



Technical Data Sheet

Bondloc B3293 PU 1:1 Three Minute Bonder

PRODUCT DESCRIPTION

B3293 is a two-component fast setting, room temperature cure structural polyurethane adhesive system. This sand able adhesive system has an excellent adhesion to wide variety of surfaces.

APPLICATIONS

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength. Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. Attach cartridge to 50ml or 400ml manual or pneumatic dispensing systems. Open tip. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing). Attach mix nozzle to end of cartridge. Apply to surface and attach other substrate quickly, as you have 5 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.007".

USEFUL HINTS/NOTES

Benefits:

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as aluminum, stainless steel, ABS, PVC, polyurethane, composites, thermoplastics, thermosetting plastics, wood, glass, concrete without any use of primer.

STORAGE

Store in a cool dry place.

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.....50ml

TYPICAL PROPERTIES

	Part A	Part B
Colour	Beige	Black
Viscosity @25°C Brookfield, cps	30,000	30,000
Weight per Gallon	11	11
Mix Ratio	1:1	
Working Time	4 – 6 Minutes	
Fixture Time	12 – 15 Minutes	
Functional Cure	20 – 30 Minutes	
Full Cure	24 Hours	
Service Temperature	-40°C to +121.1°C	
Coverage Per lb.	94 sq. inch per lb @ 1/4"	

TYPICAL CURED PROPERTIES

T-Peel Strength	65 – 75 Pli	ASTM D1876
Tensile Elongation	200%	ASTM D638
Shore Hardness	65 – 70	ASTM D 2240
Dielectric Strength	350	volts/mil ASTM D 149
Cure Shrinkage	0.0014 in./in.	ASTM D 2566
Tear Resistance	400 Pli	ASTM D 624
Tensile Strength	2,200 psi	ASTM D 638

LAP SHEAR STRENGTH (after 7 days @ 25°C)

ABS to ABS	1250 psi
Steel to Steel	2050 psi
Glass to Glass	4100 psi
SMC to SMC	1200 psi
Aluminium to Aluminium	2225 psi
Concrete to Concrete	1940 psi
GBS to GBS	2750 psi
Galvanised Metal to Metal	2840 psi

Bondloc UK Ltd.
Units 1 & 2
Bewdley Business Park
Bewdley, Worcestershire
DY12 2TZ, UK

+44 (0) 1299 269 269
sales@bondloc.co.uk

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheets (SDS) for this and all other products being used are understood by all persons who will work with the product. Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is consider accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.

