

## SG230: Works the Way You Do

SG230's Flexible Working Times and Reduced Emissions Mean a Tough, Nearly Odorless Bond on **Your** Terms



**SCIGRIP® SG230 Adhesive** is the flexible solution that combines just one adhesive with a choice of 5 different activators to create custom working times that will match just about any marine bonding workflow. This innovative adhesive has low emissions and requires almost no surface preparation. Furthermore, its predictable cure dries tack-free with little or no residual odor. You get the tough, permanent bond you expect, a cleaner workplace, and a dependable adhesive that works the way you do.

### Performance Benefits

- Unique high viscosity formula “stays put” on vertical surfaces
- Reduced emissions, less offensive odor
- Minimal surface preparation
- Improved tack free cure with little to no residual odor
- Excellent environmental resistance
- Bonds to range of substrates: thermoplastics (Acrylic, PVC, ABS), thermoset composites (vinyl ester, polyester, gelcoats, and epoxy), primed metals, and coated metals.



Thanks to its application characteristics and excellent mechanical performance it was a perfect match for the hull manufacturing process used in the Ferretti assembly lines.

### Additional Resources

- Try SG100 for topside applications that require UV resistance

NOTES:  
1. Polyolefins, thermoplastic polyesters, fluorocarbon plastics and other low surface energy plastics are generally not bondable.  
2. Prepare metal for bonding by removing all dust, loose scale, rust, and other surface residue including oil and grease. Use of MP100 Metal Primer is a necessity and strongly recommended for stainless steel and aluminum bonding. Heavy grinding or sanding may interfere with the chemical action of MP100 and is not recommended, especially with aluminum and stainless steel. For maximum bond strength on steel, abrade the mating surfaces prior to bonding. See notes a, b and c on reverse side. Value will depend on strength and stiffness of substrate.  
3. Tensile modulus as measured in the linear portion of the stress strain curve.  
4. Lap shear strength of aluminum to aluminum bond pretreated with MP100 Metal Primer and based on ASTM D1002 method.

### TECHNICAL DATA SHEET

# SG230 HV

METHACRYLATE ADHESIVES

### RECOMMENDED FOR BONDING

Composites	Metals <sup>2</sup>	Thermoplastics <sup>1</sup>
Epoxy	Aluminum	ABS
Polyester/DCPD	Carbon Steel	Acrylics
Vinyl Ester	Stainless Steel	PVC/CPVC
Gelcoats	Coated Metals	Styrenics

### WORKING PROPERTIES

Cartridge	Adhesive	Activator	Working Time	Fixture Time
SG230-30	SG230 HV A	SG605 B	25-35 min	45-55 min
SG230-40	SG230 HV A	SG214 B	25-45 min	60-75 min
SG230-60	SG230 HV A	SG216 B	50-70 min	140-170 min
Bulk Only	SG230 HV A	SG218 B	70-90 min	180-210 min
Bulk Only	SG230 HV A	SG220 B	100-130 min	260-312 min

Time to reach 70% of ultimate strength in lap shear @75°F (24°C)<sup>4</sup>

### TYPICAL PHYSICAL PROPERTIES @75°F (24°C)

SG230 SERIES Uncured	Part A Adhesive	Part B Activator	A+B Mix
Color	Off White	Gray	Gray
Mix ratio/volume	10	1	-
Mix ratio/weight	8.4	1	-
Density, g/cc	0.97	1.15	0.99
Density, lb/gallon	8.09	9.60	8.25
Viscosity, cps	900,000-1,400,000	120,000-180,000	-

### TYPICAL CURED PROPERTIES @75°F (24°C)

Tensile Strength PSI (MPa)	3,000-3,500 (21-24)
Maximum Tensile Elongation	100-150%
Tensile Modulus <sup>3</sup> PSI (MPa)	80,000-103,000 (552-710)
Cohesive Shear Strength <sup>4</sup> PSI (MPa)	2,000-2,500 (15-17)
Service Temperatures °F (°C)	-40 to 180 (-40 to 82)

### PACKAGING & AVAILABILITY

Cartridges  
490 ML



Pails  
5 Gal./19 L



Drums  
55 Gal./ 189 L

