

**BONDING +  
SEALING +  
ENCAPSULATION**

**Kisling**



# 1665

**Flexible, fast curing methacrylate adhesive (MMA) for various applications. Fast strength build-up after an open time of 3 - 6 minutes.**

1665 is a universal adhesive for industrial applications, preferably in the field of composites and lightweight materials. Thanks to its non-sagging property the methacrylate adhesive is especially suited for vertical or overhead applications and it bridges a gap up to 10 mm.

The two-component structural adhesive is suitable for thermoplastics, metals and composites bonding. After the open time the adhesive reaches very quickly handling strength and functional stability which results in short fixture and waiting times.

# 1665

- + Good adhesion to a wide range of materials
- + Bridges gap up to 10 mm
- + Excellent resistance against dynamic loads
- + Colour change during curing allows visual process control (light blue to green)
- + Good weather resistance

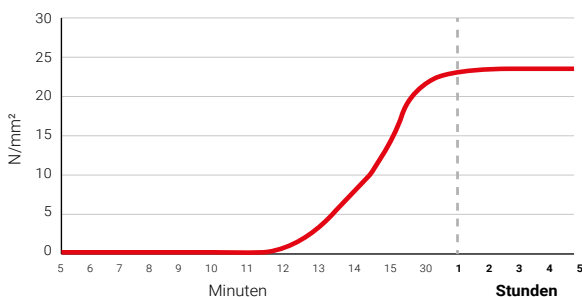


## Specifications

<b>Product category</b>	Methylmethacrylate structural adhesive
<b>Colour</b>	green (after cure)
<b>Mixing ratio</b>	10:1 (V:V)
<b>Viscosity [mPas]</b>	~100 000 thixotropic (Mix)
<b>Pot life [min]</b>	3 – 6
<b>Fixture time [min]</b>	8 – 13
<b>Final strength [h]</b>	~12
<b>Tensile strength [N/mm<sup>2</sup>]</b>	~15
<b>Tensile shear strength [N/mm<sup>2</sup>]</b> <b>Alu-Alu</b>	>19
<b>Tensile shear strength [N/mm<sup>2</sup>]</b> <b>Steel-Steel</b>	>20
<b>Elongation at break [%]</b>	~100
<b>Temperatureinsatzbereich [°C]</b>	+55 – +120
<b>Container size (Bulk containers on request)</b>	50 ml   490 ml

## Curing speed

Tensile shear strength on steel acc. to EN 1465, tested at 23°C



## Temperature range

Tensile shear strength on steel (sand-blasted) acc. to EN 1465

