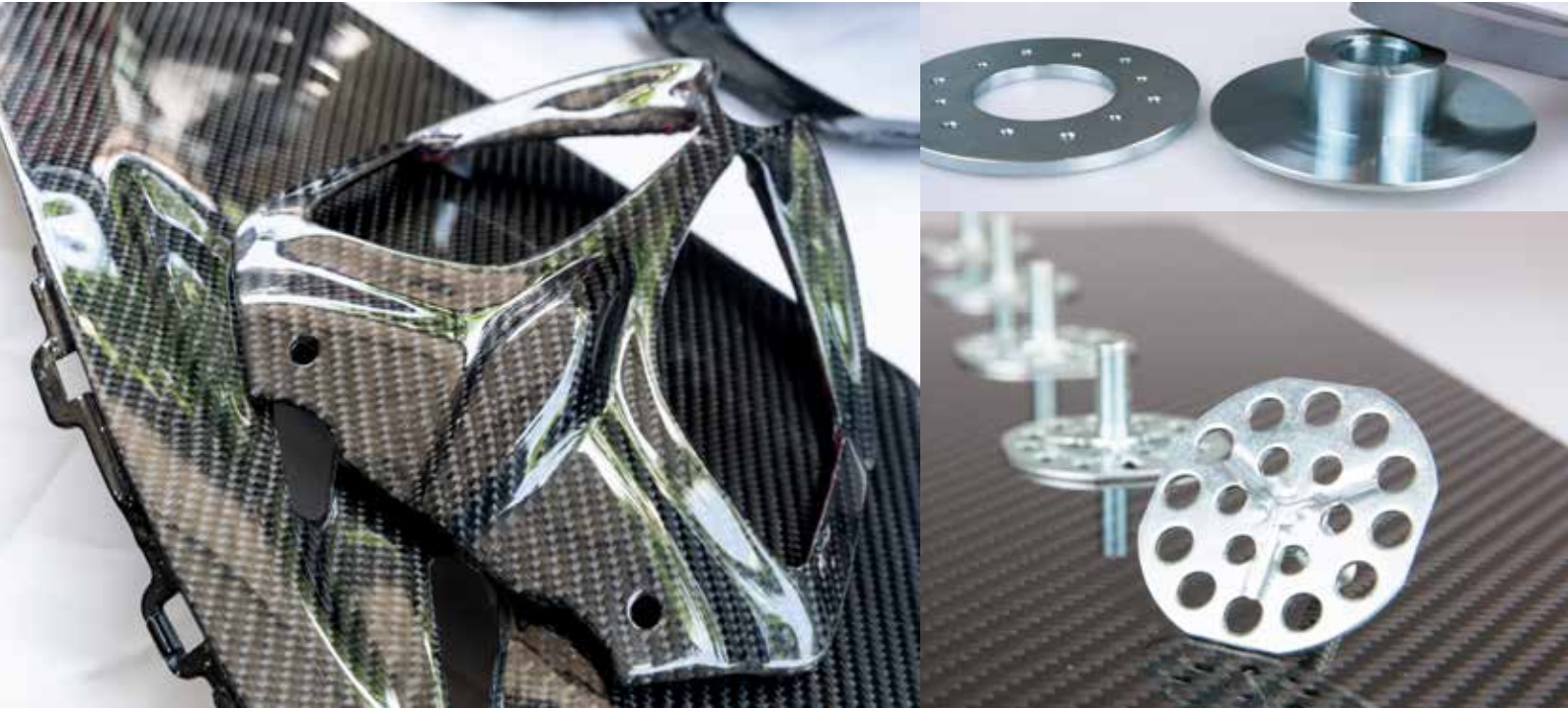


**BONDING +  
SEALING +  
ENCAPSULATION**

**Kisling**



# 1680

**1680 is the low odour all-rounder with extended pot life, rapid strength build-up and excellent adhesion on metals and most common plastics.**

1680 is a nearly odourless, non-sagging, two-part methacrylate adhesive designed for structural bonding. The cured adhesive offers a balanced profile of properties with high rigidity combined with excellent strength. 1680 is mainly designed as an universal grade for industrial applications where composites are involved. Its curing process is made optically visible by its colour changing from blue to green.

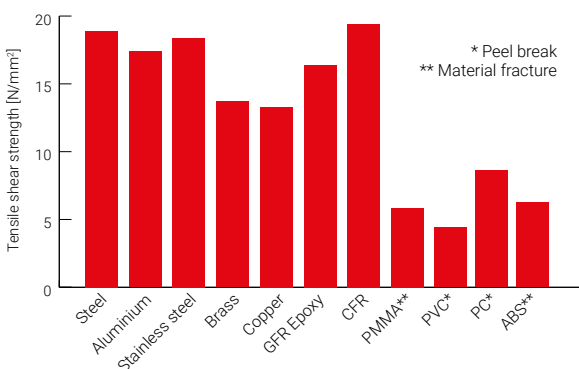
# 1680

- + Extended pot life for medium to large applications
- + Short fixing times due to rapid strength development
- + Excellent adhesion on a variety of materials
- + High elasticity and elongation at break
- + Good temperature resistance
- + Low odour and low flashpoint



Specifications	
<b>Product category</b>	Methacrylate structural adhesives
<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>	8 – 12
<b>Fixture time [min]</b>	~17
<b>Final strength [h]</b>	~24
<b>Tensile strength [N/mm<sup>2</sup>]</b>	~14
<b>Tensile shear strength [N/mm<sup>2</sup>]</b>	<b>Alu-Alu</b> ~17
<b>Tensile shear strength [N/mm<sup>2</sup>]</b>	<b>Steel-Steel</b> ~19
<b>Elongation at break [%]</b>	~65
<b>Temperature range [°C]</b>	-50 – +120
<b>Registrations &amp; Certificates</b>	DIN EN 45545-2 chart 5, R1, R7 and R17 with HL1-3
<b>Container size (Bulk containers on request)</b>	50 ml   250 ml   490 ml

## Tensile shear strength



## Strength build-up

