

MAKOBOND ADHESIVE PASTE 125

PRODUCT DESCRIPTION

Makobond AP 125 is a gray elastomeric adhesive designed for tough applications and environments. AP-125 demonstrates outstanding shear and peel strength while boasting impressive impact resistance. It adheres effectively to various surfaces including ceramics, metals, glass, wood, and many plastics while reaching handling strength in 2 hours. AP-125 boast a desirable 1:1 mix ratio and will stand up to both expansion and contraction. AP-125 applies easily and flows smoothly, minimizing dripping and migration.

PRODUCT HIGHLIGHTS

- High shear and peel strength • 1:1 Mix Ratio • High Performance • Elastomeric

PRODUCT CHARACTERISTICS

	AP 125A	AP 125B
Viscosity @ 25°C	35-75K cps.	45-65k cps.
Specific Gravity	1.08	1.01
Color	Gray	Amber

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	68-72D	D2240
*Lap Shear (psi) Aluminum to Aluminum	3,800	D1002

*Lap Shear Properties improve with thermal aging.

HANDLING PROPERTIES

Adhesive Paste 125	
Mix Ratio By Weight, Resin, Hardener	100:100
Mixed Viscosity @ 25°C	Paste
Pot Life @ 25°C	15-25 min

HANDLING AND CURING

Measure out proper weights of AP 125 and mix until uniform with no streaks are present throughout. Scape container for any unmixed material. Apply AP 125 to prepared surface and let set at 25°C (77°F) for at least 7 days for full cure properties. An accelerated cure can be achieved once AP-125 has set for 24 hours, a post cure of 8-12 hours at 65.6°C (150°F) will provide full properties.



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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
AP-125A	2 lbs	8 lbs	40 lbs	450 lbs
AP-125B	2 lbs	8 lbs	40 lbs	450 lbs
AP-125 Kit	4 lbs	16 lbs	80 lbs	900 lbs

*Cartridge Packaging is available upon request. Please contact Mako for details.

STORAGE AND SAFETY

Makobond AP 125 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.