



# Technical Data Sheet

## Bondloc B2012 5 Minute Cure Epoxy

### PRODUCT DESCRIPTION

B2012 is a semi flexible easy-to-use solvent free epoxy adhesive. Can be used to bond or repair almost any material; such as wood, metal, glass, ceramic, plastic and rubber. B2012 is a fast setting resin which hardens in 5 minutes with high bond strength, chemical resistance and is clear in appearance.

### APPLICATIONS

B2012 is suitable for bonding a wide range of variety of surfaces including steel, aluminium, and galvanised iron. B2012 reacts within a few minutes to give a tough resilient bond on a wide variety of surfaces.

### USEFUL HINTS/NOTES

- Clean & easy to use.
- Viscous but not thixotropic.
- Rapid curing.

### INSTRUCTIONS FOR USE

- Ensure that surfaces to be bonded are clean and free from grease, dirt, dust and any other contamination.
- Mix equal quantities either by weight or volume of the two parts and stir thoroughly. Where a static mixing nozzle is supplied the 2 parts will be mixed correctly upon dispensing.
- Apply to one surface and offer up the second surface. Clamp or jig together under light pressure.

Leave to cure at room temperature.

### STORAGE

Stored under dry conditions in closed containers between 5 and 25°C B2012 will have a shelf life of 12 months.

### TECHNICAL FEATURES

	Part 1	Part 2
<b>Physical Form</b>	Viscous liquid	Viscous liquid
<b>Chemical Type</b>	Epoxy	Mercaptan and polyamide
<b>Appearance</b>	Clear	Clear
<b>Mixed Viscosity 25°C</b>	15,000 – 20,000 Pa.S	
<b>Specific Gravity</b>	1.1	
<b>Mix Ratio</b>	1:1 vol/vol or wt/wt	

### MECHANICAL PROPERTIES

Shore Hardness D	78-80 (ASTM D 2240)
Shear Strength (N/mm <sup>2</sup> )	14-18 (DIN 53283)
Peel Strength (N/mm <sup>2</sup> )	3-5 (ISO 4578)
Thermal Conductivity (W/mK)	0.1
Coefficient of thermal expansion (1/k)	60-120 x 10 E <sup>-6</sup>
Dielectric Strength (kv/mm)	50-90
Volume Resistivity (OHM/cm)	3-5 x 10 E <sup>12</sup>
Service Temperature	-40°C to +121°C (-40°F to 250°F)

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### CURED PERFORMANCE

Lap Shear Strength	
Substrate	Shear Strength/Failure Mode
CRS/CRS	2,350 psi – Cohesive Failure
Aluminium/Aluminium	1,950 psi – Cohesive Failure
Copper/Copper	1,850 psi – Cohesive Failure
FRP/FRP	900 psi – Cohesive Failure
ABS/ABS	850 psi – Cohesive Failure
<b>Chemical Resistance</b>	
Media	Lap Shear (ASTM D 1002) Strength in PSI
Gasoline	2550
Acetic acid (10%)	2180
Xylene	2165
Lubricating oil-HD30	2400
Paraffin	2275
Water @ 23°C	2355
Water @ 90°C	2325

Plastics	Shear strength psi
ABS	210
GRP	540
HIPS	210
Nylon	180
Perspex	330
uPVC	170
Polycarbonate	240
Metals	Shear strength psi
Steel	550
Steel, abraded	900
Stainless steel	1050
Aluminium	650
Aluminium, abraded	960
Galvanised iron	800
Others	
Plywood	680
Teak	820

### 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

Cartridge - 25ml, 50ml, 400ml

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