

# SabreBond™ XMP275

SabreBond XMP275 is a toughened hybridpolymer/epoxy-based two components structural adhesive. It has a very short open time. Resin and hardener react fast to form an elastomer with high bonding strength. The cured product has excellent water- and chemical-resistance. It does not contain isocyanates or solvents.

## Application

SabreBond XMP275 is suitable for general industrial applications requiring high strength. It has excellent bonding performance on most substrates, such as steel, aluminum, copper, nickel-coated steel, PVC, ABS, PC, PA and PET etc.



## Technical Characteristics (at 20-25°C, unless otherwise stated)

Components	SabreBond XMP 275 (Resin)	SabreBond XMP 275 (Hardener)
Color	Black	Translucent
Appearance	Paste	Paste
Density (g/cm <sup>3</sup> )	1,03 ± 0,05	1,05 ± 0,05
Mixing Ratio by volume	2	1

Components	SabreBond XMP 275 (Resin)	SabreBond XMP 275 (Hardener)
<b>After mixing of the components</b>		
Pot-life (min)	8 – 10	
Initial Strength (min)	30	
Full Cure, ambient	2d @25°C	
Full Cure, elevated	1h @80°C	
<b>After full cure</b>		
Hardness (Shore-A)	75	
Tensile Strength (MPa)	6,5; after ageing (7d, 150°C): 4,8	
Elongation at break (%)	280; after ageing (7d, 150°C): 100	
Lap-Shear Strength (N/mm <sup>2</sup> )		
<b>CURE: 7d @25°C</b>		
Al / Al	9,2	
Stainless Steel / Stainless Steel	8,7	
PA / PA	4,9	
ABS / ABS	5,4	
PC / PC	6,3	
PET / PET	5,5	
PMMA / PMMA	5,2	
<b>AFTER AGEING: 7d @85°C and 85% r.h.</b>		
Al / Al	9,4	
Stainless Steel / Stainless Steel	8,5	
PA / PA	4,6	
ABS / ABS	5,3	
PC / PC	5,5	
PET / PET	5,7	
PMMA / PMMA	5,1	

## Preparation and Use

### Comment

The components must be stored in tightly sealed containers. Ensure adequate ventilation during use. Avoid direct skin contact with the individual components or the non-cured mixture. Wear protective gloves and glasses. The surface to be bonded should be dry, free of grease and dust and should have no other contamination. Coatings (e.g. paints) on metal surfaces or any release agent on plastic surfaces should be removed. Also, the formation of condensation on the surfaces must be avoided. To do this, heat the substrates to room temperature. A low temperature increases the viscosity of the product.

### Use

Mix the resin and the hardener before application. Ensure the correct mixing ratio and uniform mixing to obtain ideal mechanical and chemical properties. Make sure to prepare the right amount of adhesive, so that it can be used within the pot-life. The product can be processed manually or by machine.

### Cleaning

Non-cured adhesive or the individual components can be removed with solvent. Pay attention to the compatibility of the substrate with the cleaner. Cured adhesive can only be removed mechanically.

### Storage

The product must be stored at temperatures between 10 and 30°C. Direct sunlight, heat, frost or moisture must be avoided. The material can be stored in the original sealed containers for 12 months.

### Packaging

50ml or 400ml cartridge or on request.

### Safety

In any case, consult the valid safety data sheet before using the product.

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#### IMPORTANT NOTICE

Sabre Adhesives Limited makes no warranties, express or implied, including, but not limited to, any implied warranty of merchantability or fitness for a particular purpose. User is responsible for determining whether the product is fit for a particular purpose and suitable for user's method of application. Due to the fact that specific substrates, such as: plastics, polycarbonates, etc, may differ from manufacturer to manufacturer we recommend preliminary compatibility tests. Please remember that many factors can affect the use and performance in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a product. Given the variety of factors that can affect the use of our products some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

#### LIMITATION OF REMEDIES AND LIABILITY

If the product is proved to be defective, the sole remedy shall be to refund the purchase price or to repair or replace the defective product. Sabre shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

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