

Series	Features, Benefits & Applications	Adhesive	Gap Fill inch (mm)	Working Time ¹ min.	Fixture Time ¹ min.	Ratio A:B Volume Weight	Mixed Density g/cc lb/gal	Viscosity (10 ³ cps) A Comp. B Comp.	Tensile Strength ² psi (MPa) % Elongation	Shear Strength psi (MPa)
SG100	Color Stabilized (White) UV Resistant Intermediate Shear Strength High Toughness • 490 ml Cartridge or Bulk Containers ⁶ • Composites, Plastics, Primed Metals	SG100-15 SG100-40	0.02 – 0.5 (0.50 – 12.7)	12 – 18 35 – 45	30 – 45 80 – 100	10:1 6.42:1	1.00 8.33	A: 150 – 220 B: 70 – 180	2,500 – 2,900 (17.2 – 20) 15 – 35	2,000 – 2,400 ³ (14 – 16)
SG200	General Purpose (Off White) ⁵ Maximum Toughness High Shear Strength • 490 ml Cartridge or Bulk Containers ⁶ • Composites, Plastics, Primed Metals	SG200-10 SG200-20 SG200-40	0.02 – 0.5 (0.50 – 12.7)	8 – 12 17 – 22 35 – 45	25 – 30 35 – 42 80 – 90	10:1 8.10:1	0.97 8.10	A: 170 – 220 B: 70 – 180	2,500 – 3,000 (17 – 21) 60 – 100	2,200 – 2,500 ³ (15 – 17)
SG230 HV	Large Structures (Gray) ⁵ Gap Fill up to 1.5" (39 mm), Non Sag Intermediate Shear Strength Maximum Toughness • 490 ml Cartridge or Bulk Containers ⁶ • Composites, Plastics, Primed Metals	SG230 HV SG214 B⁷ SG216 B SG218 B	0.02 – 1.55 (0.50 – 39.0)	25 – 130	45 – 312 ⁴	10:1 8.4:1	0.99 8.25	A: 900 – 1,400 B: 120 – 180	3,000 – 3,500 (21 – 24) 100 – 150	2,200 – 2,500 ³ (15 – 17)
SG300	Metal Bonder (Black or Off White) ⁵ Primerless Metal Bonding Low Read Through High Shear Strength High Toughness • 490 ml Cartridges or Bulk Containers ⁶ • Composites, Plastics, Metals	SG300-05 SG300-15 SG300-40	0.02 – 0.375 (0.50 – 9.5)	4 – 6 13 – 17 35 – 45	15 – 20 30 – 40 80 – 90	10:1 9.0:1	1.02 8.51	A: 175 – 275 B: 120 – 180	1,700 – 2,200 (12 – 15) 40 – 60	2,300 – 2,800 ³ (16 – 19)
SG600	General Purpose (Black or Off White) ⁵ Ease of Manual Dispensing High Shear Strength High Toughness • 490 ml Cartridges or Bulk Containers ⁶ • Composites, Plastics, Primed Metals	SG600-05 SG600-10 SG600-20	0.02 – 0.375 (0.50 – 9.5)	4 – 6 8 – 12 15 – 20	15 – 18 25 – 30 35 – 40	10:1 8.5:1	0.97 8.10	A: 150 – 250 B: 120 – 180	3,000 – 3,300 (21 – 23) 65 – 105	3,000 – 3,600 ³ (21 – 25)
SG5000	High Strength 1:1 Metal Bonder (Amber or Black) ⁵ Maximum Strength High Shear Strength • 50 & 400 ml Cartridges or Bulk Containers ⁶ • Composites, Plastics, Primerless Metals	SG5000-03 SG5000-06 SG5000-13	0.02 – 0.125 (0.50 – 3.2)	2 – 5 5 – 8 14 – 19	6 – 8 10 – 12 20 – 25	1:1 1:1	0.97 8.09	A: 90 – 150 B: 150 – 250	5,076 – 5,802 (35 – 40) 5 – 10	2,611 – 3,626 ³ (18 – 25)

Notes:

- Working / fixture times at 75°F (24°C) unless noted. Fixture time is minimum recommended time in fixture.
- All tensile properties are based on post cure cycle, 1 hour @ 180°F (82°C).
- ASTM D1002 - 6061T Aluminum treated with MP100 Metal Primer (no primer needed with SG300 series).
Bond strength attainable on other materials is limited and controlled by the strength and stiffness of the substrate.
- Single adhesive, selection of activators. Please refer to the product data sheet for more specific information.
- Cured adhesive colors are for products offered in cartridges. Several other colors are possible with products sold in bulk.
- Bulk containers - 5 and 50 gallons (19 and 189 liters).
- Please refer to the product data sheet for more specific information..