



Technical Data Sheet

Bondloc DTBKIT Difficult to Bond Kit

PRODUCT DESCRIPTION

Bondloc Difficult to Bond Kit has been developed for the bonding of "difficult to Bond" plastics and thermoplastic rubbers.. DTB is a low cost solutions that eliminates the need for expensive surface treatments such as plasma, corona, flame or chemical etching. DTB Adhesive is a low viscosity, high quality, triple distilled cyanoacrylate, this highly catalyzed adhesive works perfectly with DTB Primer to wet the surface of most low surface energy materials to ensure a high strength bond bond is achieved.

APPLICATIONS

DTB can be used on the following materials:

Polypropylene (PP) – Automotive body panels, bumpers, in-take manifolds, door cladding, containers/packaging, appliances and electrical/electronic applications.

Polyethylene (PE) – Automotive, packaging, housewares and wire and cable insulations, pipe and processing equipment.

Fluoroplastics (PTFE) (FEP) (PFA) – gaskets, seals, slides/guides, insulators, tubing.

Silicone rubber (TPE) – Automotive, O-rings, food industry, gaskets, anti-vibration, weather stripping

USEFUL NOTES

- Rapid bonding of plastics & elastomers
- High quality triple distilled adhesive
- Replaces expensive surface treatment
- Bonds dissimilar substrates

INSTRUCTIONS FOR USE

- Ensure surfaces are clean, dry and free from grease.
- Apply DTB Primer to the low energy Surface material by wiping (using a brush or clean cloth) or dipping. Allow to dry at an ambient temperature prior to bonding.
- Bonding polyolefins with DTB adhesive can be performed up to 2 hours after the primer has been applied (this may be less depending

on the particular blend of polyolefin)

Immediate bonding is recommended for PTFE

- Apply the DTB adhesive and press together. full cure will be achieved after 24 hours.

TECHNICAL FEATURES

DTB ADHESIVE

Base	Ethyl Cyanoacrylate
Appearance	Clear
Specific gravity	1.06 g/cm ³
Shelf life	12 months
Viscosity @ 25°C	25-35 cps

DTB PRIMER

Base	Heptane/acetone
Evaporation	30-60 seconds
Specific Gravity	0.68 g/cm ³
Shelf Life	12 months
Viscosity @ 20°C	1.25 mPas
Drying Time	<35 seconds

STORAGE

BCA HV should ideally be stored in original sealed containers until used. Containers should be stored between 2°C and 10°C with a maximum storage temperature of 25°C. Avoid exposure to strong light and heat sources. Refrigeration can prolong shelf life.

HEALTH & SAFETY

This technical information sheet does not constitute a Safety Data Sheet (SDS). Before using this product ensure you have read and fully understood this products SDS.

PACKAGING FORMAT

Kit.....20g/20ml, 50g/50ml, 500g/500ml

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