



# INSTANT TOUGH MV

## ONE COMPONENT, MEDIUM VISCOSITY, TOUGHENED ADHESIVE

TECHNICAL SHEET - 22/12/2025



### SMART BENEFITS

- Instant Adhesion
- High Strength
- Multi-material adhesion
- Rubber and metal bonding
- Peel resistance

### DESCRIPTION

**Instant Tough MV** is a rubber-toughened instant adhesive designed for high-performance bonding applications across a wide range of materials, including metals and rubbers. The product is specially formulated to provide increased impact and peel resistance, along with improved flexibility.

### METHOD OF USE

- Before applying the adhesive, make sure the surface is clean, dry and free of grease.
- Apply adhesive to one of the surfaces. Do not use items like tissues or a brush to spread the adhesive.
- Assemble the parts with proper alignment as the short fixture time leaves little opportunity for adjustment.
- Bonds should be held fixed or clamped until adhesive has fixture.
- Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

### PROPERTIES

TECHNICAL DATA		
CHARACTERISTICS		VALUE
<b>Base</b>		Ethyl Cyanoacrylate
<b>Viscosity</b> Brookfield, 25 °C, Spindle 21, 100 rpm	[mPa·s]	240 - 400
<b>Color</b>		Transparent, colourless to straw colored liquid
<b>Specific Gravity</b> ASTM D1875 @ 23 °C	[g/ml]	1.10

FIXTURE TIME @ 23 °C		
Substrate		
<b>Beech Wood</b>	[s]	30 - 60
<b>ABS</b>	[s]	40 - 110
<b>Polycarbonate</b>	[s]	40 - 150
<b>Aluminium A5754</b>	[s]	10 - 120
<b>Mild steel</b>	[s]	20 - 90
<b>NBR*</b>	[s]	10 - 40
<b>EPDM*</b>	[s]	10 - 40
<b>Neoprene*</b>	[s]	15 - 40

\*1 Kg load for 10 s

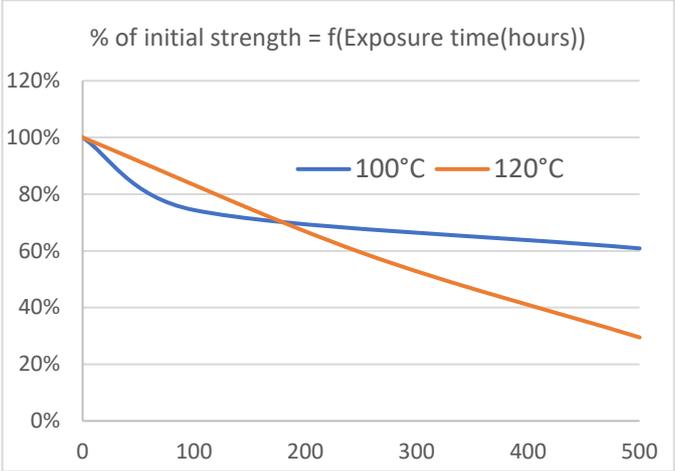
BONDING PERFORMANCE Tensile Shear strength (ISO 4587) - Cured 24 h @ 23°C		
Substrate		
<b>Beech Wood</b>	[N/mm <sup>2</sup> ]	13 - 16 *
<b>ABS</b>	[N/mm <sup>2</sup> ]	5 - 13 *
<b>Polycarbonate</b>	[N/mm <sup>2</sup> ]	5 - 12 *
<b>Aluminium A5754</b>	[N/mm <sup>2</sup> ]	14 - 18
<b>Grit Blasted Mild steel (GBMS)</b>	[N/mm <sup>2</sup> ]	18 - 24
<b>NBR</b>	[N/mm <sup>2</sup> ]	0.5 - 0.6 *

\*Substrate failure

BONDING PERFORMANCE		
Peel strength (ISO 11339) - Cured 24 h @ 23°C		
SUBSTRATE		@ 22 °C
Mild Steel	[N/mm <sup>2</sup> ]	2.0 - 3.5

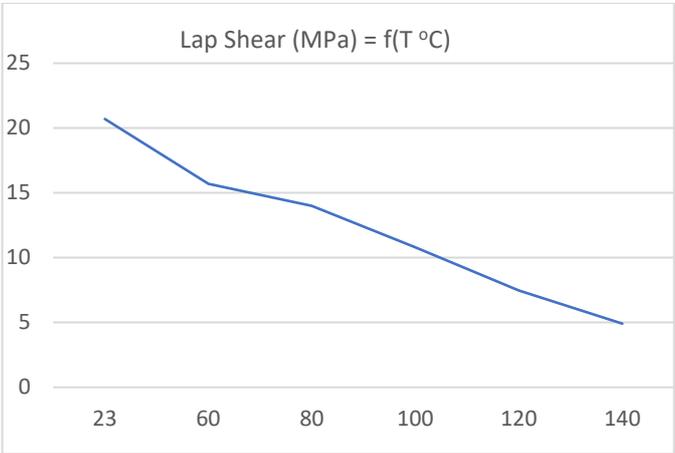
**HEAT AGEING**

The graph below shows the heat ageing results. The adhesive was aged at the temperature indicated, tested at 22 °C and cured for one week. The lap shear strength was tested according to ISO 4587 on grit-blasted, mild steel (GBMS).



**HOT STRENGTH**

The graph below shows the adhesive performance on grit-blasted mild steel (GBMS) at various temperatures. The adhesive was cured for one week at 22 °C. The lap shear strength was tested according to ISO 4587. The strength test was performed in a climatic chamber that was set up for 30 minutes before testing at the indicated temperatures.



**CHEMICAL/SOLVENT RESISTANCE**

Aged under conditions indicated and tested on GBMS.

% of Initial Strength vs. Exposure Time (hours) and vs. Type of Contaminant				
Testing on GBMS		% of Initial Strength		
ENVIRONMENT	TEMP	100 h	500 h	1000 h
Water	23 °C	67	51	51
Motor Oil	82 °C	62	56	43

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**HUMIDITY RESISTANCE**

Aged under conditions indicated and tested @ 23 °C after curing for 1 week @ 23 °C.

% of Initial Strength vs. Exposure Time (hours)				
95% HR, 40 °C		% of Initial Strength		
ENVIRONMENT	TEMP	100 h	500 h	1000 h
GBMS	40 °C	71	51	48

The information given and recommendations made here in are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent

**SMART HELP**

Please contact your local representative

