A-2020 is a two-part methacrylate, structural bonding adhesive designed for structural bonding of interior architectural finishes such as wall and ceiling panels, finishing trims, moldings, complex shapes and applications, eliminating the need for exposed fasteners. A-2020 has a working time of 30 to 50 minutes and achieves nearly 90 percent of its ultimate strength in 100 to 150 minutes at room temperature curing. A-2020 provides high strength bonds to engineered polymer finishes (acrylic and polyester), fiberglass, engineered stone, quartz surfaces and naturals stone to steel clips, rods, fiberglass and other materials. A-2020 bonds very strongly to steel, stainless steel, and aluminum framing and structural members.

**CHARACTERISTICS:**

**Room Temperature Cure**
- Working Time: 30 to 50 minutes (at 75°F/24°C)
- Fixture Time: 100 to 150 minutes (at 75°F/24°C)
- Can be Moved In: 180 to 240 minutes
- Operating Temp.: 65°F to 85°F (18°C to 30°C)
- Gap Filling: .250 inches
- Mixed Density: 8.1 lbs/gal (.96 g/cc)
- Flash Point: 51°F (11°C) – See SDS for more safety information

**CHEMICAL RESISTANCE:**

**Excellent Resistance to:**
- Hydrocarbons
- Acids and Bases

**Susceptible to:**
- Polar Solvents
- Super Strong Acids and Bases

**PHYSICAL PROPERTIES:**

**Uncured:**
- Viscosity (cps): 100,000 – 150,000
- Color: Translucent
- Density (lbs/gal): 8.2
- Mix Ratio (wt or vol): 1.0
- Mixer Recommendation: Cartridge (400 ml):

**Resin:**
- Activator: 100,000 – 150,000
- Amber

**MIXER RECOMMENDATION:**
- Cartridge (400 ml): MBQX 08-24T – Square 24 element White/Green Mix Tips (1.1)

**MECHANICAL PROPERTIES:**

**Tensile Strength (ASTM D638):**
- Strength, psi: Engineered Polymers, 2,000 - 3,000; Gel Coat Surface, 2,000 - 3,000; Steel/Stainless Steel, 1,800 - 2,500; Aluminum, 1,800 - 2,500
- Failure Type: Cohesive, Substrate, Cohesive, Cohesive

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