



Technical Specification: ATA-30 Tile Adhesive

ENGINE

SERVICE CHANNEL

ATA-30 is a two component, high tack strength, epoxy adhesive specifically developed for the installation of vibration damping materials such as Soundown DT Series Damping Tiles and TuffMass. Clamping or shoring is generally eliminated as ATA-30 adhesive will support in weight excess of 25kg/m² (5lbs/ft²) on overhead and vertical surfaces while curing takes place. ATA-30 is excellent for grouting between damping tile or sheet and for forming fillets at welds or seams. ATA-30 is nontoxic and contains no solvents. Fumes and odors of mixed ATA-30 are negligible, thus facilitating usage in confined areas. Resistance to freshwater, saltwater, crude and refined oils, gasoline, jet fuel, etc., is excellent.



Surface Preparation

Surfaces must be clean and sound, free of oil, dirt, old paint and other foreign matter. Blast, abrade or clean surface for best adhesion. Final rinse of surface with appropriate solvent such as Impax IXT 59 helps to ensure complete removal of grease and oils.

Mixing and Application Instruction

ATA-30 is mixed one part white resin to one part black hardener by volume. Equal sized quantities are best placed side by side on a wood or hardboard surface and thoroughly mixed until a uniform gray color is achieved. Mix quantities which can be used within approximately one hour. ATA-30 has an exceptionally soft creamy consistency providing ease of mixing.

Mixed adhesive may be applied to damping tile or sheet with either a smooth or notched trowel. With smooth edge trowel apply uniformly at approximately 0.8mm (1/32") or thicker. Notched trowels with serrated edges of 1.6mm (1/16") or larger may be utilized. Coat entire surface of tile evenly including edges, bend coated tile, and starting with edge, roll on to hull structure such that adhesive spreads under tile ensuring that air is not entrapped. Adhesive may be applied to either or both surfaces. Intimate contact maybe further insured through pounding with a rubber mallet. ATA-30 develops excellent bond between poorly fitted surfaces and is recommended for metals, rubber, wood, glass, masonry and many plastics. ATA-30 is easily cleaned off tools and hands prior to setting with any solvent typically used for clean up or thinning of epoxies.



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DUAL-LIFT (0,123m²)

8" ID (203,2mm) ENGINE EXHAUST PIPE

Property	Characterstic
Color	Resin - White
	Hardener - Black
	Mixed - Gray
Compressive Modulus of Elasticity	13,790 kg/m ² (197,00 psi)
Compressive Strength	770kg/m ² (11,00 psi)
Coverage	Up to 1.85m ² (75ft ²) When applied with notched trowel.
Cure Time	24hrs @ 22°C (72°F) 15 Days @ 1.7°C (35°F)
Hardness (Barcol)	20
Mixing Ratio	By volume 1:1 By weight: 100 parts resin to 88 parts Hardener
Packaging	6.35kg(14lbs) per unit 4.9 liters (1.3 gallons) per unit
Pot Life	1.5 Hours @ 22°C (72°C) 6 liters (1.6 gallon) batch
Resistance to High Impact	Pass MIL-S-901
Shear Strength	89.5kg/cm ² (1,274 psi)
Shelf Life	2 years
Temperature Resistance	65°C (15°F)
Tensile Adhseion Perpendicular to Bond	120kg/cm ² (1,700 psi)
Tensile Strength	224kg/m ² (3,200 psi)
Viscosity	Thixotropic past, trowelable

All statements herein are expression of opinion that we believe to be accurate and reliable, but are presented without guaranty or responsibility on our part.

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