

# FIT30 15

## Two Component Methacrylate



### Product Description

FIT 30-15 is a versatile structural adhesive designed for bonding metals, plastics, and composites in various industrial applications. Its patented methacrylate formula provides exceptional flexibility, strength, and resistance to sagging, making it ideal for vertical applications. FIT 30-15 excels in aggressive environments, offering unmatched performance against weathering and aging.

### Characteristics

- Fast Curing
- Non-sag, application on vertical surfaces
- Excellent environmental resistance
- Minimal surface preparation

### Product Characteristics

System	Two components 10:1 Volume Ratio
Polymerization	Room Temperature

### Adhesive Properties

Physical Properties	Resin
Appearance	Off-white
Density ( +/-0.02)	1.07
Viscosity @23°C [min]	350 000 - 600 000 <sup>1</sup>
Type	Non-sag

### Curing Properties

Open time [min]	6 - 8
Fixture time @23°C [min]	12 - 15
Full Cure [hours]	24

### Mechanical Properties

Lap Shear strength on GFRP <sup>7</sup>	DF <sup>6</sup>
Tensile Strength at break [MPa] <sup>4</sup>	15 - 17
Tensile Modulus [MPa] <sup>4</sup>	1000 - 1200
Hardness [Shore D]	70 - 80
% Elongation at break <sup>4</sup>	25 - 30

### Weathering and Ageing Resistance

Lap shear strength (MPa) with ISO 4587 after D3 cycle.  
D3 cycle NF EN ISO 9142 7 ageing cycles (7 days).

### Lap Shear Strength (Mpa)<sup>3</sup> thickness 250 µm

Substrates	Before ageing cycles	After ageing cycles D3
Aluminum	19.0CF <sup>5</sup>	16.0CF
Stainless Steel	18.0SCF <sup>8</sup>	18.0SCF
Steel	20.0CF	20.0 CF
GFRP <sup>7</sup>	9.0DF <sup>6</sup>	8.0 DF

### Notes

1. Brookfield viscosity (mPa.s) mobile T-F @ 10rpm
2. Brookfield viscosity (mPa.s) mobile RV7 @ 10rpm
3. ISO 4587
4. ISO 527-1A
5. CF: Cohesive Failure
6. DF : Delamination Failure
7. Glass Reinforced Fiber Polymer
8. SCF: Special Cohesive failure

Note: The physical and performance characteristics shown are averages obtained from tests performed according to ASTM test methods. Matco can make no warranty of any kind as to the results of the adhesive product use. The information published here is representative of laboratory research on these products and is believed to be reliable. Values should not be used for specification purposes. Each user should make their own test to determine the product suitability for their own intended use and shall assume all risks and liabilities in connection therewith. Materials should be stored at 70°F (21°C) with 50% relative humidity.



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### Surface Preparation

Use alcohol to remove grease, contamination or poorly adhering oxides from metal surfaces. Most plastics require a simple cleaning before bonding. Some may require sanding for better performances.

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### Precautions

Adhesive contains methacrylate monomers and is flammable. Materials must be stored in cool place away from sources of heat. During the polymerization, the chemical reaction causes a typical smell, please use the product in a well-ventilated area.

When the adhesive two components are mixed, an exothermic reaction can occur and generates heat. The amount of heat is dependent on the mass and thickness of the mixed product. Read material Safety Data Sheet before handling or using this product.

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### Application

Optimum qualities are obtained at room temperature, ideally between 18°C and 28°C without post-curing. Follow the instructions on the product operating guide or contact your MPI-Matco representative for any information concerning product use, dispensing equipment or substrates application.

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### Packaging

FIT30 15 adhesive is available in 50mL and 490mL side by side cartridges, 20L pails or 200L drums.

FIT30 15 50mL cartridges require the use of **ADH\_MH5416** mixers.

FIT30 15 490mL cartridges require the use of **ADH\_MFX1018** mixers.

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