arise during the handling and the use of the products.

KEOL cannot assume all the guarantees mentioned or implied, including guarantees of market value or compliance for a specific reason, arising from sales or use of KEOL products. KEOL cannot assume liability for incidental consequences or damages of any kind, including lost profits.

Users should always refer to the most recent edition of the technical data sheet for the product concerned. Copies of this document will be provided upon request.

THE BONDING KEY !